

 BHARAT HEAVY ELECTRICALS LIMITED PIPING CENTRE, CHENNAI- 17 QUALITY ASSURANCE & CONTROL DEPT.			PAINTING SCHEME FOR LOW PRESSURE PIPING (CW / ACW / ECW / Plant water, Air Piping, etc...,) PROJECT NAME : - BIFPCL MAITREE STPP - 2X660 MW BHEL CUSTOMER Nos : 7328, 7329, 7330, 7331.								QPNo: 7328:QPC:12 REV.NO: 02 Dt : 30.04.2018	
Sl. NO	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat			Finish coat			Total DFT Microns (Min.)	REMARKS
			Primer	No of coats	Paint	No of coats	Shade	Paint	No of coats	Shade		
1	2	3	4	5	6	7	8	9	10	11	12	13
1	(a) Internal Surface - CW Pipe (for pipe dia - 350 mm to 1200mm)	Blast Cleaning SSPC SP-10 / SA 2½	Rubber lining								5000 Microns / 5mm (Refer Note 3)	
	(b) Holiday test (Refer Note 3)	Holiday test @ 5KV/mm. Holiday test Equipment to be calibrated before testing.										
2	(a) Internal Surface - CW Pipe (for pipe dia - 1200 mm and above)	Blast Cleaning SSPC SP-10 / SA 2½	POLY - URETHANE COATING OF 2000 MICRONS DRY FILM THICKNESS . (Refer Note 2)								2000 Microns (Refer Note 3)	
	(b) Holiday test (Refer Note 3)	Holiday testing as per AWWA C222 and Paint Manufacturer recommendation. Holiday test Equipment to be calibrated before testing.										
3	External Surface of CW --Buried Piping / Encased in concrete (For pipe dia- 1000 mm and above) (Temporary Protection for transportation from works to site). **Further protection to be done by BHEL Erection Group as per Contract requirement.	Blast Cleaning SSPC SP-10 / SA 2½	Epoxy Zinc Phosphate	1 (40 Microns per coat)	-----	-----	-----	-----	-----	-----	40 Microns	
4	External Surface (over ground piping) of CW,ACW.(For all diameters)	Blast Cleaning SSPC SP-10 / SA 2½	Epoxy Polyamide resin based Zinc Phosphate Primer	2 (35 microns per coat)	Epoxy resin with MIO	1 (75 microns per coat.)	-----	Epoxy Polyamide finish Paint	1 \$ (40 microns per coat)	Smoke Grey Shade No 692 of IS 5 (Refer Note-4)	145 at shop + 40 at site	\$: 1 coat of DFT-40 microns finish coat at site
5	External Surface of ECW, Plant water (For all diameters)	Blast Cleaning SSPC SP-10 / SA 2½	Epoxy Polyamide resin based Zinc Phosphate Primer	2 (35 microns per coat)	Epoxy resin with MIO	1 (75 microns per coat.)	-----	Epoxy Polyamide finish Paint	1 \$ (40 microns per coat)	Smoke Grey Shade No 692 of IS 5 (Refer Note-4)	145 at shop + 40 at site	\$: 1 coat of DFT-40 microns finish coat at site
6	Galvanised and Stainless steel Piping	No painting										
Notes: 1. Blast cleaning to near white metal to obtain roughness as per epoxy paint data sheet. 2. Application of Poly-Urethane coating shall be done as per manufacturer's data sheet / recommendation, meeting the thickness requirements as per this document. 3. Witness by BHEL / BHEL nominated inspection agency. 4. Shade for finish coat to be done at site shall be as per project specification/contract requirement.												
			For BIFPCL use :		DOC. NO.: Maitree-00-CF-QA-732812-PC-00 REV..... CAT.....						Page 1/1	
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								ENGG.DIV./QA&I				