

**Removal
characteristics**

**Dry
Blasting**

**Coating material surface
is hammered piece by
piece and abraded away**

**High pressure water
Blasting**

**Water forces its' way
through and under the
coating breaking the bond
and shearing it off the
substrate**

	Dry blasting	High pressure water blasting
Surface condition after blasting	Scale free matt metal finish with uniformly surface roughness	Unevenly rough metallic, porous surface
	Rust deposits further embedded and partially hidden	All rust blasted out. Foreign matter and rust stimulators totally removed
	Blasting particles containing chlorides embedded in the surface	Mill scale (if any) remains
	Dust and dirt everywhere	Flash rusting forms (If no direct vacuuming employed)

→ NACE / SSPC

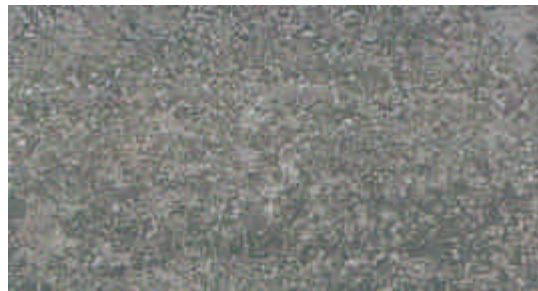
Old coating

Initial
condition

HAMMELMANN performance

Manual tools

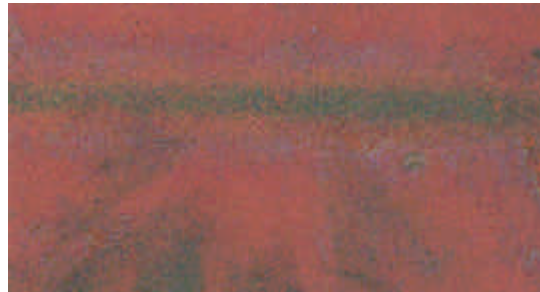
Dockmaster

Old coating
WJ-3850 bar
35 l/min
70 kw12-20 m²/h850 bar
190 l/min
350 kw300 m²/hOld coating
WJ-21400 bar
25 l/min
80 kw8-12 m²/h1400 bar
196 l/min
550 kw300 m²/hOld coating
WJ-12500 bar
20 l/min
90 kw6-10 m²/h2500 bar
85 l/min
400 kw150 m²/h

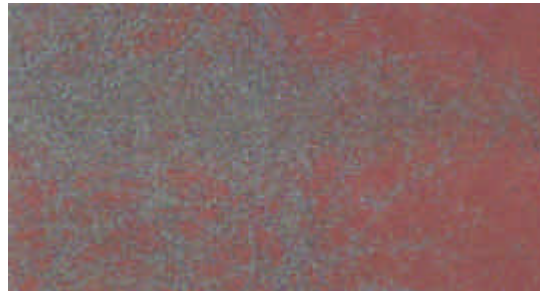
→ NACE / SSPC

Red epoxy
shop primer

Initial
condition

**HAMMELMANN performance****Manual tools****Dockmaster**

Red epoxy
WJ-3



850 bar
35 l/min
70 kw

12-20 m²/h

850 bar
190 l/min
350 kw

300 m²/h

Red epoxy
WJ-2



1400 bar
25 l/min
80 kw

8-12 m²/h

1400 bar
196 l/min
550 kw

300 m²/h

Red epoxy
WJ-1



2500 bar
20 l/min
90 kw

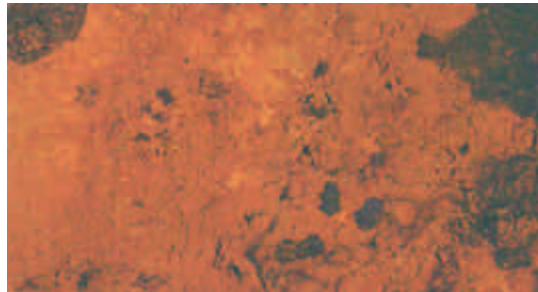
6-10 m²/h

2500 bar
85 l/min
400 kw

150 m²/h

→ NACE / SSPC

Rust grade D
Initial
condition

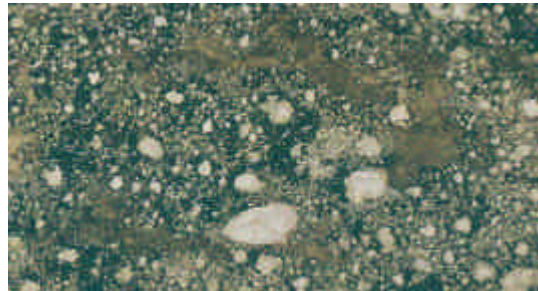


HAMMELMANN performance

Manual tools

Dockmaster

Rust grade D
WJ-3



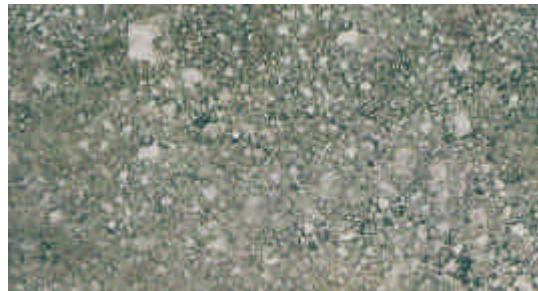
850 bar
35 l/min
70 kw

12-20 m²/h

850 bar
190 l/min
350 kw

300 m²/h

Rust grade D
WJ-2



1400 bar
25 l/min
80 kw

8-12 m²/h

1400 bar
196 l/min
550 kw

300 m²/h

Rust grade D
WJ-1



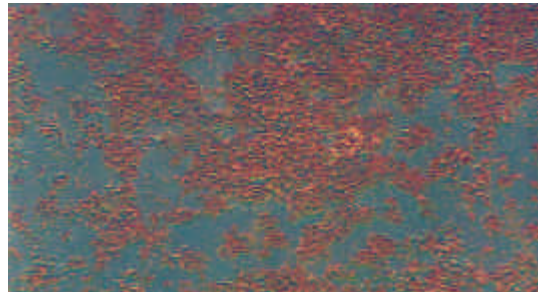
2500 bar
20 l/min
90 kw

6-10 m²/h

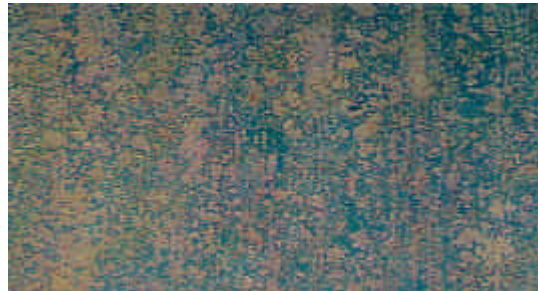
2500 bar
85 l/min
400 kw

150 m²/h

Rust grade B
Initial
condition



Rust grade B
B Sa 1



Rust grade B
B Sa 2



Rust grade B
B Sa 2 1/2



→ ISO 8501-1
(Swedish standard)

This standard applies to the treatment of steel surfaces by abrasive blasting methods.

The definitions cannot be used in conjunction with water jetting.

Water jetting cannot produce a profile on a steel surface.

High pressure systems can return the surface to its original conditions.