

Weld Finishes



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COMMON SYMBOL	RANGE OF "Ra"	EXPLANATION FOR TYPE OF WELD FINISH OR FINISHING PROCESS
#AW	Greater than 250	Welds not cleaned or in an "As Welded/As Is" condition.
* #1W	Greater than 250	Welds to be stainless steel wire brushed or buffed with Behr-Tex type blending wheel, some weld splatter removal.
#2W	125 or less	Welds rough ground smooth and flush with #47 grit hard rock, then #60 grit flap wheels, square bobs, fire crackers or sanding belts; includes weld splatter and some heat tint removal.
#3W	40 thru 70	Welds finished using #9W and #2W processes plus a final #100/#120 grit sanding process; usually an exterior type weld finish when polishing required.
* #4W	20 thru 50	Welds finished using #9W, #2W and #3W processes plus additional #140/#150 grit sanding process; usually a food grade interior finish and / or exterior weld finish for food and pharmaceutical applications.
#4WE	less than 30	Welds finished as #4W with a final electropolish finish after completion of fabrication.
* #5W	15 thru 30	Welds finished using a combination of #9W, #2W, #3W and #4W processes plus a final #180 grit sanding process; usually a pharmaceutical standard interior common finish.
#5WE	less than 20	Welds finished as #5W with a final electropolishing after completion of fabrication.
* #6W	10 thru 25	Welds finished using a combination of #9W, #2W, #3W, #4W and #5W processes plus a final #240 grit sanding process in conjunction with a #220/#240 grit greaseless compound over red/gray wheels for final luster.
#6WE	less than 15	Welds finished as per #6W with a final electropolishing after completion of fabrication.
* #7W	5 thru 20	Welds ground finished using a combination of #9W, #2W thru #6W processes plus a final #320 grit sanding process in conjunction with a #320 grit greaseless compound over red/gray wheels for final luster and finish.
#7WE	less than 10	Welds finished as per #7W with a final electropolishing after completion of fabrication.
#8W	3 thru 10	Welds finished using steps #9W, #2W thru #7W processes plus a jewelers rough compound of #400/#500 grit over fine red/gray wheels to obtain finest mirror-like luster
#8WE	less than 5	Welds finished as per #8W with a final electropolishing after completion of fabrication.
* #9W	80 thru 250	Welds rough ground smooth, not necessarily flush, using #47 grit hard rock stone, plus removing weld splatter and some heat tint.
#10W	20 thru 100	Welds finished using #9W and #2W processes plus the addition of #60 grit sanding with weld splatter and heat tint removal.
#11W	Greater than 250	Welds to be fine silica sand (#81) blasted with weld splatter removed and only rough weld areas removed prior to blasting.
#12W	Greater than 250	Welds to be glass bead blasted (#3 size), includes removing weld splatter and some grinding of rough areas prior to blasting.
#13W	Greater than 250	Welds to be cleaned with pickling paste for removing heat tint only, no grinding included but some weld splatter removal included.
* Represents the most common weld finishes.		