



**NACE SP0615 WAB  
Item No. 21197**

## **Standard Practice**

# **SSPC Surface Preparation Standard NACE WAB-2/SSPC-SP 10 (WAB) Near-White Metal Wet Abrasive Blast Cleaning**

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NACE International  
15835 Park Ten Place  
Houston, TX 77084-5145  
+1 281-228-6200

SSPC: The Society for Protective Coatings  
800 Trumbull Drive  
Pittsburgh, PA 15205  
+1 412-281-2331

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## Foreword

This NACE/SSPC joint standard defines the process for preparing a carbon steel surface to the Near-White Metal degree of surface cleanliness using a wet abrasive blast (WAB) method of cleaning. This standard is intended for use by coating or lining specifiers, applicators, inspectors, or others whose responsibility is to define a standard degree of surface cleanliness for carbon steel surfaces to be achieved by wet abrasive blast cleaning.

Degree of Surface Cleanliness	Designation
White Metal WAB	NACE WAB-1/SSPC-SP 5 (WAB) <sup>1</sup>
Near-White Metal WAB	NACE WAB-2/SSPC-SP 10 (WAB)
Commercial WAB	NACE WAB-3/SSPC-SP 6 (WAB) <sup>2</sup>
Industrial WAB	NACE WAB-8/SSPC-SP 14 (WAB) <sup>3</sup>
Brush-Off WAB	NACE WAB-4/SSPC-SP 7 (WAB) <sup>4</sup>

WAB cleaning is a process using a mixture of water and abrasive that can produce various levels of surface cleanliness and surface profile (roughness) similar to those obtained with dry abrasive blast (DAB) cleaning. WAB cleaning may be specified when dust suppression is desired, and may also be a means for reducing soluble salt contamination. The WAB cleanliness level specified should be the same as the corresponding degree of cleaning specified if DAB cleaning were the process being used.

The focus of this standard is Near-White Metal WAB cleaning. The five degrees of WAB cleaning are as follows:

Near-White Metal WAB cleaning provides a greater degree of cleaning than Commercial WAB cleaning (NACE WAB-3/SSPC-SP 6 [WAB]) but less than White Metal WAB cleaning (NACE WAB 1/SSPC- SP 5 [WAB]).

Near-White Metal WAB cleaning is used when the objective is to remove all rust and other corrosion products, coating, and mill scale, but when the extra effort required to remove all stains of these materials is determined to be unwarranted.

Near-White Metal WAB cleaning allows staining on no more than 5% of each unit area of surface, while commercial WAB cleaning allows staining on no more than 33% of each unit area of surface. White Metal WAB cleaning does not permit any staining to remain on the surface.

This standard references the three levels of flash rust as defined in the NACE/SSPC joint standards for waterjetting (see Paragraph 3.1 in this standard).<sup>5-8</sup> Nonmandatory Appendixes A, B, and C offer additional information regarding flash rust.

Steel surfaces prepared by WAB cleaning can develop flash rust within minutes after the cleaning is completed. The project specification often contains requirements for the permissible level of flash rust before coating application (Additional information is provided in Appendix A, Paragraph A1 and Appendix C.)