



## Standard Steelwork Preparation Guide based on ISO 8501-1 Standards

*It is assumed that prior to treatment the steel surface has been cleaned of dirt and grease, and that the heavier layers of rust have been removed by chipping.*

### Hand Cleaning

#### **St2 Thorough Hand and Mechanical Tool Cleaning**

Removal of all rust, mill scale, loose rust and paint by wire brushing, hand sanding, scraping, chipping, mechanical abrading.  
The finished surface will be free from oil, grease and dirt and should have a feint metallic sheen.

#### **St3 Very Thorough Hand and Power tool Cleaning**

Removal of all rust, mill scale, loose rust and paint by power wire brushing, power grinding, mechanical sanding, needle gunning  
The finished surface will be free from oil, grease and dirt and should have a feint metallic sheen.

### Blast Cleaning

#### **Sa 1 Light Blast Cleaning**

Removal of all oil grease, dirt and loose mill and rust scale and flaking paint. It is not intended that then surface be free of all mill scale rust and paint.  
Any remaining scale rust and paint should be firmly adhered to the surface. Finally the surface should be abraded to provide a key.

#### **Sa2 Thorough Blast Cleaning**

Removal of mill scale rust paints dirt oil and grease by use of abrasive blasting leaving only the staining of discolouration from the rust, scale or paint.

#### **Sa2½ Very Thorough Blast Cleaning**

Removal of mill scale rust paints dirt oil and grease by use of abrasive blasting leaving only very light staining or discolouration from the rust, scale or paint.  
95% of each square inch should be free from all visible residues.

#### **Sa3 Blast Cleaning to Clean Uniform Steel**

Removal of all mill scale, rust paint or other matter to a finished surface that is uniform, grey white metallic in colour and slightly roughened.