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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 18838.2-2017

**Preparation of steel substrates before application of paints and
related products -- Specifications for metallic blast-cleaning
abrasives -- Part 2: Chilled-iron grit**

涂覆涂料前钢材表面处理 喷射清理用金属磨料的技术要求 第2部分：冷硬铸铁砂

(English Translation)

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Foreword

GB/T 18838 "coating of steel surface treatment before blasting metal abrasive technical requirements" is divided into the following sections.

- Part 1. Guidelines and classification;
- Part 2. Chilled cast iron sand;
- Part 3. High carbon cast steel balls and sand;
- Part 4. Low carbon cast steel balls;
- Part 5. Steel wire cut pill.

This section GB/T 18838 Part 2.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This section uses the translation method identical with ISO 11124-2:1993 "before coating the surface of steel spray cleaning metal abrasive Technical requirements Part 2. Chilled cast iron sand. " this part is proposed by China State Shipbuilding Corporation.

This part of the National Coatings and Pigments Standardization Technical Committee paint before the metal surface treatment and painting technology sub-Technical Committee (SAC/TC5/SC6) centralized.

This section drafted by. China Shipbuilding Industry Corporation XI Institute, Shanghai Long Cang New Materials Technology Co., Ltd., Shanghai Xuan Yang Chemical Materials Technology Co., Ltd., China Shipbuilding Industry and Technology Institute of integrated economy.

1 Scope

GB/T 18838 provisions of this part of the jet cleaning 12 grades of chilled cast iron sand abrasive technical requirements, including hardness, Density, defects, microstructure and chemical composition.

The requirements specified in this section applies only to unused abrasive, does not apply

to used abrasive.

Jet cleaning metal abrasive test methods see GB/T 19816 of the various parts.

Chilled cast iron sanding abrasives are recyclable and reusable abrasives that can be used both on fixed and on-site injection equipment.

Note 1: The commonly referenced standards for metal abrasives worldwide and their relationship with this part are given in Appendix A and Appendix B.

Note 2: Although this part of GB/T 18838 is formulated to meet the requirements of steel surface treatment, but also applies to the use of jet cleaning technology to deal with other the surface or part of the material. These rules are given in ISO 8504-2:2000(1) "Coating of steel surface treatment before the second part of the surface treatment methods Minutes. Abrasive jet cleaning "is given.

1) This standard is ISO 8504-2:1992 in ISO 11124-2:1993. GB/T 18839.2-2002 modified to use ISO 8504-2:2000.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

Preparation of steel substrates before application of paints and related products - Test methods for metallic abrasives for jet cleaning GB/T 19816.1-2005.

Sampling (ISO 11125-1:1993, IDT) Preparation of steel substrates before application of paints and related products - Test methods for metallic abrasives for jet cleaning - Part 2. Methods of test GB/T 19816.2-2005.

Determination of particle size distribution (ISO 11125-2:1993, IDT) Preparation of steel substrates before application of paints and related products - Test methods for metallic abrasives for blast cleaning - Part 3. Methods of test GB/T 19816.3-2005.

Determination of hardness (ISO 11125-3:1993, IDT) Preparation of steel substrates before application of coatings - Test methods for metallic abrasives for blast cleaning - Part 4. Methods of test GB/T 19816.4-2005.

Determination of apparent density (ISO 11125-4:1993, IDT) Preparation of steel substrates before application of paints and related products - Test methods for metallic abrasives for blast cleaning - Part 5. Methods of test GB/T 19816.5-2005.

Defective particle percentage and microstructure determination (ISO 11125-5:1993, IDT) Preparation of steel substrates before application of paints and related products - Test methods for metallic abrasives for jet cleaning - Part 6. Methods of test GB/T 19816.6-2005.

Determination of foreign impurities (ISO 11125-6:1993, IDT) Preparation of steel substrates

before application of paints and related products - Test methods for metallic abrasives for jet cleaning - Part 7.

Water content determination (ISO 11125-7:1993, IDT) ISO 9556:1989 steel and iron - Determination of the total carbon content Induction furnace oxidation after the infrared absorption method (Steelandiron-