Klargøring af ståloverflader forud for påføring af maling og lignende produkter – Metoder til forbehandling af overfladen – Del 5: Højtryksspuling

Preparation of steel substrates before application of paints and related products – Surface preparation methods – Part 5: Water jet cleaning

DANSK STANDARD
Danish Standards Association

Göteborg Plads 1
DK-2150 Nordhavn

Tel: +45 39 96 61 01
dansk.standard@ds.dk
www.ds.dk

DS projekt: M378168
ICS: 25.220.10

Første del af denne publikations betegnelse er:
DS/ISO, hvilket betyder, at det er en international standard, der har status som dansk standard.

Denne publikations overensstemmelse er:
IDT med: ISO 8504-5:2024

DS-publikationen er på engelsk.

INTERNATIONAL ISO

First edition
2024-09

Preparation of steel substrates before application of paints and related products — Surface preparation methods —

Part 5: Water jet cleaning

Préparation des subjectiles d'acier avant application de peintures et de produits assimilés — Méthodes de préparation des subjectiles —

Partie 5: Nettoyage au jet

Reference number
ISO 8504-5:2024(E)

ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

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Foreword

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This document was prepared by Technical Committee ISO/TC 35, *Paints and varnishes*, Subcommittee SC 12, *Preparation of steel substrates before application of paints and related products*.

A list of all parts in the ISO 8504 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user’s national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

The performance of protective coatings of paint and related products applied to steel is significantly affected by the state of the steel surface immediately prior to painting. The principal factors that are known to influence this performance are:

— the presence of rust and mill scale,

— the presence of surface contaminants, including salts, dust, oils and greases, and

— the surface profile.

The ISO 8501 series, the ISO 8502 series and the ISO 8503 series provide methods for assessing these factors, while the ISO 8504 series provides requirements and guidance on the preparation methods that are available for cleaning steel substrates, indicating the capabilities of each in attaining specified levels of cleanliness.

The ISO 8504 series is applicable to new and corroded steel surfaces and to steel surfaces that are uncoated or have been previously coated with paints and related products.

The ISO 8501, ISO 8502, ISO 8503 and ISO 8504 series do not contain provisions for the protective coating system to be applied to the steel surface. They do not contain provisions for the surface quality requirements for specific situations, even though surface quality can have a direct influence on the choice of protective coating to be applied and on its performance. Such provisions can be found in other documents such as national standards and codes of practice. Users of the ISO 8501, ISO 8502, ISO 8503 and ISO 8504 series should ensure the qualities specified are:

— compatible and appropriate both for the environmental conditions to which the steel will be exposed and for the protective coating system to be used, and

— within the capability of the cleaning procedure specified.

The primary objective of surface preparation is to ensure the removal of deleterious matter and to obtain a surface that permits satisfactory adhesion of the priming paint to steel. It is also intended to assist in reducing the amounts of contaminants that initiate corrosion.

Water jetting is an effective method for removing coatings from previously painted surfaces, removing water-soluble contaminants, and producing partially removed coatings. While water jetting by itself can produce a granular profile in metals under some conditions, water jetting is considered a secondary surface preparation method and is not used to provide the primary anchor pattern on the metallic substrate known as “surface profile.” Water jetting is primarily used for surfaces where there is an adequate pre-existing surface profile or for Grade C and Grade D substrates. Water jetting can remove oil, grease, and corrosion-stimulating substances such as chlorides and sulphates. Water jetting is widely applicable because this method of surface preparation has several features listed below.

— The method allows a high production rate.

— Coatings and salts can be removed in one pass.

— Production rates can be similar to conventional abrasive blast cleaning.

— A work atmosphere is present without particulate dust pollution.

— Other trades can work nearby during the surface preparation.

— Surface preparation can generally be performed in unsafe explosive or flammable areas without interruption with suitable control measures, for example, earthing of equipment to prevent static discharges from water jetting guns, pumps, and hoses.

— The equipment can be stationary or mobile and is adaptable to the objects to be cleaned.

— The equipment can be remotely or manually controlled.

— The method is applicable to most types and forms of metal surfaces.

— Different surface preparation grades can be produced.

— It is possible to remove selectively partial failed coatings to leave sound coatings intact.

Representative photographic examples in ISO 8501-4:2020, Clause 8 can be used for assessing some new and previously coated steel surfaces. Owing to the many different situations that arise in the preparation of surfaces, these photographs are not always sufficient to describe specific instances. It is therefore recommended to produce specific photographs of a treated reference area that are acceptable to the interested parties for use as a basis for further surface preparation procedures.

Preparation of steel substrates before application of paints and related products — Surface preparation methods —

Part 5: Water jet cleaning

1 Scope

This document specifies water jet cleaning methods for the removal of the existing coatings and rust during surface preparation of steel surfaces before application of paints and related products. It provides information on the effectiveness of the individual methods and their fields of application. It also describes the equipment and the procedures to follow.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 4628-3, *Paints and varnishes — Evaluation of degradation of coatings — Designation of quantity and size of defects, and of intensity of uniform changes in appearance — Part 3: Assessment of degree of rusting*

ISO 8501-4:2020, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 4: Initial surface conditions, preparation grades and flash rust grades in connection with water jetting*