

Application Report No. A 05-0e
Standards for Cleaning of Steel Surfaces

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At the present time, the standards of NACE 5 / SSPC – SP, 1995 are applicable and these standards have been underlined with the aid of photos by one of the leading suppliers of paint for the shipping industry, HEMPEL Marine Paints A/S in Denmark.

We list below the cleaning degrees as defined by NACE 5 / SSPC – SP 12 and which are illustrated in the handbook issued by Messrs. HEMPEL, "Photo Reference Water Jetting".

Four (4) standards are defined, as follows:

- WJ-4** "A WJ-4 surface must have all loose rust, loose mill scale and loose coatings uniformly removed".
- WJ-3** "A WJ-3 surface must be cleaned to a matt finish with at least two-thirds of the surface free of all visible residues (except mill scale), and the remaining one-third containing only randomly dispersed stains of previously existing rust, coatings and foreign matter".
- WJ-2** "A WJ-2 surface must be cleaned to a matt finish with at least 95% of the surface area free of all previously existing visible residues and the remaining 5% containing only randomly dispersed stains of rust, coatings and foreign matter".
- WJ-1** "A WJ-1 surface must be free of all previously existing visible rust, coatings, mill scale and foreign matter and have a matt metal finish".