

ICS 25.220.10
CCS A 29



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

GB/T 8923.4-2013

**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 high-pressure water jetting**

(English Translation)

Issued on: January 1, 1970

Implemented on: January 1, 1970

Issued by: Standardization Administration of China

Table of Contents

Foreword

1 Scope

2 Normative references

Foreword

GB/T 8923 "steel substrates before application of paints Visual assessment of surface cleanliness" is divided into the following sections.

--- Part 1. uncoated steel surfaces and fully remove the original steel surface coating after Rust grades and preparation grades;

--- Part 2. coated steel surface has a partial removal of previous coatings after processing level;

--- Part 3. surface defects of welds, edges and other areas of the processing level;

--- Part 4. with high-pressure water jetting treatment-related initial surface state, the process level and flash rust grades.

This section GB/T 48923 Part of.

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

This section uses the translation method identical with ISO 8501-4:2006 "before application of paints and surface treatment of steel surface cleanliness Visual assessment Part 4. with high-pressure water jetting treatment-related initial surface state, the process level and flash rust grades. " Consistency correspondence between this part of international documents and normative references of our files are as follows.

--- GB/T 8923.1-2011 steel substrates before application of paints and visual assessment of surface cleanliness - Part 1. uncoated Cover over the steel surfaces and steel surfaces after overall removal of previous coatings Rust grades and grade (ISO 8501-1.

2007, IDT)

--- GB/T 13288 (all parts) steel surface steel substrates before application of paints and the roughness characteristics of blast - cleaned [ISO 8503 (all parts)] Qualification Test --- GB/T 18570 (all parts) steel substrates before application of paints and surface cleanliness [ISO 8502 (the Part)] this part is proposed by the China State Shipbuilding Corporation.

This part of the National Standardization Technical Committee before painting and metal

surface treatment and painting processes Technical Committee paint pigment (SAC/TC5/SC6) centralized.

This section drafted by. China Shipbuilding Technology and Economy Research Institute, China Shipbuilding Industry Corporation 11th Institute, Jiangsu Province Fairmont 513 Limited, Zhangjiagang Shunchang Chemical Co., Ltd.

1 Scope

This section GB/T 8923 specifies the high-pressure water jet to clear or partially remove water-soluble contaminants, rust, coatings and coated outer to a series of steel surface treatment after the impurity level. By common definition of various grades and typical narrative model photos. In addition, the Department Points also provides an initial surface condition and clean up after flash rust grades, also defined by a common narrative and typical model photos.

Note 1: The foreign substances including salt, dirt, dust, scale, oil, grease, and marine organisms (such as algae).

This section describes the state of the surface clean visual appearance, in most cases, be sufficient to meet the requirements, however, it is likely to storm Coating exposed to harsh environmental conditions such as water immersion and continuous condensation, etc., should consider the use of physical and chemical specified in various parts of ISO 8502 Methods already evaluated visually clean surface of soluble salts and other invisible contaminants tested detection.

Although by high-pressure water jetting treatment will not produce a rough surface roughness or caused significant changes in existing, but the surface roughness Characteristics can still reference the provisions of ISO 8503.

Note 2: The water pressure, water volume, nozzle design, and the distance from the moving speed of the impact is clear as water-soluble contaminants, rust and other contaminants and coating clear in addition to the factors of efficiency, the removal efficiency also depends on whether the cleaning process cleaning agents. If used, followed by the need for clean water with clean Wash.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

Evaluation of the number and size of the ISO 4628-3 Paints and varnishes - Evaluation of degradation of coatings as well as the appearance of defects balanced degree of change Part 3. Evaluation of corrosion level
(Paintsandvarnishes-Evaluationofdegradationofcoatings-Designation

of quantity and size of defects, and of intensity of uniform changes in appearance-Part 3.
Assessment of degree of rusting) ISO 8501-1 steel before application of paints and surface
cleanliness - Visual assessment - Part 1. uncoated steel sheet Rust grades and preparation
grades of steel surfaces and the surface of the full removal of previous coatings after
(Preparation of steel substrates before
application of paints and related products-Visual assessment of surface cleanliness-Part 1. Rust
grades and preparation grades of uncoated steel substrates and of steel substrates after overall rem
oval of previous coatings) ISO 8502 steel substrates before application of paints and
assessment of surface cleanliness test (Preparation of steel substrates
before application of paints and related products-Tests for the assessment of surface cleanliness)
ISO 8503 steel substrates before application of paints and steel surface roughness
characteristics (Preparation of steel after the blast - cleaning
substrates before application of paints and related products-Surface roughness characteristics of
blast-cleaned steel substrates)