

## SURFACE PREPARATION GUIDE

### Abrasive Blast Cleaning

NACE 1 / SSPC-SP 5	White Metal Blast Cleaning
NACE 2 / SSPC-SP 10	Near-White Metal Blast Cleaning
NACE 3 / SSPC-SP 6	Commercial Blast Cleaning
NACE 4 / SSPC-SP 13	Brush-Off Blast Cleaning
NACE 8 / SSPC-SP 14	Industrial Blast Cleaning

### Non-Abrasive Blast Cleaning

SSPC-SP 1	Solvent Cleaning
SSPC-SP 2	Hand Tool Cleaning
SSPC-SP 3	Power Tool Cleaning
SSPC-SP 11	Power Tool Cleaning to Bare Metal

### Waterjet Cleaning Standards

NACE WJ-1 / SSPC-SP WJ 1	Clean to Bare Substrate
NACE WJ-2 / SSPC-SP WJ 2	Very Thorough Cleaning
NACE WJ-3 / SSPC-SP WJ 3	Thorough Cleaning
NACE WJ-4 / SSPC-SP WJ 4	Light Cleaning



### Waterjet Cleaning Methods

#### Water Cleaning (WC):

- Low-pressure water cleaning (LP WC): Pressures less than 5,000psi (34 MPa) (“power washing” or “pressure washing”)
- High-pressure water cleaning (HP WC): Pressures from 5,000psi to 10,000psi (34 MPa to 70 MPa)

#### Water Jetting (WJ):

- High-pressure water jetting (HP WJ): Pressures from 10,000psi to 30,000psi (70 MPa to 210 MPa)
- Ultra-high pressure water jetting (UHP WJ): Pressures greater than 30,000psi (210MPa)

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