

DETERMINING PROPER BLASTOX® BLEND RATIOS

A majority of projects that utilize dry blasting with Blastox® for lead abatement on steel use a blend ratio of 15 percent by weight. This is satisfactory for an application rate of 6 lbs or greater of blended abrasive per square foot of surface abraded. When the application rate is reduced below 6 lbs, it is necessary to increase the amount of Blastox® so that there is a sufficient amount of chemistry to adequately stabilize each square foot of lead paint. The scenarios where an increased rate is required are when: an application rate on steel is less than 6 lbs per square foot; a brick, concrete or masonry substrate is blasted; a wood substrate is blasted; or, a Torbo slurry (wet) blast system is utilized. The following information specifies the ratio of Blastox® to be used in each instance.

As mentioned, the ratio of Blastox® used for dry abrasive blasting on steel substrates is most often 15 percent. This is based on the expectation that a minimum application rate of 6 lbs or greater of abrasive per square foot of surface prepared is used. This minimum application rate covers most surface preparation requirements, but when less than 6 lbs is used, as the case is for a brush or sweep blast, a 20 percent blend of Blastox® is necessary.

When blasting brick, concrete or masonry work with dry abrasive blasting, a 20 percent ratio of Blastox® is required. This type of substrate requires far less abrasive when dry blasting and necessitates an increased blend to 20 percent.

Wood blasting requires the use of 30 percent regardless of whether a dry abrasive blast system or a Torbo blast system is used. This type of soft substrate can require an extremely low application rate for surface preparation and thus requires the increase of Blastox® to 30 percent.

For projects that use the Torbo wet (slurry) blast system on steel surfaces, a 20 percent ratio of Blastox® is required. Concrete, brick, and masonry projects with Torbo require the use of a 30 percent Blastox® blend. Similarly, an increased blend rate to 30 percent is required for all wood work with the Torbo system.

Quick Reference Chart of Required Blastox® Ratios

Substrate/Application	6 lbs or more	3-6 lbs (dry)	3 lbs or less (dry)	Torbo
Steel	15%	20%	NA	20% (3-4 lbs.)
Brick, Concrete, Masonry	NA	20%	30%	30% (1.5-2 lbs.)
Wood	NA	30%	30%	30% (1-1.5 lbs.)

If the total amount of lead expressed as mg/kg (ppm) or as a percent in a coating system exceeds 400,000 mg/kg (ppm) or 40 percent, or for general questions on Blastox® blend ratios, please contact Technical Services.