

Size grading for high carbon cast steel abrasive

Airblast Eurospray steel shot is manufactured to SAE J444, Cast Steel and Grit Size Specification for Peening and Cleaning.

The size specification for SAE J444 is the same as for the International Standard ISO 11124-3, preparation of steel substrates before application of paints and related products; specification for cast-steel shot and grit.

However, the SAE Shot Numbers and SAE Grit Numbers are different from the ISO Grade Codes although the equivalents are the same size grading.

The SAE Shot Numbers and corresponding ISO Grade Codes are as follows:

Steel Shot

Sieve No	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120
Mesh (mm)	2.80	2.36	2.00	1.70	1.40	1.18	1.00	0.85	0.71	0.60	0.50	0.42	0.35	0.30	0.18	0.12
SAE ISO																
S780	0%		85% Min	97% Min												
	0%		85% Min	97% Min												
S660		0%		85% Min	97% Min											
		0%		85% Min	97% Min											
S550			0%		85% Min	97% Min										
			0%		85% Min	97% Min										
S460			0%	5% Max		85% Min	96% Min									
			0%	5% Max		85% Min	96% Min									
S390			0%	5% Max		85% Min	96% Min									
			0%	5% Max		85% Min	96% Min									
S330				0%	5% Max		85% Min	96% Min								
				0%	5% Max		85% Min	96% Min								
S280					0%	5% Max		85% Min	96% Min							
					0%	5% Max		85% Min	96% Min							
S230						0%	5% Max		85% Min	97% Min						
						0%	5% Max		85% Min	97% Min						
S170							0%	10% Max		85% Min	96% Min					
							0%	10% Max		85% Min	96% Min					
S110									0%	10% Max			80% Min	90% Min		
									0%	10% Max			80% Min	90% Min		
S070											0%	10% Max		80% Min	90% Min	
											0%	10% Max		80% Min	90% Min	
Sieve No	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120
Mesh (mm)	2.80	2.36	2.00	1.70	1.40	1.18	1.00	0.85	0.71	0.60	0.50	0.42	0.35	0.30	0.18	0.12

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The SAE Shot Numbers and corresponding ISO Grade Codes are as follows:

Steel Grit

Sieve No	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120
Mesh (mm)	2.80	2.36	2.00	1.70	1.40	1.18	1.00	0.85	0.71	0.60	0.50	0.42	0.35	0.30	0.18	0.12
SAE	ISO															
G10		0%	80% min	90% min												
	G240	0%	80% min	90% min												
G12		0%	80% min	90% min												
	G200	0%	80% min	90% min												
G14			0%	80% min	90% min											
	G170		0%	80% min	90% min											
G16				0%	75% min	85% min										
	G140			0%	75% min	85% min										
G18					0%	75% min	85% min		85% min							
	G120				0%	75% min	85% min		85% min							
G25						0%	70% min					80% min				
	G100					0%	70% min					80% min				
G40							0%					70% min		80% min		
	G070						0%					70% min		80% min		
G50									0%					65% min	75% min	
	G050								0%					65% min	75% min	
G80												0%			65% min	75% min
	S030											0%			65% min	75% min
Sieve No	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120
Mesh (mm)	2.80	2.36	2.00	1.70	1.40	1.18	1.00	0.85	0.71	0.60	0.50	0.42	0.35	0.30	0.18	0.12