

# B. W. SINCLAIR, INC.

BULK MATERIAL HANDLING

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## WELD FINISH CLASSIFICATIONS

BWSI Class	DESCRIPTION	CEMA	RMS	Micro Inch
SIN-0	Weld splatter and slag removed. NO grinding	I		
SIN-1	Welds ground with 24-grit rock to "knock down" high spots. Cracks and crevices still present.			
SIN-2	Welds ground "smoother," with weld ripple and unusual roughness removed. Cracks and crevices still present. 24-grit.			
SIN-3	Same as above, but 40 grit profiles. Cracks and crevices still present.	II		
SIN-4	Medium grind welds to 60-grit. The lowest of the "food grade" designations.		98	87
SIN-5	Same as above, 80-grit. Some cracks and crevices still present.	III	80	71
SIN-6	Same as above, 100-grit. Some cracks and crevices still present.		69	62
SIN-7	120-140 grit finish. No cracks or crevices.	IV	46	52
SIN-8	150-180 grit finish. All pits removed. Food grade or sanitary to both weld deposit and parent metal.	V	35	30

### Notes:

1. Weld finishes normally apply only to internal, product contact surfaces.
2. SIN-3 and above require a minimum of 10 Ga. (.1345") material thickness.
3. Stainless steel plate 3/16" and thicker normally comes with a "No. 1 Mill Finish" of approximately 160 RMS.
4. Stainless steel sheet up to 7 Ga. (.1874") comes with a 2D (dull) or 2B (bright) finish, correlating to approx. 80 grit.
5. BWSI weld finishes are progressive and are only possible by beginning with a coarse grinding rock and moving to finer materials. It is not possible, for example, to achieve a 120-grit finish by starting with a 120-grit wheel. Therefore the progression of surface smoothness means a proportional increase in the number of man-hours involved, and the cost of the finished product.
6. *Finer finishes may be available, depending upon the application and the project budget.*