

W ABRASIVES SIZE SPECIFICATIONS



SHOT SIZE SPECIFICATIONS

Values given in cumulated weight %

Sieve #	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120	200	Nominal dimension (mm)
mm	2.8	2.36	2.0	1.7	1.4	1.18	1.0	0.85	0.71	0.6	0.5	0.425	0.355	0.3	0.18	0.125	0.075	
S780	AP		> 90	> 97														2.00
S660	AP	< 20		> 97														1.70
S550		AP	< 30		> 90	> 97												1.40
S460			AP	< 30		> 90	> 97											1.18
S390				AP	< 20		> 85	> 97										1.00
S330					AP	< 10		> 85	> 97									0.85
S280						AP	< 30		> 90	> 97								0.71
S230							AP	< 30		> 90	> 97							0.60
S170								AP	< 30		> 90	> 97						0.50
S110									AP	< 20				> 90	> 97			0.30
S070											AP	< 5			> 90	> 97		0.18



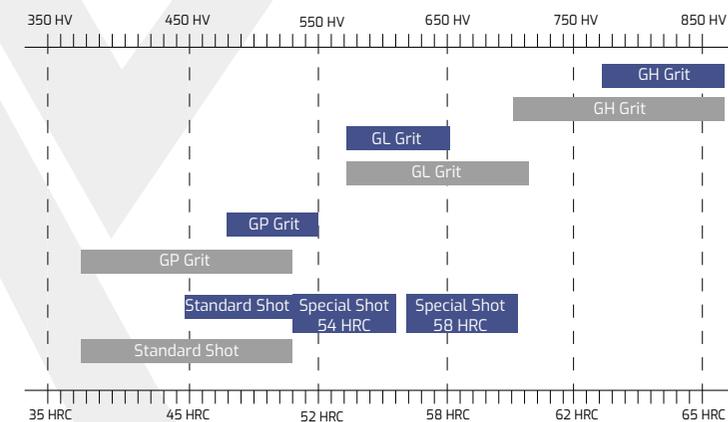
GRIT SIZE SPECIFICATIONS

Values given in cumulated weight %

Sieve #	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120	200	Nominal dimension (mm)
mm	2.8	2.36	2.0	1.7	1.4	1.18	1.0	0.85	0.71	0.6	0.5	0.42	0.35	0.3	0.18	0.12	0.07	
G12	AP	< 20		> 85	> 97													1.70
G14		AP	< 10		> 80	> 90												1.40
G16			AP	< 10		> 80	> 90											1.18
G18				AP	< 30		> 85	> 97										1.00
G25					AP	< 40			> 85	> 95								0.71
G40						AP	< 20				> 90	> 96						0.50
G50							AP	< 10				> 80	> 90					0.355
G80										AP	< 20			> 75	> 90			0.18
G120												AP	< 10		> 50	> 80		0.125

HARDNESS GRADING

W Abrasives ISO 11124-3



Other specifications upon request



W Abrasives®
your key success factor

HIGH-CARBON STEEL SHOT AND GRIT BY W ABRASIVES

ALL WINOA SITES ARE CERTIFIED:

- ISO 9001
- ISO 14001
- ISO 45001



PE/0121/GBWVA/087

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preparing tomorrow's surfaces

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MAIN FEATURES OF ABRASIVES

W ABRASIVES	Steel Shot	Steel grit GP	Steel grit GL	Steel grit GH
Shape	Round	Angular		
Chemical composition	%C 0.8-1.2 %Si 0.4-1.2 %S&P < 0.05		%Mn 0.35-1.2 S070 and S110 %Mn 0.5-1.2 for S170 %Mn 0.6-1.2 for S230 and above, all grit sizes	
Hardness	Shots: 450-530 HV (45-51 HRC) 540-610 HV (52-56 HRC) 620-700 HV (56-60 HRC)		Grits: GP: 480-550 HV (48-52 HRC) GL: 570-650 HV (54-58 HRC) GH: ≥ 770 HV (≥ 63 HRC)	
Density	Absolute ≥ 7kg/dm ³		Apparent ≥ 4kg/dm ³	
Conductivity	< 30 μS/cm			
Microstructure x500	Tempered martensite with <15% of residual austenite			As-quenched martensite
Applicable specifications	SAE J444, SAE J827, SAE J1993, SSPC-AB3, ISO 11124-3 (except size distributions which follow W Abrasives specifications - see dedicated section)			

NUMBER OF PARTICLES PER KG IN NEW PRODUCTS

Product		Average diameter mm	Number of particles per kg of new product
Shot	Grit		
WS-780		2	25 000
WS-660	WG-12	1.7	42 000
WS-550	WG-14	1.4	70 000
WS-460	WG-16	1.18	120 000
WS-390	WG-18	1	205 000
WS-330		0.85	335 000
WS-280	WG-25	0.71	550 000
WS-230		0.6	925 000
WS-170	WG-40	0.5	1 660 000
	WG-50	0.35	4 930 000
WS-110		0.3	7 480 000
WS-70	WG-80	0.21	26 400 000



WELCOMING TOMORROW WITH A GLOBAL SERVICE PROVIDER

- 4 Test Centers
- 20 Technical Experts
- 150 Trials per year

BENEFIT FROM THE BEST EXPERTS



A global team of highly experienced application experts committed to deliver top-notch technical support and guide customers through the optimization of their blasting process.

LEARN AND GROW YOUR TEAMS



A full range of training solutions for operators, engineers, managers, to better master the blasting process and get the best from your machines.

TEAM UP WITH WINOA EXPERTS



A global network of testing facilities to optimize your process and tackle your challenges along with Wino experts.

HIGH-CARBON STEEL SHOT

Quenched and tempered high-carbon steel shot for general blasting operations, characterized by high resilience and superior rebounding properties.



HIGH-CARBON STEEL GRIT

Quenched and tempered high-carbon steel grit for general blasting operations, available under 3 hardness levels.



GP GRIT
GP hardness grit typically used in cleaning and descaling operations, it rounds-up rapidly after few working cycles for an optimum balance between cleaning efficiency and machine wear.



GL GRIT
GL hardness grit typically used in surface preparation and descaling operations, its sharp edges get progressively smoothed during service, leading to higher efficiency than GP grit.



GH GRIT
GH hardness grit typically used in air-blasting operations, it keeps its sharp edges along its whole service life, ensuring sharp surface profiles and uniform, etched surface finish.



PROFILUM
A ready-to-use operating mix for stringent air-blasting operations where surface profile consistency is a must.



SURFIUM
A high-performance grit for surface preparation by wheel-blasting, characterized by high lifetime and low dust generation during usage.



STAINIUM
A specially designed mix of shot and grit to ensure high-productivity of descaling operations and smooth surface finish.



PROWHEELIUM
A cost-efficient alternative to GH grit for surface preparation operations done by wheel-blasting.



HPG
A high-productivity grit for heavy-duty cleaning operations in foundries and forges.



HYBRID SHOT
A specially heat-treated mix of shot and grit to reach the most cost-efficient balance between productivity and machine wear.

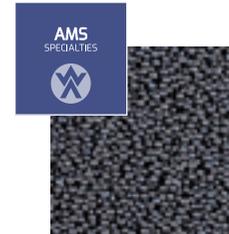


STELUX
A stainless-steel abrasives range for blasting operations on non-ferrous or stainless steel substrates, available under 3 grades.

STELUX C
A 16%Cr - 1,5%Ni stainless steel shot.

STELUX CN
A 18%Cr - 8%Ni stainless steel shot.

STELUX CG
A 30% high chromium cast iron grit.



AMS
A cast steel shot for peening operations in military and aerospace industries (fully meet AMS 2431 as well as many other proprietary standards).



HIGH DURABILITY CUT WIRE
A high-durability conditioned cut-wire for shot-peening operations, manufactured by Toyo Seiko company in Japan.



W Abrasives®
your key success factor