



NACE No. 6/SSPC-SP 13
Item No. 21082
Revised 2018-05-15
Reaffirmed 2003-03-17
Approved 1997

NACE No. 6/SSPC-SP 13, Surface Preparation of Concrete

This NACE International/SSPC: The Society for Protective Coatings joint surface preparation standard represents a consensus of those individual members who have reviewed this document, its scope, and provisions. Its acceptance does not in any respect preclude anyone, whether he or she has adopted the standard or not, from manufacturing, marketing, purchasing, or using products, processes, or procedures not in conformance with this standard practice. Nothing contained in this NACE/SSPC standard is to be construed as granting any right, by implication or otherwise, to manufacture, sell, or use in connection with any method, apparatus, or product covered by letters patent, or as indemnifying or protecting anyone against liability for infringement of letters patent. This standard represents minimum requirements and should in no way be interpreted as a restriction on the use of better procedures or materials not discussed herein. Neither is this standard intended to apply in all cases relating to the subject. Unpredictable circumstances may negate the usefulness of this standard in specific instances. NACE and SSPC assume no responsibility for the interpretation or use of this standard by other parties, and accept responsibility for only those official NACE or SSPC interpretations issued by NACE or SSPC in accordance with their governing procedures and policies, which preclude the issuance of interpretations by individual volunteers.

Users of this NACE/SSPC standard are responsible for reviewing appropriate health, safety, and regulatory documents and for determining their applicability in relation to this standard prior to its use. This NACE/SSPC standard may not necessarily address all potential health and safety problems or environmental hazards associated with the use of materials, equipment, and/or operations detailed or referred to within this standard. Users of this NACE/SSPC standard also are responsible for establishing appropriate health, safety, and environmental protection practices, in consultation with appropriate regulatory authorities if necessary, to achieve compliance with any existing applicable regulatory requirements prior to the use of this standard.

CAUTIONARY NOTICE: NACE/SSPC joint surface preparation standards are subject to periodic review, and may be revised or withdrawn at any time in accordance with NACE/SSPC technical committee procedures. NACE and SSPC require that action be taken to reaffirm, revise, or withdraw this standard no later than five years from the date of initial publication and subsequently from the date of each reaffirmation or revision. The user is cautioned to obtain the latest edition. Purchasers of NACE/SSPC standards may receive current information on all standards and other NACE/SSPC joint publications by contacting the organizations at the addresses below:

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

ABSTRACT

This NACE International/SSPC joint standard practice covers the preparation of concrete surfaces before the application of protective coating or lining systems. The standard includes two updated tables, Table 1 details classes of surface preparation, and Table 2 provides minimum acceptance criteria for concrete surfaces before coatings are applied and relevant test methods. The updated Appendix (nonmandatory) includes two additional tables, Table A1 provides typical surface properties of finished concrete, and Table A2 provides an extensive list of surface preparation methods for concrete surfaces. This standard should be used by specifiers, applicators, inspectors, and others who are responsible for defining a standard degree of cleanliness, strength, profile, and dryness of prepared concrete surfaces.

KEYWORDS

abrasive blasting, acid etching, cementitious repair, coating adhesion, coatings, concrete, lining systems, NACE No. 6, protective coating systems, surface preparation, spalling, surface profile, tensile strength, TG 417, vacuum cleaning, waterjetting

©2018 NACE International, 15835 Park Ten Place, Suite 200, Houston TX 77084, USA. All rights reserved. Reproduction, republication or redistribution of this standard in any form without the express written permission of the publisher is prohibited. Contact NACE International by means of our website www.nace.org, email FirstService@nace.org, or (phone) 281-228-6223 for reprints of this standard.

Foreword

In NACE/SSPC standards, the terms “shall,” “must,” “should,” and “may” are used in accordance with Paragraph 2.2.1.8 of the Agreement between NACE International and SSPC: The Society for Protective Coatings. The terms “shall” and “must” are used to state mandatory requirements. The term “should” is used to state something considered good and is recommended but is not mandatory. The term “may” is used to state something considered optional.

This NACE International/SSPC Joint standard covers the preparation of concrete surfaces before the application of protective coating or lining systems. This standard should be used by specifiers, applicators, inspectors, and others who are responsible for defining a standard degree of cleanliness, strength, profile, and dryness of prepared concrete surfaces.

This standard was originally prepared in 1997 by NACE/SSPC Joint Task Group (TG) F, “Surface Preparation of Concrete.” It was reaffirmed in 2003 by NACE Specific Technology Group (STG) 04, “Coatings and Linings, Protective—Surface Preparation,” and SSPC Group Committee C.2, “Surface Preparation.” It was revised in 2018 by TG 417 (formerly Task Group F). This standard is issued by NACE under the auspices of STG 04, and by SSPC Group Committee C.7.7.

NACE No. 6/SSPC-SP 13, Surface Preparation of Concrete

- 1. General4
- 2. Definitions5
- 3. Inspection Procedures Before Surface Preparation.....6
- 4. Surface Preparation8
- 5. Inspection and Classification of Prepared Concrete Surfaces10
- 6. Acceptance Criteria.....12
- 7. Safety and Environmental Requirements.....13
- References.....13
- Appendix A: Comments (Nonmandatory).....17

Tables

- Table 1: Classes of Surface Preparation.....4
- Table 2: Minimum Acceptance Criteria for Concrete Surfaces Before Coatings are Applied12
- Table A1: Typical Surface Properties of Finished Concrete17
- Table A2: Surface Preparation Methods.....21