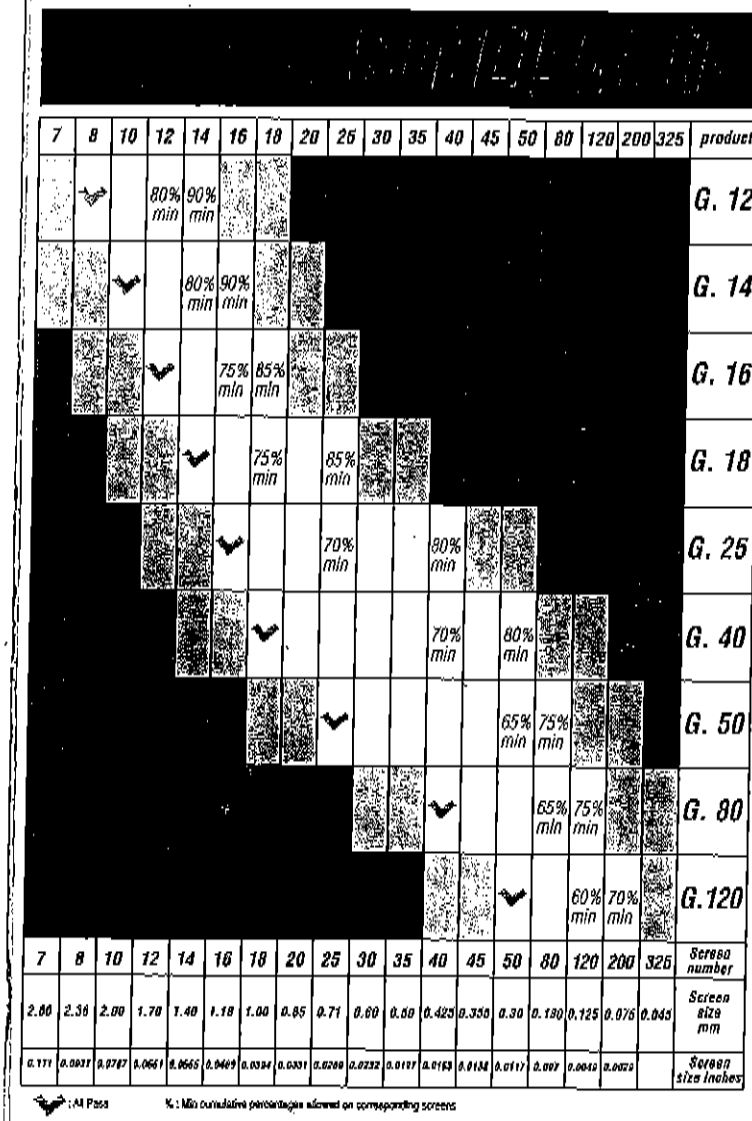

Cast steel angular grit is produced by crushing specially heat treated shot pellets. Its behavior characteristics in service are very much dependent upon the hardness selection of GP, GB, GL or GH grit.

GP STEEL GRIT
Angular when new, this grit rapidly rounds off in use and is particularly suited to descaling applications.

GB STEEL GRIT
More aggressive than GP, with many characteristics similar to GL.

GL STEEL GRIT
Although harder and more aggressive than GP Steel Grit, GL also loses its sharp edges during shotblasting and is particularly suited to descaling and surface preparation applications.

GH STEEL GRIT
Having maximum hardness, GH always remains angular in its operating mix. This steel grit does not shatter readily yet has a fast, effective, etching action, making it ideal for deep descaling and etched surface requirements. For use mainly with compressed air equipment.

Wheelabrator Steel Shot And Grit Specifications

PROPERTY	SHOT	GP	GL	GH
SIZE	All material is screened to meet or exceed SAE & SFS Specs.			
CHEMISTRY Carbon Sulfur Phosphorus	 0.85 - 1.20 Less than 0.05 Less than 0.05	 0.85 - 1.20 Less than 0.05 Less than 0.05	 0.85 - 1.20 Less than 0.05 Less than 0.05	 0.85 - 1.20 Less than 0.05 Less than 0.05
AV. HARDNESS	40-50 Rc	40 - 50 Rc	56 - 60 Rc	60 - 66 Rc
HARDNESS DEVIATION*	Maximum average deviation is + 3.0 Rc			
MICROSTRUCTURE	Highly refined and homogeneous tempered martensite and bainite.			Martensite and retained austenite.
MINIMUM DENSITY (as determined by displacement of alcohol)	7.3 g/cc	7.6 g/cc	7.6 g/cc	7.6 g/cc

** Hardness is tested with a Tukon® Microhardness Tester with Knoop Indenter, 1000 gram load or equivalent.*

Wheelabrator steel abrasives sizes and general applications

(Based on results obtained with a 49 1/2" dia. w/a at 2250 R.P.M.)

Wheelabrator Steel Shot	Approx. Size of Abrasive	"Arc-Height" Expected in Peening Applications	Shot Finish Produced	General Applications	Corresponding SAE Grit Size*	Grit Finish Produced
(None) (None)	.002" .004"			Blasting of small ferrous & non-ferrous work & machined parts. Removal of very light scale.	* G-200 G-120	Very light etch-Matte or satin finish.
• S- 70 • S-110 • S-170	.007" .011" .017"	.004 To .007 A_2 .007 To .011 A_2 .012 To .015 A_2	Fine, smooth shot finish. Excellent coverage.	Blasting of relatively small ferrous & non-ferrous castings. Removal of light scale from forgings & heat treated parts. Blasting of machined parts. Removal of mill scale, rust & other deposits.	G-80 ▲ G-50 ▲ G-40	Medium etch
• S-230 • S-280 • S-330	.023" .028" .033"	.016 To .019 A_2 .020 To .024 A_2 .024 To .028 A_2	Medium-light shot finish. Good coverage.	Blasting of grey iron, malleable iron, light steel castings, medium forgings, heat treated parts & heavy mill scale, – rust & other deposits.	▲ G-25	Sharp etch
• S-390 • S-460 • S-550	.039" .046" .055"	.007 To .011 C_2 .012 To .016 C_2	Average to heavy shot finish. Average coverage.	Blasting of steel, heavy mall, and grey iron castings. Removal of scale from large billets, slabs - rust & other deposits.	▲ G-18 ▲ G16 ▲ G-14	Deep etch rough
• S-660 • S-780	.066" .078"		Rough coverage. Adequate for most applications.	Heavy steel castings. Removal of tough heavy scale.	*▲ G-12 *▲ G-10	Very rough

* Not often used

The above chart lists the abrasive sizes most commonly used in blasting operations – the encircled dots to the left of the SAE size number represent the appoximate shape and size of actural abrasive pellets. The round Wheelabrator Steel Shot is heat treated and drawn to a hardness of 42 to 50 Rockwell "C." Wheelabrator angular products are available in various degrees of hardness.