

# Airblast Tech Tips

## Abrasive/Profile Comparative Chart



The following chart should be used only for approximating the abrasive size required to obtain a specified anchor pattern. The standard metal used to obtain these results was hot rolled steel with tightly adhering mill scale. The resulting depth of anchor pattern will vary with the method used for measuring depths as well as any one of numerous other variables (type and hardness of steel, thickness of mil scale, degree of cleaning specified, etc.). This information can be used for centrifugal wheel blasting as well as pressure blasting. Pressure blasting should be done using approx. 7 bar nozzle pressure. The depth of anchor pattern used in this chart is an average and not a minimum or maximum depth obtainable. Contact Airblast for specific technical data.

	1 mil profile	1,5 mil profile	2 mil profile	2,5 mil profile	3-4 mil profile
Steel grit	G-80	G-50	G-40/50	G-40	G-25
Steel shot*	S-110	S-170	S-230/280	S-330/390	S-390/460
Garnet	80	30-60	20-40	12-24	-
Aluminium oxide	60-100	36-46	36-40	20-30	12-16

\* Steel shot alone will not give a good angular anchor pattern and should be used in combination with soft steel grit for best results.