



# MARCO HIGH CARBON STEEL SHOT

<b>Chemical Composition</b>	Carbon .....	0.70-1.20%	Phosphorus.....	<0.05%
	Silicon.....	0.15-1.20%	Copper .....	0.040%
	Manganese.....	0.20-1.20%	Nickel .....	0.030%
	Sulfur .....	<0.05%	Chromium .....	0.60-1.60%
	Molybdenum.....	0.012%	Iron .....	balance

**Sizing**

SAE Size	Opening		Percent (%) by Weight										
	mm	inches	S780	S660	S550	S460	S390	S330	S280	S230	S170	S110	S70
7	2.80	0.1110	All Pass										
8	2.36	0.0937		All Pass									
10	2.00	0.0787	85% Min		All Pass	All Pass							
12	1.70	0.0661	97% Min	85% Min		5% Max	All Pass						
14	1.40	0.0555		97% Min	85% Min		5% Max	All Pass					
16	1.18	0.0469			97% Min	85% Min		5% Max	All Pass				
18	1.00	0.0394				96% Min	85% Min		5% Max	All Pass			
20	0.850	0.0331					96% Min	85% Min		10% Max	All Pass		
25	0.710	0.0278						96% Min	85% Min		10% Max		
30	0.600	0.0234							96% Min	85% Min		All Pass	
35	0.500	0.0197								97% Min		10% Max	
40	0.425	0.0165									85% Min		All Pass
45	0.550	0.0139									97% Min		10% Max
50	0.300	0.0117										80% Min	
80	0.180	0.0070										90% Min	80% Min
120	0.125	0.0049											90% Min

\*Screen Opening Sizes and Screen Numbers with Max and Min Cumulative Percentages Allowed on Corresponding Screens. ASTM E-11 and ISO 55 Test Sieves.

<b>Physical Characteristics</b>	<b>Shape:</b>	Round	<b>Specific Gravity:</b>	4.8 g/cc
	<b>Hardness (Rockwell C):</b>	40–51 HRC	<b>Total Chlorides:</b>	No Chlorides
	<b>Bulk Density:</b>	289–298 lbs./cu. ft.	<b>Free Silica:</b>	No Free Silica

<b>Other Characteristics</b>	<b>Reactivity:</b>	Inert	<b>Reactivity:</b>	Not Reactive
	<b>Solubility in Water:</b>	Not Soluble	<b>Melting Point:</b>	1371-1482° C
	<b>Odor:</b>	Odorless	<b>Appearance:</b>	Grey Solid

**Certifications**  
 SAE J444 (Sizing)  
 SAE J827 (Hardness, Microstructure, Density)

**Testing Method**      ASTM E1024, ASTM E1019, ICP



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**▲ WARNING** Breathing dust containing silica could cause silicosis, a fatal lung disease. Breathing dust during abrasive blasting operations, post-blast cleaning operations, and/or servicing equipment within the abrasive blasting area may expose an individual to conditions that could cause asbestosis, lead poisoning and/or other serious or fatal diseases. Harmful dust containing toxic material from abrasives or surfaces being abrasive blasted can remain suspended in the air for long periods of time after abrasive blasting has ceased. A NIOSH-approved, well-maintained, respirator designed for the specific operation being performed must be used by anyone abrasive blasting, handling or using the abrasive, and anyone in the area of the dust. Failure to comply with the above warning could result in death or serious injury.

**▲ WARNING** You must comply with all OSHA, local, City, State, Province, Country and jurisdiction regulations, ordinances and standards, related to your particular work area and environment. Keep unprotected individuals out of the work area. Failure to comply with the above warning could result in death or serious injury.

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This document not intended to replace material Safety Data Sheet 608M306.

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