



P e, Pe a ed

There's more than one way to surface prep a member.



What is "surface profile" in reference to prepared steel?

Surface pro le refers to the depth and shape of the microscopic pits and peaks that make up the steel surface. The depth and shape can be varied to some degree by the surface preparation chosen and the abrasive media used. Some high-performance coatings adhere better to a deeper or more angular pro le. The pro le depth can be measured and is quanti ed in mils. Surface pro le is also commonly referred to as "anchor pro le" or "anchor pattern." The abrasive media must be clean so as not to redeposit oil on the steel. Blasting with abrasives can either be done with commercial rotary blasting machines or with nozzles.

What are the different categories of surface preparation?

A basic description of the different standards is as follows:

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incur more costs. Costs vary across the country and even from fabricator to fabricator, depending on the equipment available and the level of experience of shop employees. Many shops don't have commercial blasting equipment available and send out pieces that must be blasted. The cost matrix included in RMSCA's model speci cation indicates that commercial blast cleaning (SSPC-SP6) will typically incur a 10% to 20% cost increase on the fabrication of those members. Preparing and painting a typical shop prime coat will incur a cost increase of 5% to 10%. Blasting to Category SSPC-SP5 (White Metal) is 4-5 times more expensive than preparing to Brush-Off Blasting (SSPC-SP7) or Power Tool (SSPC-SP3). (JCPL Applicator Training Bulletin, Jan. 2005.)

And finally, a word about unspecified standard shop paint...

A "shop coat" is a lower-end primer intended to provide temporary protection to the steel. A good rule of thumb is that if you aren't specifying a nal paint coat, you don't need a shop primer coat. Steel that will remain enclosed for its service life does not need to be shop coated. In the Commentary of Chapter M of the Speci cation for Structural Steel Buildings, it is noted that upon studying long-standing steel frames, the presence of a shop coat is irrelevant. Specifying a shop primer for aesthetic reasons is unnecessary and will add to the schedule and cost of your project. If the steel is unprotected in the eld during erection, there is the chance that it will develop a thin Im of " ash" rusting (iron oxide). This is not harmful to the strength or serviceability of the steel. MSC

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