

## STEEL ABRASIVE MEDIUM FOR SURFACE TREATMENT

**Steel abrasives** are produced with super eutectoid medium alloy steel. The percentage of sulphur, phosphorus and chromium content is low. Abrasives are heat treated, applying the most modern procedure. The micro structure of high-carbon steel heat treated abrasives is a fine homogeneous martensite.

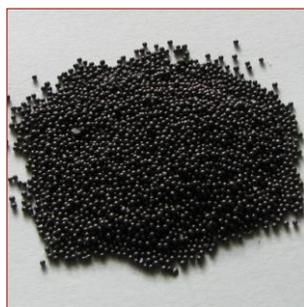
Abrasives are produced in round and angular form and we do not recommend the use of steel grit bigger than 400 µm (40 mesh) and steel shot bigger than S-170 (> 600 µm).

♦ **STEEL SHOT (S)** is used mainly for sandblasting/cleaning of casting sand, rust, scale, paint, for surface preparation prior to coating and for surface strengthening -shot peening (in aircraft industry, peen forming, welding, gears, springs,...). The component surface after sandblasting with steel shot is full of round dimples. Sandblasting with steel shot is mainly used in blast rooms and wheel blasting machines.

The characteristics of round high-carbon heat treated steel abrasives are:

- low depreciation
- long life time
- resistance to wear
- toughness

Steel shot is supplied in different sizes:



	Shot size in mm:
Steel shot S 70	0,2
Steel shot S 110	0,3
Steel shot S 170	0,4
Steel shot S 230	0,6
Steel shot S 280	0,7
Steel shot S 330	0,8
Steel shot S 390	1
Steel shot S 460	1,2
Steel shot S 550	1,4
Steel shot S 660	1,7
Steel shot S 780	2
Steel shot S 930	2,4



♦ **STEEL GRIT (G)** – it can be supplied in three different hardness grades: **GH**, **GM** and **GN**. The angular nature of steel grit produces an etched surface on metal.

**G** abrasives, marked **GH** possess a minimum hardness of 60 HRc. We recommend them exclusively for blasting with compressed air. Due to their exceptional abrasive characteristics optimal surface profiles can be achieved and this is a basic requirement for high quality surface protection.

Exceptionally **GH** abrasives can be used in wheel blasting machines for the blasting of cylinders.

Characteristics: In the process of blasting **GH** abrasives keep their original sharp-edged form. **G** abrasives marked **GM** possess a hardness from 52 to 56 HRc. They are recommended for the preparation of surfaces with high requirements concerning the purification and roughness profile (enamelling, metal coating...).

Characteristics: In the process of blasting **GM** abrasives lose their original sharp-edged form. **G** abrasives marked **GN** possess a hardness from 48 to 52 HRc. They are recommended for the applications in the surface preparation (cleaning) prior to painting, for the removal of sand.

Characteristics: In the process of blasting **GN** abrasives become round.

Steel grit is supplied in different sizes:



	Size in mm:
Steel grit G 120	0,1
Steel grit G 80	0,2
Steel grit G 50	0,3
Steel grit G 40	0,4
Steel grit G 25	0,7
Steel grit G 18	1
Steel grit G 16	1,2
Steel grit G 14	1,4
Steel grit G 12	1,7



Because of its high mass, steel shot and grit are less suitable for sandblasting with injector type blasting machines.

When using steel abrasive media, we recommend the use of high quality suction hoses, resistant to wear, and the hose diameter must be one size smaller in comparison to standard size.



Example of welded sheet metal before and after sand blasting with steel grit.

Steel abrasives are supplied in 25-kilogram PE bags, 1 ton on pallet, protected with foil.