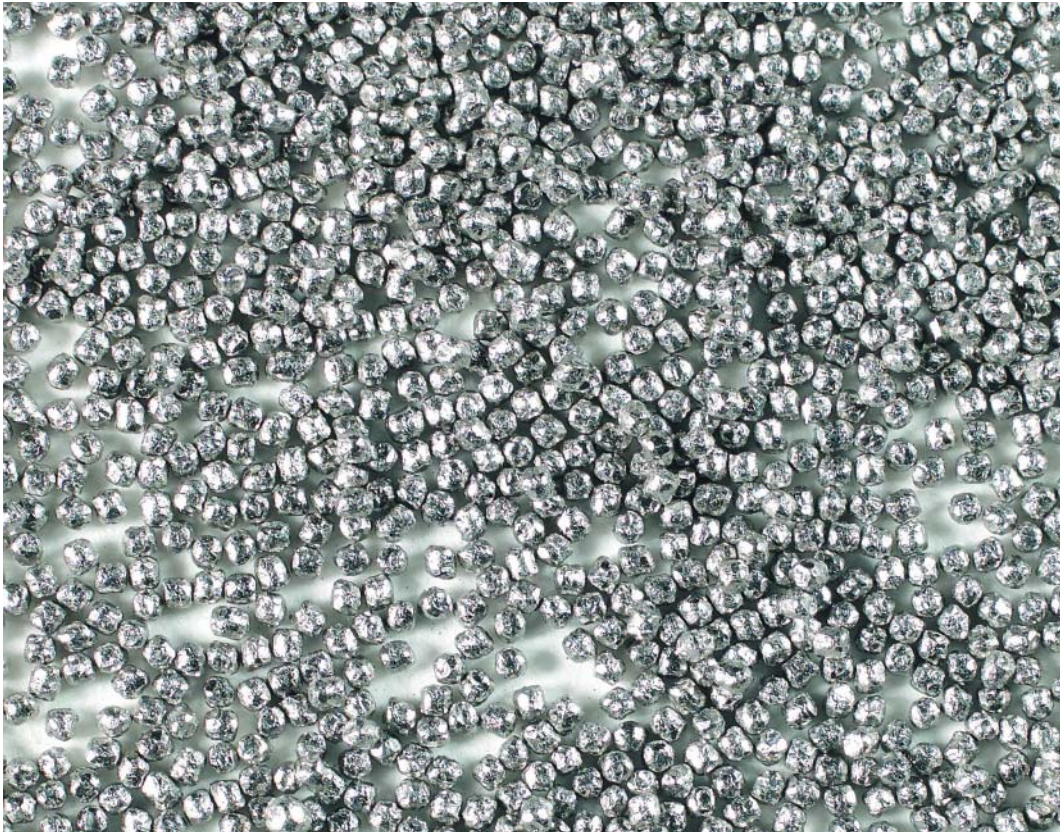


Metallic blast media



Wheelabrator Plus, offer a wide range of metallic media meeting both commercial and aerospace specifications for both cleaning and shot peening.

High carbon cast steel shot - Available in a range of different hardness, this is the metallic medium most used for recirculatory blasting in both airless and pressure blasting equipment.

Low carbon cast steel shot - A softer shot than high carbon being suitable for all but the most severe applications. This material imparts a brighter finish with the benefits of longer life and reduced wear on the equipment in which it is used.

Chilled iron grit - A very hard, sharp material with sufficient mass to enable it to impart very coarse surface profiles and rapid removal of surface contamination.

High carbon steel grit - Available in different hardnesses to provide an efficient cutting action allied with longer life and less machine wear than chilled iron grit.

Cut wire pellets and shot - The pellets are extremely aggressive being denser than conventional shot and are also of uniform size rather than a range of sizes within a given grade. The spherical version is the ultimate high quality, high intensity peening medium.

Stainless steel shot - A relatively soft peening medium possessing the impact energy of a metallic media without imparting ferrous contamination. Stainless steel shot provides a lustrous bright finish to workpieces.

For more information please contact:

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Metallic blast media Technical specifications

Stocks

Wheelabrator Plus holds extensive stocks of over 400 tons of mixed abrasives and generally aims to deliver within 3-5 working days from receipt of order.

Approvals

Wheelabrator Plus metallic media can be supplied to the following specifications:

MIL-Spec S851, MIL-Spec S13165
SAE J444, SAE J1993, SAE J827
SAE AMS 2431/1,2 CSS 119, CSS 118,
DIN 8201.

Packaging

Standard packaging in 25kg bags.

Physical properties

	High carbon steel shot	Steel grit	Low carbon steel shot	Stainless steel shot	Chilled iron grit	Cut wire pellets or conditioned
Shape	Spherical	Angular	Spherical	Spherical	Angular	Rod shaped or spherical
Hardness rockwell C	40-50 45-52 55-62	≥64	40-47	40-50 45-52 55-62	≤57	45-55
Density gm/cc	<7	<7	7	>7	7	54>65
Buld density gm/cc	4.5	4.5	4.30-4.55	4.7	4.5	7.8
Grades available	S70 S110 S170	G80 G50 G40 G25	S70 S110 S170	10 20 30 40	G2 G5 G7 G12	4.5
Fine >Coarse	S230 S280 S330 S390 S460 S550 S660 S780	G18 G16 G14 G12	S230 S280 S330 S390 S460 S550 S660 S780 S930	50 60 100	G17 G24 G34 G39 G47 G55 G66 G80	0.30 mm 0.35 mm 0.40 mm 0.50 mm 0.60 mm 0.70 mm 0.80 mm 0.90 mm 1.00 mm

Composition of metallic abrasives

	Chilled iron grit	High carbon steel shot & grit	Low carbon steel shot
C	3.00	0.85 - 1.20	0.09 - 0.14
Si	1.60	0.40 - 1.50	0.01 - 0.18
Mn	0.50	0.35 - 1.20	1.15 - 1.50
P	≤0.15	0.05 maximum	0.035 maximum
S	≤0.15	0.05 maximum	0.035 maximum
Fe	Balance	Balance	Balance

	Stainless steel shot	Stainless steel grit
C	0.2 ± 0.05	0.25 ± 0.05
Cr	18.00 ± 2.00	14.0 ± 1.00
Ni	2.00 ± 0.50	2.00 ± ± 0.50
Si	8.00 ± 1.00	-
Mn	1.00 ± 0.30	-
Fe	Balance	Balance
Structure	Austenite	Martensite/Ferrite