

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

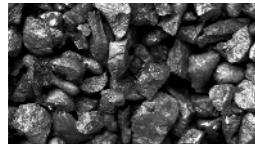
A 16%Cr - 1,5%Ni stainless steel shot.



STELUX CN

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

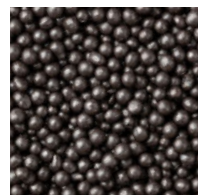
Grit



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:

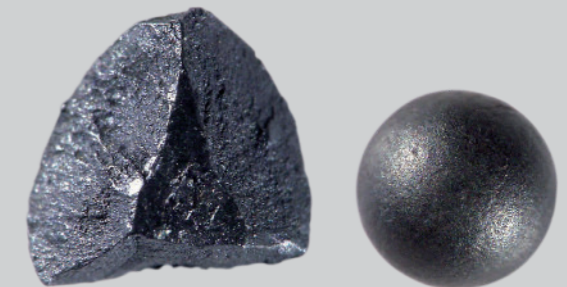
ISO 9001

ISO 14001

ISO 45001

Winoa
www.winoa.com

This document is not contractually binding,
it sets out W Abrasives specifications.
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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.

W ABRASIVES 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
S780	AP	<20	>90	>97												
S660	AP	<20	>97													
S550		AP	<30	>90	>97											
S460			AP	<30	>90	>97										
S390				AP	<20	>85	>97									
S330					AP	<10	>85	>97								
S280						AP	<30	>90	>97							
S230							AP	<30	>90	>97						
S170								AP	<30	>90	>97					
S110									AP	<20			>90	>97		
S070											AP	<5		>90	>97	

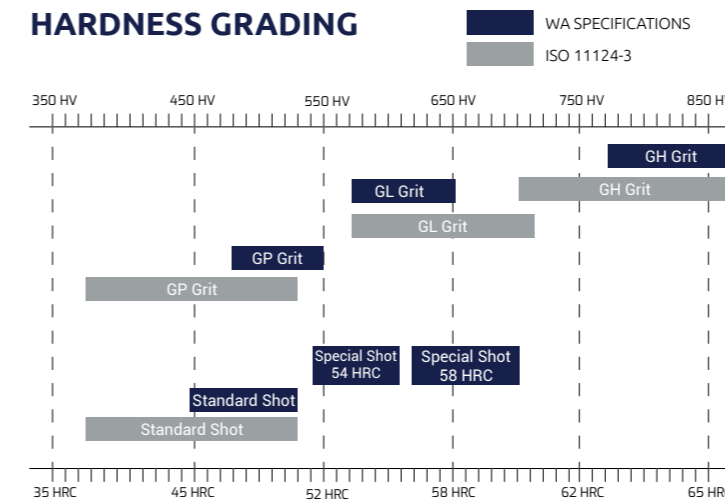
Values given in cumulated weight % / Cast Shot W Abrasives Specifications

GRIT SIZE SPECIFICATIONS

Sieve #	7	8	10	12	14	16	18	20	25	30	35	40	45	50	80	120	200
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												
G14		AP	<10		>80	>90											
G16			AP	<10		>80	>90										
G18				AP	<30		>85	>97									
G25					AP	<40		>85	>95								
G40						AP	<20			>90	>96						
G50							AP	<10				>80	>90				
G80										AP	<20			>75	>90		
G120												AP	<10		>50	>80	

Values given in cumulated weight % / Cast Grit W Abrasives Specifications

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: 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 ≥ 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 (except size distributions which follow W Abrasives specifications - see dedicated section)			

Number of particles

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