



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 as well as pressure blasting. Pressure blasting should be done using 90-100 psi nozzle pressure. The depth of anchor pattern used in this chart is an average and not a minimum or maximum depth obtainable.

1 Mil Profile

G-80 Steel Grit
S-110 Steel Shot*
80 Mesh Garnet
100 Aluminum Oxide
Patriot Blast Elite 3060
Patriot Blast Glass 4070

1.5 Mil Profile

G-50 Steel Grit
S-170 Steel Shot*
30/60 Mesh Garnet
50 Grit Aluminum Oxide
Patriot Blast Elite 3060
Patriot Blast Glass 3060

2 Mil Profile

G-40 Steel Grit
S-230 Steel Shot*
36 Mesh Garnet
36 Grit Aluminum Oxide
Patriot Blast Elite 2040
Patriot Blast Glass 2030

2.5 Mil Profile

G-40 Steel Grit
S-280 Steel Shot*
16 Mesh Garnet
24 Grit Aluminum Oxide
Patriot Blast Elite 2040
Patriot Blast Glass 2030

3-4 Mil Profile

G-25 Steel Grit
S-330 or 390 Steel Shot*
16 Mesh Garnet
16 Grit Aluminum Oxide
Patriot Blast Elite 1240
Patriot Blast Glass 1230

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