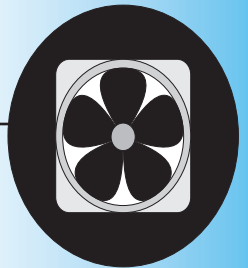
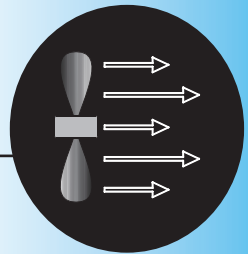


Abrasive Blasting



Chapter 296-818 WAC

September 2006 Edition

Standards Update to Chapter 296-818 WAC, Abrasive Blasting

Issue Date 9/2006
Effective Date 9/1/2006

The Department of Labor and Industries has rewritten and reorganized for clarity and ease of use the safety standards for Abrasive Blasting. The general industry requirements relating to Abrasive Blasting have been repealed from Chapter 296-24 WAC, General Safety & Health Standards and adopted as Chapter 296-818 WAC, Abrasive Blasting.

Chapter 296-24 WAC, General Safety & Health Standards

- Please discard Part H-2 (296-24-675 through 67521)

To receive future updates of this standard and all other Department of Labor and Industries safety and health standards electronically, please sign up on the WISHA Listserv (<http://www.lni.wa.gov/Safety/Rules/default.htm>). By subscribing to the Listserv, you will also receive rule updates, hearing notices, and informational packets for all safety and health rules.

Also available on the WISHA web site:

- WISHA Core Rules
- Other General WISHA Rules
- Industry and Task-specific Rules
- Proposed rules and hearings
- Newly adopted rules and new rule information
- WISHA Regional Directives (WRDs)
- WISHA Interim Operations and Interpretive Memoranda (WIIM)
- Memoranda of Understanding (MOU)

To receive hardcopy updates of this rule, please return the card located at the back of the book.

Abrasive Blasting

Chapter 286-818 WAC

Other Rules that may apply to your workplace

- The WISHA Safety and Health Core Rules, Chapter 296-800 WAC, contain the basic requirements that apply to most employers in Washington. They also contain:
 - An Introduction that lists important information you should know, including a section on building, fire and electrical codes.
 - A Resource section that includes a complete list of all WISHA rules and a directory of the Labor and Industries (L&I) offices.
- Other WISHA rules may apply to you, depending on the activities and operations of your workplace. Contact your local L&I office if you're uncertain about which WISHA requirements apply to you.
- To go online to access all the Safety and Health Rules: <http://www.lni.wa.gov/wisha>
- If you would like to receive e-mail notification of rule updates, please register for the Standards Listserv on the WISHA web site at <http://www.lni.wa.gov/home/listservs.htm>
- For a CD or paper copy contact us by:

Mail: Department of Labor and Industries
P.O. Box 44620
Olympia, WA 98504-4620

Telephone: 1-800-4BE-SAFE (1-800-423-7233)

<http://www.lni.wa.gov/>

Abrasive Blasting

Chapter 296-818 WAC

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Abrasive Blasting

Chapter 296-818 WAC

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Abrasive Blasting

Chapter 296-818 WAC

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Abrasive Blasting

WAC 296-818-100

Scope

This chapter applies to all abrasive blasting operations where an abrasive is forcibly applied to a surface using any of the following:

- Pneumatic pressure
- Hydraulic pressure
- Centrifugal force



References:

Depending on your work processes, here are examples of other chapters you may need:

- Safety and Health Core Rules, Chapter 296-800 WAC
- Machine Safety, Chapter 296-806 WAC
- Respiratory Hazards, Chapter 296-841 WAC
- Respirators, Chapter 296-842 WAC
- Scaffolds, Chapter 296-874 WAC
- Cadmium, Chapter 296-62 WAC
- Part L, Electrical, Chapter 296-24 WAC



General Safety

WAC 296-818-200

Section Contents

YOUR RESPONSIBILITY:

To protect employees from hazards associated with their work environment

Dust hazards WAC 296-818-20005	200-2
Personal protective equipment (PPE) WAC 296-818-20010	200-3
Housekeeping WAC 296-818-20015	200-6



General Safety

WAC 296-818-200

Rule

WAC 296-818-20005

Dust hazards

IMPORTANT:

- Abrasives and the surface coatings on materials blasted are shattered and pulverized during blasting operations. The dust formed will contain particles that could result in the following hazards:
 - Respiratory
 - Fire
 - Explosion
- Wet blasting methods minimize dust exposure, but dispersed droplets, mists, and dried residues may become airborne and create potential exposures.

You must

- Evaluate the potential health hazards from abrasive blasting operations by considering the composition and toxicity of the abrasive material and the surface being abraded.



References:

- For additional hazard assessment requirements, go to these separate chapters:
 - Respirators, Chapter 296-842 WAC
 - The Safety and Health Core Rules, Chapter 296-800 WAC
 - Personal Protective Equipment, WAC 296-800-16005.
- For requirements on the use of combustible organic abrasive, go to WAC 296-818-30005.

-Continued-



WAC 296-818-20005

Dust hazards (continued)

You must

- Keep dust concentrations below the permissible exposure limits found in a separate chapter, Respiratory Hazards, Chapter 296-841 WAC.



Note:

When sampling for dust concentrations, place the sample collection device:

- In the breathing zone of the operator
- and**
- Outside the respiratory protection worn



Helpful tools:

Sampling for Airborne Contaminant Concentrations

Links you can use to find information on sampling airborne contaminant concentrations in the breathing zone can be found in the Resource section of this chapter

Types of Abrasives used in Blasting Operations

For information on the types of abrasives used in blasting operations, see the Resource section of this chapter

Types of Coatings Removed in Blasting Operations

For information on the types of coatings removed in abrasive blasting, see the Resource section of this chapter.

WAC 296-818-20010

Personal protective equipment (PPE)

You must

- Provide, at no cost to the employee, and make sure personal protective equipment is worn.
- Follow the requirements in Table-1, Personal Protective Equipment (PPE).

-Continued-



General Safety

WAC 296-818-200

Rule

WAC 296-818-20010

Personal protective equipment (PPE) (continued)

**Table 1
Personal Protective Equipment (PPE)**

Provide	When
Abrasive Blasting Respirators	<p>Operators work in any of the following situations:</p> <ul style="list-style-type: none"> – Inside blast cleaning rooms – Where silica sand is used in manual blasting operations – Where concentrations of toxic dust exceed the permissible exposure limits found in a separate chapter: <ul style="list-style-type: none"> • Respiratory Hazards, WAC 296-841-20020, Table-3 “Exposure Limits for Air Contaminants” <p>Exemption: An abrasive respirator doesn’t need to be worn if the operator is physically separated from the nozzle and blast by an exhaust ventilated enclosure.</p> <p>Definition: Abrasive-blasting respirator A supplied air or a continuous flow respirator constructed to cover and protect the operator’s head, neck and shoulders from rebounding abrasive.</p>
<p>Eye and Face protection to both of the following:</p> <ul style="list-style-type: none"> – Blasting operators – Personnel working near blasting operations 	Respirators worn during blasting operations don’t provide eye and face protection
<p>Gloves and Aprons made of heavy canvas or leather; or Equivalent protection</p>	Operators are exposed to the impact of rebounding abrasives

-Continued-



WAC 296-818-20010

Personal protective equipment (PPE) (continued)



Notes:

- Use only respirators certified by NIOSH in 42 C.F.R. Part 84 for protecting employees from dusts, and other hazards produced during abrasive blasting operations, like:
 - Using a garnet sand to blast a concrete surface, resulting in crystalline silica dust
 - A filtering face piece may be used only for short, intermittent, or occasional dust exposures for any of the following tasks:
 - To protect the operator during abrasive blasting operations performed outside the enclosure or outdoors where nonsilica abrasives are used on materials with low toxicity
 - Clean-up
 - Dumping dust collectors
 - Unloading shipments of sand at receiving areas when the following controls aren't feasible:
 - Enclosures
 - Exhaust ventilation
- or**
- Other means



Reference:

- For additional requirements to help you fully protect employees, go to the following separate chapters:
- The Safety and Health Core Rules, Chapter 296-800 WAC:
 - Personal Protective Equipment (PPE), WAC 296-800-160
 - Respiratory Hazards, Chapter 296-841 WAC
 - Respirators, Chapter 296-842 WAC:
 - Respirator program, WAC 296-842-120
 - Specifications for air quality, WAC 296-842-200



General Safety

WAC 296-818-200

Rule

WAC 296-818-20015

Housekeeping

You must

- Keep aisles and walkways clear of steel shot or similar abrasives that may create a slipping hazard.
- Prohibit the accumulation of dust on the floors or ledges outside blasting enclosures.
- Clean up dust spills promptly.



Note:

Removal of accumulated dust should be done:

- With a high efficiency particulate air filter (HEPA), vacuum cleaner when the plant isn't in operation;
- **and**
- By a person wearing a respirator approved for the existing conditions



Reference:

For additional housekeeping requirements, see the Safety and Health Core Rules, Chapter 296-800 WAC, Housekeeping, WAC 296-800-220.



Operations

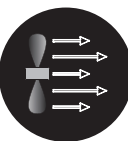
WAC 296-818-300

Section Contents

YOUR RESPONSIBILITY:

To follow these operational requirements

Combustible organic abrasives WAC 296-818-30005	300-2
Blast cleaning enclosures WAC 296-818-30010	300-3
Blast cleaning nozzles WAC 296-818-30015	300-5



Operations

WAC 296-818-300

Rule

WAC 296-818-30005

Combustible organic abrasive

IMPORTANT:

This section applies to blasting operations where flammable or explosive dust mixtures may be present.

You must

- Prohibit the use of combustible organic abrasives, except in automatic blast cleaning systems.
- Bond and ground the blast nozzle to prevent the buildup of static charges.



Note:

Fine dust produced from combustible, organic abrasive is a fire and explosion hazard.



WAC 296-818-30010

Blast cleaning enclosures

You must

- Install adequate ventilation systems in blast cleaning enclosures that are able to do all of the following:
 - Control concentrations of airborne contaminants below the permissible exposure limits that apply
 - Provide a continuous inward flow of air at all openings in the enclosure during blasting operations
 - Minimize the escape of dust into adjacent work areas
 - Maintain visibility in blast cleaning rooms and cabinets
 - Rapidly clear dust from the air after blasting stops
 - Discharge exhaust so contaminated air doesn't do either of the following:
 - Present a health hazard to any worker
 - or**
 - Reenter buildings in harmful amounts
- Make sure ventilation systems are designed and operated so employees aren't exposed to excessive air velocities
- Make sure make-up air systems don't interfere with the effectiveness of the exhaust system, and are designed to do both of the following:
 - Replace exhausted air in ample quantities
 - Temper make-up (supply) air when necessary
- Do both of the following before opening the blast cleaning enclosure:
 - Turn the blast off
 - Run the exhaust system for a sufficient period of time to clear the air of dust particles
- Follow the requirements in Table-2, Blast Cleaning Enclosures.

-Continued-



Operations

WAC 296-818-300

Rule

WAC 296-818-30010

Blast cleaning enclosures (continued)

Table 2
Blast Cleaning Enclosures

If you have	Then make sure
Air inlets and access openings	They are either baffled or arranged so the combination of inward airflow and baffles minimizes both of the following: <ul style="list-style-type: none">- The escape of abrasive or dust particles into adjacent work areas.- Visible spurts of dust
Small access openings where dust might escape	Slit resistant baffles are installed in multiple sets at all small access openings, and do both of the following: <ul style="list-style-type: none">- Regularly inspect them- Replace them when needed
An observation window in enclosures where hard, deep cutting abrasives are used	The window is made of safety glass protected by screening Notes: <ul style="list-style-type: none">- Hard, deep cutting abrasives may shatter normal glass.- If the safety glass shatters, the protective screening will help contain the glass and protect employees from cuts and lacerations.
Small operator access doors	They are flanged and tight when closed, and open from both inside and outside the enclosure. Note: If you have a small operator access door and a large work access door, the large work access door may open or close from the outside only.



Helpful tool:

Blast Cleaning Enclosures and Recommended Air Velocities

For information on types of blast cleaning enclosures and recommended air velocities, see the Resources section of this chapter.

-Continued-



WAC 296-818-30010

Blast cleaning enclosures (continued)



References:

For more information on:

- Air velocities, refer to the following:
 - The latest edition of Recommended Industrial Ventilation Guidelines (ACGIH)
 - NIOSH 1976 Industrial Ventilation
- Exit routes, go to the Safety and Health Core Rules, WAC 296-800-310.

WAC 296-818-30015

Blast cleaning nozzles

You must

- Make sure nozzles are all of the following:
 - Mounted on a support when not in use
 - Equipped with operating valves that are manually held open.



Note:

To help prevent the buildup of static charges, pressurized tanks used to supply abrasive should be:

- Connected to the manual control of the nozzle
- and**
- Have the relief valve or opening located so it can safely vent.



Exhaust Ventilation Systems

WAC 286-818-400

Section Contents

YOUR RESPONSIBILITY:

To make sure exhaust ventilation systems meet these requirements

Construction WAC 296-818-40005	400-2
Explosion venting and wiring WAC 296-818-40010	400-3
Inspection and maintenance WAC 296-818-40015	400-4



Exhaust Ventilation Systems

WAC 296-818-400

Rule

WAC 296-818-40005

Construction

You must

- Make sure exhaust systems are constructed, installed, inspected, and maintained to meet both of the following:
 - The American National Standards Institute (ANSI), Z9.2-2001 for:
 - Fundamentals Governing the Design and Operation of Local Exhaust Systems
 - The National Fire Protection Association (NFPA) 91-2004 for:
 - Exhaust Systems for Air Conveying of Vapors, Gases and Noncombustible Particulate Solids.



Reference:

- Refer to the American National Standards Institute, ANSI Z9.4-1997 for information on the following:
 - Exhaust Systems for Abrasive-blasting Operations, Ventilation, and Safe Practices for Fixed Location Enclosures.



Exhaust Ventilation Systems

WAC 296-818-400

Rule

WAC 296-818-40010

Explosion venting and wiring

You must

- Follow the requirements in Table-3 for flammable or combustible dust mixtures.

Table 3
Explosion Venting and Wiring

If you have	Then
Flammable or explosive dust mixtures that may be present	<p>Make sure the construction of equipment, including the exhaust system and all electrical wiring, meets both of the following</p> <ul style="list-style-type: none">– The American National Standard Installation (ANSI) of Blower and Exhaust Systems for Dust, Stock, and Vapor Removal or Conveying, NFPA 91. 2004.– The electrical requirements for Class II locations in WAC 296-24-95613, located in Part L of chapter 296-24 WAC. <p>Make sure blast cleaning enclosures, the ducts, and the dust collector are constructed with either loose panels or explosion venting areas that meet all of the following:</p> <ul style="list-style-type: none">– Provides pressure relief in case of an explosion.– Are located away from occupied areas.– The Guide for Deflagations, NFPA 68. 2002.



Exhaust Ventilation Systems

WAC 296-818-400

Rule

WAC 296-818-40015

Inspection and maintenance

You must

- Make sure the exhaust ventilation system is fully operational by checking the static pressure drop at the exhaust ducts leading from the equipment at both of the following times:
 - When installation is completed
 - Annually after installation.
- Repair or clean exhaust systems when either of the following occur:
 - Dust leaks are found
 - or**
 - The pressure drop gauge indicates a change exceeding 20 percent.
- Use an abrasive separator to separate larger particles for reuse on installations where abrasive is recirculated.
- Set up dust collecting equipment to do both of the following:
 - Empty and remove accumulated dust without contaminating work areas
 - Discharge the air used in blast cleaning equipment.



Note:

Dispose fine dust from dry collectors by doing one of the following:

- Emptying and transporting the fine dust in enclosed containers
- Using a sluice with a wetting process to contain the dust.



Abrasive Blasting

WAC 296-818-500

Definitions

Abrasive

A solid granular substance used in abrasive blasting operations.

Abrasive blasting

The forcible application of an abrasive to a surface using either:

- Pneumatic or hydraulic pressure

or

- Centrifugal force

Abrasive-blasting respirator

A supplied air or a continuous flow respirator constructed with a shroud that covers and protects the head, neck, and shoulders.

Automatic blast cleaning systems

A unit that has a blast cleaning chamber which usually has both of the following to provide a timed cleaning cycle:

- An automatic timer

and

- An automatic shutoff control

Baffles

Partial enclosures in and around the emission sources which improve or enhance airflow at the hood.

Blast cleaning barrel

A complete enclosure that rotates on an axis or an internal tread to tumble parts in order to expose various surfaces of the parts to an automatic blast spray.

Blast cleaning room

An enclosed room where blasting operations are performed by an operator who works from inside the room using a blasting nozzle to direct the flow of abrasive material.



Abrasive Blasting

WAC 296-818-500

Definitions

Blasting cabinet

An enclosure where the operator stands outside using a blasting nozzle through an opening, or openings in the enclosure.

Dust collector

A device in an exhaust ventilation system used to remove dust from air.

Exhaust ventilation system

A system that removes contaminated air using the following:

- Enclosure or hood
- Duct work
- Dust collecting equipment
- Exhauster
- Discharge stack

Local exhaust ventilation

The mechanical removal of contaminated air from the point where the contaminant is being generated or liberated.

Make-up air systems

A ventilation system that controls the volume of outdoor air supplied to a building to replace air being exhausted.

Rotary blast cleaning table

An enclosure where the pieces to be cleaned are placed on a rotating table and passed automatically through a series of blast sprays.

Tempered make-up air

Air which has been conditioned by changing its heat content to get a specific desired temperature.

Ventilation

The provision, circulation or exhausting of air into or from an area or space.



Abrasive Blasting Rule

Chapter 296-826 WAC

Resources

Helpful Tools

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Notes

Sampling for Airborne Contaminant Concentrations (Links)

Use with the Abrasive Blasting Rule, Chapter 296-818 WAC

Use the following links for information on sampling airborne contaminant concentrations in the breathing zone:

- Personal Sampling for Air Contaminants:
 - http://www.osha.gov/dts/osta/otm/otm_ii/otm_ii_1.html#1
- Index of Sampling and Analytical Methods
 - <http://www.osha.gov/dts/sltc/methods/toc.html>
 - <http://www.osha.gov/SLTC/samplinganalysis/index.html>
- Sampling and Analytical Methods
 - <http://www.osha.gov/dts/sltc/methods/index.html>
 - <http://www.osha.gov/SLTC/samplinganalysis/index.html>



Types of Abrasives used for Blasting Operations

Use with the Abrasive Blasting Rule, Chapter 296-818 WAC

This helpful tool outlines the types and examples of abrasives used for blasting operations.

Types of Abrasive	Examples of Abrasives	Other Information
Synthetic or natural mineral grains	<ul style="list-style-type: none"> – Crystalline Silica – Garnet 	<p>Silica sand is the most hazardous. Limit the use of silica sand wherever possible.</p> <p>Link: For types of abrasive used in place of silica go to the Occupational Safety and Health Administration's (OSHA), homepage at: http://www.osha.gov/. Select 'S' for Silica.</p>
Slag abrasive	<ul style="list-style-type: none"> – Copper slag – Nickel slag – Mixed metal slag 	May contain heavy metals.
Metallic shot or grit	<ul style="list-style-type: none"> – Steel – Chilled cast iron 	The potential hazard is considered minimal.
Organic	<ul style="list-style-type: none"> – Ground corncobs – Ground walnut shells 	Readily combustible organic abrasives can form explosive mixtures with air.

Types of Coatings Removed in Blasting Operations

Use with the Abrasive Blasting Rule, Chapter 296-818 WAC

This helpful tool outlines the types and examples of coatings removed during blasting operations.

Types of Coatings	Examples of Coatings	Other Information
<p>Surface</p> <ul style="list-style-type: none">- Formed during the fabrication of a part <p>Protective</p> <ul style="list-style-type: none">- Applied after fabrication	<p>Those containing toxic metals:</p> <ul style="list-style-type: none">- Paints containing mercury- Cadmium plating- Lead:<ul style="list-style-type: none">▪ Paints on structural steel▪ Deposits on pistons of internal combustible engines <p>Plastic or resin:</p> <ul style="list-style-type: none">- May decompose and produce irritating by-products during blasting operations	<p>The type of coating should be known to evaluate potential hazards.</p>





Blast Cleaning Enclosures and Recommended Inward Air Velocities

Use with the Abrasive Blasting Rule, Chapter 296-818 WAC

This helpful tool provides examples of blast cleaning enclosures and the recommended air velocities used for abrasive blasting operations.

Examples of Blast Cleaning Enclosures	Recommended Air Velocities in Feet Per Minute (fpm)
Abrasive blasting cabinets	At least 500 fpm at the hand openings
Blast cleaning rooms	At least 300 fpm with well baffled air inlets
Rotary blast cleaning tables	200-250 fpm at the access opening
Abrasive separators Bucket elevators Other accessory abrasive handling equipment, including blast cleaning drums and barrels	200-250 fpm at all openings

Abrasive Blasting

Chapter 296-818 WAC

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Statutory Authority

296-818-100 Scope.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-100, filed 06/06/06, effective 09/01/06]

296-818-200 General safety.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-200, filed 06/06/06, effective 09/01/06]

296-818-20005 Dust hazards.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-20005, filed 06/06/06, effective 09/01/06]

296-818-20010 Personal protective equipment (PPE).

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 09-05-071 (Order 08-35), § 296-818-20010, filed 02/17/09, effective 04/01/09] [Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-20010, filed 06/06/06, effective 09/01/06]

296-818-20015 Housekeeping.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-20015, filed 06/06/06, effective 09/01/06]

296-818-300 Operations.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-300, filed 06/06/06, effective 09/01/06]

296-818-30005 Combustible organic abrasive.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-30005, filed 06/06/06, effective 09/01/06]

296-818-30010 Blasting cleaning enclosures.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-30010, filed 06/06/06, effective 09/01/06]

296-818-30015 Blast cleaning nozzles.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-30015, filed 06/06/06, effective 09/01/06]

296-818-400 Exhaust ventilation systems.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-400, filed 06/06/06, effective 09/01/06]

296-818-40005 Construction.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-40005, filed 06/06/06, effective 09/01/06]

296-818-40010 Explosion venting and wiring.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-40010, filed 06/06/06, effective 09/01/06]

296-818-40015 Inspection and maintenance.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-40015, filed 06/06/06, effective 09/01/06]

296-818-500 Definitions.

[Statutory Authority: RCW 49.17.010, .040, .050, and .060. 06-12-074 (Order 06-05), § 296-818-500, filed 06/06/06, effective 09/01/06]

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