
**Preparation of steel substrates before
application of paints and related
products — Specifications for metallic
blast-cleaning abrasives —**

**Part 5:
Cut steel wire**

*Préparation des subjectiles d'acier avant application de peintures
et de produits assimilés — Spécifications pour préparation par
projection d'abrasifs métalliques —*

Partie 5: Fils d'acier coupés

ISO 11124-5:2019

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 35, *Paints and varnishes*, Subcommittee SC 12, *Preparation of steel substrates before application of paints and related products*.

A list of all parts in the ISO 11124 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives —

Part 5: Cut steel wire

1 Scope

This document specifies requirements for 13 grades of cut steel wire abrasives, as supplied for blast-cleaning processes. It specifies ranges of particle sizes, together with corresponding grade designations. Values are specified for hardness, density, defect/structural requirements, metallographic structure and chemical composition.

This document is suitable for cut steel wire supplied for blast-cleaning processes which is made by cutting new cold drawn wire.

The requirements specified in this document apply to abrasives manufactured from virgin wire supplied in the new and unconditioned state only. They do not apply to abrasives either during or after use.

NOTE 1 Information on commonly referenced national standards for cut steel wire abrasives and their approximate relationship with ISO 11124 is given in [Annex A](#).

NOTE 2 Although this document has been developed specifically to meet requirements for preparation of steelwork, the properties specified will generally be appropriate for use when preparing other material surfaces, or components, using blast-cleaning techniques.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 439, *Steel and iron — Determination of total silicon content — Gravimetric method*

ISO 629, *Steel and cast iron — Determination of manganese content — Spectrophotometric method*

ISO 4935, *Steel and iron — Determination of sulfur content — Infrared absorption method after combustion in an induction furnace*

ISO 9556, *Steel and iron — Determination of total carbon content — Infrared absorption method after combustion in an induction furnace*

ISO 10714, *Steel and iron — Determination of phosphorus content — Phosphovanadomolybdate spectrophotometric method*

ISO 11125-1, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 1: Sampling*

ISO 11125-3, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 3: Determination of hardness*

ISO 11125-4, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 4: Determination of apparent density*

ISO 11125-5, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 5: Determination of percentage defective particles and of microstructure*

ISO 11125-6, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 6: Determination of foreign matter*

ISO 11125-7, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 7: Determination of moisture*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1

cut steel wire

metallic blast-cleaning abrasive made by cutting cold drawn steel wire

3.2

virgin wire

wire which is unaltered from its original manufactured state, and which has not previously been used as a component in any other manufactured product or composite material

Note 1 to entry: Wire which has been previously used poses a potential risk of imparting invisible contaminants onto a prepared surface, which could have an adverse effect on the performance of subsequently applied coatings.

3.3

cylindrical

sharp-edged particles, having a diameter to length ratio of 1:1, cut so that their faces are approximately at right angles to their centreline

3.4

defect

fault or weakness in an abrasive which, if present at or above a given level, can be detrimental to the performance characteristics of the abrasive

Note 1 to entry: See [Table 2](#).

3.5

over-length particles

particles of which the axial length to diameter ratio is equal to or greater than 2

3.6

crack

linear discontinuity that has a length-to-width ratio of 3:1 or greater, that extends over more than 20 % of the diameter or shortest dimension of a particle

3.7

foreign matter

material or particles mixed with the abrasive which are not attached to the abrasive particles and which are nonmagnetic