



*P303: Graden van voorberekking  
P1/P2/P3  
Alinco NV*

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Pagina	Pagina 1 van 4

## 1. Scope

Deze procedure beschrijft hoe de voorberekking van de stalen constructie moet zijn als voorbereiding op de corrosiebescherming.

Er zijn drie graden van voorberekking, nl. P1, P2 en P3, waarbij de strengheid toeneemt van P1 naar P3.

## 2. Vaststellen van de graad van voorberekking

Een constructie kan verschillende graden bevatten.

Indien de verwachte levensduur van de corrosiebescherming en de corrosiecategorie opgelegd zijn, moet de graad van voorberekking overeenkomen zoals vastgelegd in tabel 22 van EN 1090-2.

à Indien er niets is opgegeven is de graad van voorberekking P1

Tabel 22 — Voorbekeringsgraad

Verwachte levensduur van de corrosiebescherming <sup>a</sup>	Corrosiecategorie <sup>b</sup>	Vorbekeringsgraad <sup>c</sup>
> 15 jaar	C1	P1
	C2 tot C3	P2
	Boven C3	P2 of P3 indien gespecificeerd
5 jaar tot 15 jaar	C1 tot C3	P1
	Boven C3	P2
< 5 jaar	C1 tot C4	P1
	C5 – Im	P2

<sup>a b</sup> De verwachte levensduur van de corrosiebescherming en de corrosiecategorie verwijzen naar EN ISO 12944 en EN ISO 14713 voor zover van toepassing.

### 3. Graden van voorbereking

Onderstaande tabel geeft weer welke eisen er gesteld worden per graad van voorbereking.

**Table 1 — Imperfections and preparation grades**

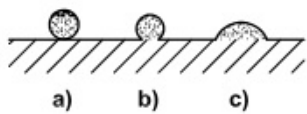
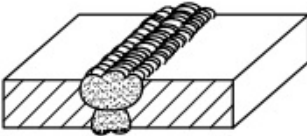
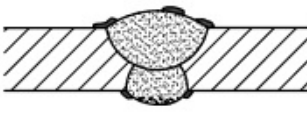
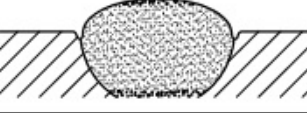
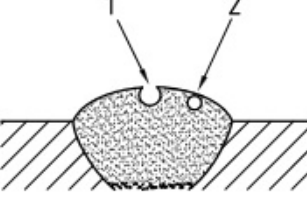


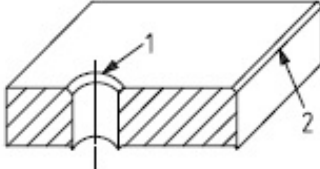
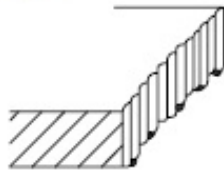



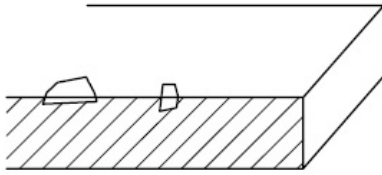
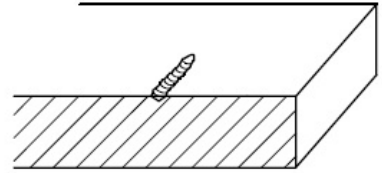
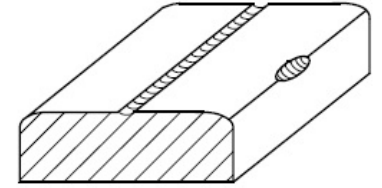
Type of imperfection		Preparation grades		
Description	Illustration	P1	P2	P3
<b>1 Welds</b>				
1.1 Welding spatter	 <p>a)      b)      c)</p>	Surface shall be free of all loose welding spatter [see a)]	Surface shall be free of all loose and lightly adhering welding spatter [see a) and b)] Welding spatter shown in c) may remain	Surface shall be free of all welding spatter
1.2 Weld ripple/profile		No preparation	Surface shall be dressed (e.g. by grinding) to remove irregular and sharp-edged profiles	Surface shall be fully dressed, i.e. smooth
1.3 Welding slag		Surface shall be free from welding slag	Surface shall be free from welding slag	Surface shall be free from welding slag
1.4 Undercut		No preparation	Surface shall be free from sharp or deep undercuts	Surface shall be free from undercuts
1.5 Weld porosity	 <p>1      2</p> <p><b>Key</b>            1 visible            2 invisible (might open after abrasive blast cleaning)</p>	No preparation	Surface pores shall be sufficiently open to allow penetration of paint, or dressed out	Surface shall be free from visible pores
1.6 End craters		No preparation	End craters shall be free from sharp edges	Surface shall be free from visible end craters

Table 1 — (continued)

Type of imperfection		Preparation grades		
Description	Illustration	P1	P2	P3
<b>2 Edges</b>				
2.1 Rolled edges		No preparation	No preparation	Edges shall be rounded with a radius of not less than 2 mm (see ISO 12944-3)
2.2 Edges made by punching, shearing, sawing or drilling	  Key 1 punching 2 shearing	No part of the edge shall be sharp; the edge shall be free from fins	No part of the edge shall be sharp; the edge shall be free from fins	Edges shall be rounded with a radius of not less than 2 mm (see ISO 12944-3)
2.3 Thermally cut edges		Surface shall be free of slag and loose scale	No part of the edge shall have an irregular profile	Cut face shall be removed and edges shall be rounded with a radius of not less than 2 mm (see ISO 12944-3)
<b>3 Surfaces generally</b>				
3.1 Pits and craters		Pits and craters shall be sufficiently open to allow penetration of paint	Pits and craters shall be sufficiently open to allow penetration of paint	Surface shall be free of pits and craters
3.2 Shelling NOTE In English-language usage, the terms "slivers" and "hackles" are also used to describe this type of imperfection.		Surface shall be free from lifted material	Surface shall be free from visible shelling	Surface shall be free from visible shelling
3.3 Roll overs/roll laminations/cut laminations		Surface shall be free from lifted material	Surface shall be free from visible roll-overs/laminations	Surface shall be free from visible roll-overs/laminations

**Table 1** (*continued*)

Type of imperfection		Preparation grades		
Description	Illustration	P1	P2	P3
3.4 Rolled-in extraneous matter		Surface shall be free from rolled-in extraneous matter	Surface shall be free from rolled-in extraneous matter	Surface shall be free from rolled-in extraneous matter
3.5 Grooves and gouges formed by mechanical action		No preparation	The radius of grooves and gouges shall be not less than 2 mm	Surface shall be free from grooves, and the radius of gouges shall be greater than 4 mm
3.6 Indentations and roll marks		No preparation	Indentations and roll marks shall be smooth	Surface shall be free from indentations and roll marks