

SPECIALTY PRODUCTS

STAINLESS STEEL

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

Round



STELUX C

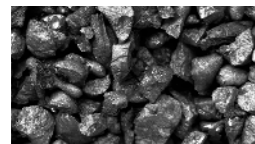
A 16%Cr - 1,5%Ni stainless steel shot.



STELUX CN

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

Grit



STELUX CG

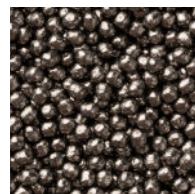
A 30% high chromium cast iron grit.

SHOT PEENING



AMS

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



CUT WIRE PELLETS

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



W Care
by Winoa

Welcoming tomorrow with a global service provider



6
Technical Centers
20
Technical Experts
150
Trials per year

CONSULTING

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.

TRAINING

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.

TESTING

Team up with Winoa experts

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

MAINTENANCE

Meet your needs with a skilled workforce

Refocus your valuable time and energy, let W Care's experienced specialists take care of your blasting equipment, reduce your operational costs and provide quality expertise.

preparing tomorrow's surfaces



W Abrasives
by Winoa

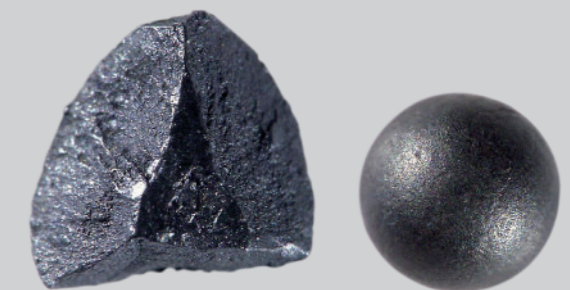
HIGH CARBON
100% RECYCLABLE
STEEL ABRASIVES

ALL WINOA SITES ARE CERTIFIED:

ISO 9001
ISO 14001
ISO 45001

Winoa
www.winoa.com

This document is not contractually binding, it sets out SAE specifications. Please make sure that this is the latest document available! Property of Winoa.



winoa



PREMIUM

Unique, high quality product range supported by its own teams of technical advisors to provide a «premium» experience to the most successful customers in order to obtain optimal blasting results, in terms of quality, efficiency and costs.

PROFILUM

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



preparing

SURFIUM

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



preparing

STAINIUM

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



preparing

PROWHEELIUM

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



preparing

HPG

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



cleaning

HYBRID SHOT

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



cleaning

STANDARD

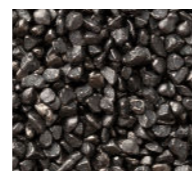
HIGH-CARBON STEEL SHOT

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



HIGH-CARBON STEEL GRIT

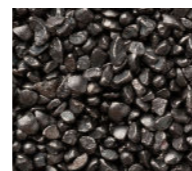
Quenched and tempered high-carbon steel grit for general blasting operations, available under 3 hardness levels.



G 16

GP GRIT

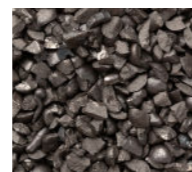
GP hardness grit typically used in cleaning and descaling operations, it rounds up rapidly after few working cycles for an optimum balance between cleaning efficiency and machine wear.



G 25

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.



G 50

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.

SAE SIZE SPECIFICATIONS



SHOT SIZE SPECIFICATIONS

Sieve #	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120
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	0.355	0.3	0.18	0.125
in	0.111	0.0937	0.0787	0.0661	0.0555	0.0469	0.0395	0.0331	0.0278	0.0234	0.0197	0.0165	0.0139	0.0117	0.007	0.0049
S780	AP		> 85	> 97												
S660		AP		> 85	> 97											
S550			AP		> 85	> 97										
S460			AP	< 5		> 85	> 96									
S390				AP	< 5		> 85	> 96								
S330					AP	< 5		> 85	> 96							
S280						AP	< 5		> 85	> 96						
S230							AP	< 10		> 85	> 97					
S170								AP	< 10			> 85	> 97			
S110										AP	< 10			> 80	> 90	
S070												AP	< 10		> 80	> 90

Values given in cumulated weight % / Cast Shot SAE Specifications J 444

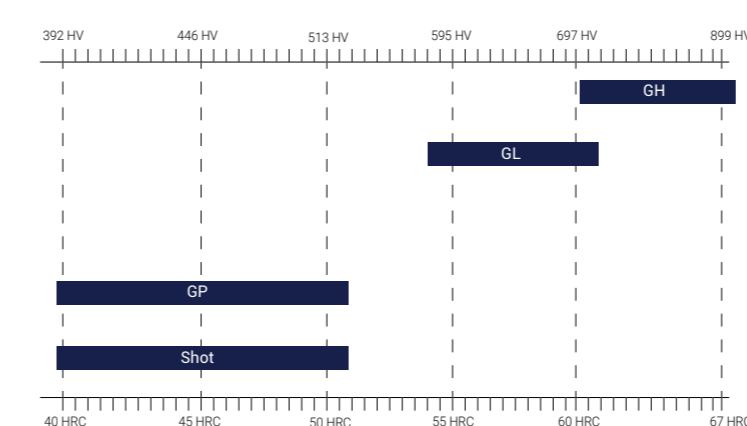


GRIT SIZE SPECIFICATIONS

Sieve #	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120	200
mm	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
in	0.0937	0.0787	0.0661	0.0555	0.0469	0.0395	0.0331	0.0278	0.0234	0.0197	0.0165	0.0139	0.0117	0.007	0.0049	0.0029
G12		AP		> 80	> 90											
G14			AP		> 80	> 90										
G16				AP		> 75	> 85									
G18					AP		> 75	> 85								
G25						AP		> 70			> 80					
G40							AP				> 70		> 80			
G50								AP				> 65	> 75			
G80										AP			> 65	> 75		
G120												AP		> 60	> 70	

Values given in cumulated weight % / Cast Grit SAE Specifications J 444

HARDNESS GRADING



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 min %S < 0,05 %P < 0,05		%Mn 0,35-1,2 S070 e S110 %Mn 0,5-1,2 pora S170 %Mn 0,6-1,2 for S230 and above, all grit sizes	
Hardness	Shots: 390-530 HV (40-51 HRC) 540-610 HV (52-56 HRC) 620-700 HV (56-60 HRC)		Grit: GP: 40-51 HRC GL: 54-61 HRC GH: ≥ 60 HRC	
Density	Absolute ≥ 7 g/cm³		Apparent ≥ 4 g/cm³	
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			

Number of particles

Product		Average diameter mm	Number of particles per weight of new product	
Round	Grit		p/Kg	p/lb
S-780		2	25 000	11 000
S-660	G-12	1,7	42 000	19 000
S-550	G-14	1,4	70 000	32 000
S-460	G-16	1,18	120 000	55 000
S-390	G-18	1	205 000	93 000
S-330		0,85	335 000	153 000
S-280	G-25	0,71	550 000	250 000
S-230	G-40	0,6	925 000	420 000
S-170	G-50	0,425	1 660 000	1 200 000
S-110		0,3	7 480 000	3 400 000
S-70	G-80	0,21	26 400 000	12 000 000