

NACE CIP Level 1 Standards

ASTM D3276 - Standard Guide for Painting Inspectors. States that the minimum surface temperature for coating is usually 40F, max is 125F.

ISO 8501 St3 - Very Thorough Hand and Power Tool Cleaning. Same as for St2, but the surface shall be treated much more thoroughly to give a metallic sheen arising from the metallic substrate.

NACE 4 (SSPC-SP7) - Brush off Cleaning. Same cleanliness as NACE 1 (SSPC-SP5) and tightly adherent mill scale, rust, and coating may remain on the surface.

SSPC-SP3 - Power Tool Cleaning

ISO 8501 Sa 2.5 - Very Thorough Blast Cleaning

NACE 8 (SSPC-SP 14) - Industrial Blast Cleaning. Lightly adherent mill scale, rust, and coating residue are permitted to remain on 10% of each unit area of the surface.

NACE 8 (SSPC-SP 14) Lightly adherent mill scale, rust, and coating residue are permitted to remain on ____ of each unit area of the surface. - 10

SSPC-VIS 3 - Visual Guide for Rust Grades. Rust Grades A-D (A is the worse)

SSPC SP-1 - Solvent Pre Cleaning

ISO 8501 Sa3 - Blast Cleaning to Visually Clean Steel.

Surfaced shall be free from oil, grease, dust, dirt, free from the mill scale, rust, paint coatings, and other foreign matter. - ISO 8501 Sa3

ISO 8501 Sa1 - Light Blast Cleaning

NACE 2 (SSPC-SP10) - Near-White Metal Blast Cleaning

When viewed the surface shall be free from oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products, and other foreign matter. Random staining shall be limited to no more than 5% of each unit area of surface. - NACE 2 (SSPC-SP 10)

SSPC-SP2 - Hand Tool Cleaning

_____ removes all loose mill scale, loose rust, loose paint, and other loose detrimental foreign matter. It is not intended that adherent mill scale, rust, and paint be removed by this process. Mill scale, rust and paint considered adherent if they cannot be removed by lifting a dull putty knife. - SSPC-SP2

Nace Cip 1 Guide

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