Corrigendum - 2 dated 28/03/2025 to CPC Tender No. BHEL/CPC/SGL/MPH-STR/25/088

Corrigendum - 2 to CPC Tender No. BHEL/CPC/SGL/MPH-STR/25/088 for the work of " Package-A: Erection, Alignment, Bolting/Welding, Roofing & Cladding, BOIs Work including handling of materials at BHEL / Client's Stores / Storage yard and Transportation and Scope of work includes supply of all Material (As per TCC and BOQ), Consumables, labour, tools and plants, Touch-up painting as and where required (including supply of paints) for Unit-1 Main Power House structure & BOIs as per BOQ at 2X800 MW NTPC Singrauli STPP Stage-III, Sonebhadra, UP

Package-B: Erection, Alignment, Bolting/Welding, Roofing & Cladding, BOIs Work including handling of materials at BHEL / Client's Stores / Storage yard and Transportation and Scope of work includes supply of all Material (As per TCC and BOQ), Consumables, labour, tools and plants, Touch-up painting as and where required (including supply of paints) for Unit-2 Main Power House structure, CCR (Common control room) and BOIs as per BOQ at 2X800 MW NTPC Singrauli STPP Stage-III, Sonebhadra, UP."

A) The clarifications on bidder's queries issued by BHEL are as below:

S.No	Tender Clause	Tender condition	Bidder's queries	BHEL Clarification
1	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. 2307	Transportation,erection and alignment, fabrication where required of factory made electroforged galvanised grating units with mild steel having minimum galvanisation conforming to IS:2062 in flooring, platforms, drain and trench covers, walkways, passages, staircases with edge binding strips and anti-skid nosing in treads etc. including fixing clamps, fittings, fixtures, **all taxes, duties**, packing, grinding, drilling, welding, edge preparation, etc. all complete. **Whereas TCC Cl. 8.2.1 stipulates that quoted rates shall be exclusive of GST.**	Kindly review the BOQ item inline with TCC Cl. No. 8.2.1 and revise the item description accordingly.	**Bidder's price/rates for erection items (supply under BHEL scope) and supply+fixing items, shall be exclusive of GST.**
2	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. 2308	Transportation,erection and alignment, fabrication where required of factory made galvanised welded grating units(minimum 610 g/sqm galvanisation) with mild steel conforming to IS:2062 in flooring, platforms, drain and trench covers, walk-ways, passages, staircases with edge binding strips and anti-skid nosing in treads etc. fixing clamps, fittings, fixtures, **all taxes, duties**, packing, grinding, drilling, welding, edge preparation, etc. all complete. **Whereas TCC Cl. 8.2.1 stipulates that quoted rates shall be exclusive of GST.**		
3	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. 2320	Fabrication and fixing of stainless steel pipe hand railing conforming to SS 409 of 32 mm/40 mm dia including transportation, loading/unloading, painting etc. all complete.	1) We understood that our scope of work is Fixing of handrails only, and we will receive shop fabricated handrails. However minor fabrication work will be on our scope. Kindly confirm. 2) For Painting work on SS Handrail, we request you kindly provide us Painting Specification.	**1) Pipe, bend, post, Toe guard etc. shall be supplied by BHEL for free issue to contractor** **2) Please refer customer/NTPC specifications attached with this corrigendum-2.**

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S.No	Tender Clause	Tender condition	Bidder's queries	BHEL Clarification
4	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. A2322	Fabrication and fixing of galvanised MS pipe hand railing (Min. 1000 mm high) of 32mm/40mm/50mm dia (Medium Class) including transportation, loading/unloading, painting etc. all complete	1. We understood that our scope of work is Fixing of handrails only, and we will receive shop fabricated handrails. However minor fabrication work will be on our scope. Kindly confirm. 2. For Painting work on SS Handrail, we request you kindly provide us Painting Specification..	**1. Pipe, bend, post, Toe guard etc. shall be supplied by BHEL for free issue to contractor** **2. Please refer customer / NTPC specifications attached with this corrigendum-2.**
5	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. A1502	METAL DECK SHEET Type-I, Fixing permanently color coated galvanised MS troughed metal sheet decking plate (including preparing erection drawings showing cut outs, fixing details, overlaps of sheets etc. and getting it approved from BHEL) of approved colour over roof purlins for cast-in-situ roof slab as per relevant IS code and Grade as per specification. Bare metal thickness(BMT) of deck plate shall be minimum 0.8mm with minimum trough depth of 44mm (or as per design whiever is higher) of grade G250 as per AS1397/grade SS255 as per ASTM A653M/ grade S250GD as per EN 10326 with zinc coating to class Z275 and shall serve as permanent shuttering to the roof slab 40mm -100mm thick measured over crest of metal decking & shall have adequate strength to support weight of green concrete and imposed loads of min 100 kg/sqm (for two span condition) during construction between beams as per manufacturer's recommendations/ calculations/ test certificates for approval including fixing of plates to beams, side lapping, end lapping etc. all complete for below mentioned spans. The sheet shall be permanently coated with silicon modified polyster(SMP silicon content 30%-50%) paint or super polyster paint of minimum 20 micron DFT on exposed surface (facing operating floor) over primer coat of minimum 5 micron(nominal) and minum 10 micron (nominal) SMP or super polyester paint over primer coat of minum 5 micron (nominal) on other face. SMP and polyster paint system sahll be of idutrial finish of product type 4 of AS/NZ2728, including fixing of sheet to top flange of beam with drawn arc welding of headed shear anchor studs @ 260mm c/c in the trough and stich screws between two adjacent sheets and sealing with epoxy sealant.The shear anchor studs shall confirm to type B studs specified in AWS D1.1/D1.1M or equivalent as shear connector of 16 mm dia & 65 mm length manufactured from cold drawn round steel bars confirming to ASTM A 29 of grade designation 1010 through 1020 of standard quality with either semi killed or killed welded by drawn arc stud welding through metal deck sheet. (Metal Deck Sheet shall be issued by BHEL free of cost)	We Presume that we will receive SMP coated sheet and our scope is fixing of sheets. Any type of coating work is not in scope of bidder. Kindly confirm.	**SMP coating work is not in scope of bidder**

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S.No	Tender Clause	Tender condition	Bidder's queries	BHEL Clarification
6	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. B1502	METAL DECK SHEET Type-II, Fixing permanently color coated galvanised MS troughed metal sheet decking plate (including preparing erection drawings showing cut outs, fixing details, overlaps of sheets etc. and getting it approved from BHEL) of approved colour over roof purlins for cast-in-situ roof slab as per relevant IS code and Grade as per specification. Bare metal thickness(BMT) of deck plate shall be minimum 0.8mm with minimum trough depth of 44 mm (or as per design whiever is higher) of grade G250 as per AS1397/grade SS255 as per ASTM A653M/ grade S250GD as per EN 10326 with zinc coating to class Z275 and shall serve as permanent shuttering to the floor slab 150 mm thick measured over crest of metal decking & shall have adequate strength to support weight of green concrete and imposed loads of min 100 kg/sqm (for two span condition) during construction between beams as per manufacturer's recommendations/ calculations/ test certificates for approval including fixing of plates to beams, side lapping, end lapping etc. all complete for below mentioned spans. The sheet shall be permanently coated with silicon modified polyster(SMP silicon content 30%-50%) paint or super polyster paint of minimum 20 micron DFT on exposed surface (facing operating floor) over primer coat of minimum 5 micron(nominal) and minum 10 micron (nominal) SMP or super polyester paint over primer coat of minum 5 micron (nominal) on other face. SMP and polyster paint system sahll be of idutrial finish of product type 4 of AS/NZ2728, including fixing of sheet to top flange of beam with drawn arc welding of headed shear anchor studs @ 260mm c/c in the trough and stich screws between two adjacent sheets and sealing with epoxy sealant.The shear anchor studs shall confirm to type B studs specified in AWS D1.1/D1.1M or equivalent as shear connector of 19 mm dia & 100 mm length manufactured from cold drawn round steel bars confirming to ASTM A 29 of grade designation 1010 through 1020 of standard quality with either semi killed or killed welded by drawn arc stud welding through metal deck sheet. (Metal Deck Sheet shall be issued by BHEL free of cost)	We Presume that we will receive SMP coated sheet and our scope is fixing of sheets. Any type of coating work is not in scope of bidder. Kindly confirm.	**SMP coating work is not in scope of bidder.**
7	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. A904	Providing and fixing single or double steel door shutters with 35mm (min) thk flush design shutter comprising of two outer sheets of 18 gauge steel sheets rigidly connected and reinforced inside with continuous vertical 20 gauge stiffeners, spot welded in position at not more than 150mm on centres including void filled with mineral wool (density as per specification), all fittings, Godrej or equivalent make mortice lock with handle on both sides, shop and final painting etc all complete.	We request to kindly provide the details / drawings for the BOQ line item along with sizes of Door shutters for enabling us to estimate rate for the line item.	**Refer BOQ quantity. Drawings shall be issued progressively during execution.**

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S.No	Tender Clause	Tender condition	Bidder's queries	BHEL Clarification
8	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. A913	Providing and fixing in position rolling shutter of hot rolled double dipped galvanised steel lath section of 18 SWG tested mild steel strips at 75mm rolling centres interlocked together through their entire length and jointed together at the end by end locks mounted on specially designed pipe shaft with brackets, side guides of 75mm wide and 3mm thick(min.) and arrangements for inside and outside locking with push and pull operation including wire springs, top/hood cover 0.9mm thick (min.) , factory galvanized, primed & field painted, partly grilled (as required) with approved enamel paint etc, all complete as per IS 6248 and specification of approved make of following types: The bottom lath shall be coupled to a lock plate fabricated from 3mm thick galvanised steel plate and securely rivetted with stiffening angles.(partly coiled and lath/full lath).	We request to kindly provide the details / drawings for the BOQ line item along with sizes of rolling shutters for enabling us to estimate rate for the line item.	**Refer BOQ. Tender Condition shall prevail.**
9	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. A2318	Providing and fixing in position PTFE type sliding bearings of reputed manufacturer for required vertical load and end displacement/rotation as per approved construction draiwngs. PTFE bearing shall be sliding against highly polished stainless steel and the coefficient of friction between them shall be less than 0.06 at 55 kg/sq.cm. In order to prevent cold flow in PTFE surface it shall be rigidly bonded by a special high temperature resistance adhesive to the stainless steel substrata. The stainless steel surface that slides against the PTFE is mirror polished. The stainless steel shall be bonded to the top plate by special high strength adhesive. The thickness of stainless steel plate shall be between 1.0 mm to 1.5 mm.	We request kindly provide the details / drawings for the BOQ line item for enabling us to estimate rate for the line item	**Refer customer / NTPC specifications as attached with this corrigendum-2 for same. BOQ item is clear.**
10	TCC Chapter IX (BOQ FOR STEEL STRUCTURE PH-1&2, CCR AND IT'S BOIs) ST NO. 2328	Supply, fixing lightning arrester and air terminal over roof of power house building, pump house and other structures inluding all materials, labour, electrodes etc complete (all materials to be supplied by the contractor).	We request kindly provide the details / drawings for the BOQ line item for enabling us to estimate rate for the line item	**BOQ item is clear. Tender Condition shall prevail.**

Note:

1) **All other terms and conditions against this NIT shall remain unchanged.**
2) **This corrigendum is to be submitted duly signed and stamped along with the Techno-commercial bid (Part- I).**

for BHARAT HEAVY ELECTRICALS LTD
Sr. Manager/ SCT

b) The galvanising shall be followed by the application of an etching Primer and dipping in black bitumen in accordance with BS: 3416, unless otherwise specified.

6.04.05 **Gratings**

All gratings shall be blast cleaned to Sa 2 ½ finish or cleaned by acid pickling as per ISO 8501-1 and shall be hot dip galvanized at the rate of 610 gm/sqm.

6.04.06 **Hand Railings and Ladders**

All Mild steel (MS) handrails and ladders in outdoor locations and in pump valve pits shall be galvanised at the rate of 610 gm/sqm as per IS 4736. All other MS handrails shall be painted as specified in clause 6.04.03 above. However, Stainless steel handrails shall be provided as specified in General Architectural Specification clause 9.00.00.

6.04.07 **Sea Worthiness**

All Steel Sections and fabricated Structures, which are required to be transported on sea, shall be provided with anti-corrosive Paint before shipment to take care of sea worthiness.

6.04.08 Chequered plate to receive same corrosion protection measures as structural steel unless specified other wise.

6.04.09 **For reinforced concrete work.**

i) The protection for concrete sub-structure shall be provided based on aggressiveness of the soil, chemical analysis of soil/sub-soil water and presence of harmful chemicals/salts.

ii) The protection to super structure shall depend on exposure condition and degree of atmospheric corrosion.

This shall require use of dense and durable concrete, control of water cement ratio, increase in clear cover, use of special type of cement and reinforcement, etc., coating of concrete surface, etc.,

Bidder shall furnish the details of corrosion protection measures.

6.04.00 **CORROSION PROTECTION**

6.04.01 **General**

(a) All Steel structures shall be provided with painting system as mention below in this specification for the Corrosivity category mentioned in Part A-IID-Civil Works

Painting system for steel surfaces embedded in Concrete is given separately.

(b) All Painting shall be done as per Technical Specification Painting scheme shall submitted by the Bidder.

(c) All steel structures shall be designed by following basic design considerations in ISO 12944 Part 3. Where steel is fully accessible for cleaning and repainting and where it is feasible to follow design criteria given in ISO 12944 part 3, minimum thicknesses of structural members shall be as follows

Structural Sections	Minimum thickness	Minimum Flange thickness	Minimum Web thickness
Plates	6		
Built up Sections		6	6
Angle sections	6		
ISMB /ISMC		6	4.5
NPB/ WPB		6	4.5
RHS/SHS/ Tubular Sections	4		
All dimensions in mm			

Where steel surfaces are inaccessible for cleaning and repainting (such as back to back sections, lap joints etc.) or where it is not feasible to follow design criteria given in ISO 12944 part 3, corrosion allowance of 1.5 mm shall be kept in thickness (over the design thickness or minimum thickness specified above, whichever is more). The minimum thickness consideration shall apply for both web and flange.

However minimum gusset plate thicknesses shall be followed as mentioned else where in the specification and minimum angle section to be used is ISA 50x50x6. Ends of tubular sections to be effectively sealed at both ends. Also tubular handrail thicknesses will be as goverened by mentioned clauses in the spec

Minimum thickness of tubular/ hollow steel sections conforming to IS 4923 shall be 4.0 mm, provided the ends of such steel sections are effectively sealed unless higher thickness is specified elsewhere for specific structure.

6.04.02 **Painting of Steel Surfaces Embedded In Concrete**

a) For the portion of Steel surfaces embedded in Concrete, the surface shall be prepared by Manual Cleaning and provided with Primer Coat of Chlorinated Rubber based Zinc Phosphate Primer of Minimum 50 Micron Dry Film Thickness (DFT).

b) All threaded and other surfaces of foundation bolts and its materials, insulation pins, Anchor channels, sleeves, etc. shall be coated with temporary rust preventive fluid and during execution of civil works, the dried film of coating shall be removed using organic solvents.

6.04.03 **Painting of Steel Surfaces (Other Than Those Embedded In Concrete)**

D-1-9 **Architectural Concepts and Design**

9.01.00 For Architectural Concepts and Design refer to 5.01.00 in this specification.

9.02.00 **General Architectural Specifications**

9.02.01 **General**

a) Minimum 1000 mm high (from floor/ roof level) hand railing shall be provided around all floor/roof openings, projections/balconies, walkways, platforms, steel stairs, etc., wherever the height of the building is more than 12m, railing height shall be 1.2m. All handrails and ladder pipes (except at operating floors) shall be 32 mm nominal bore MS pipes (medium class) conforming to IS: 1161 and shall be galvanised as per IS: 4736 and finished with suitable paint. All rungs and ladders shall also be galvanised. Minimum weight of galvanising shall be 610 g/sqm. The spacing of vertical posts shall be maximum 1500mm. Two number of horizontal rails shall be provided including the top member. In addition, toe guard/ kick plate of min size 100x6th shall be provided above the floor level.

For handrailing at operating floors of Main Power House including RCC stairs (for one flight above and below operating floor level), passages, around all floor openings shall be Stainless Steel (SS) pipes shall be used. All floors of Service building shall be provided with SS Handrail. Height of the handrail shall be 1000 mm /1200mm in accordance with the preceding para. For SS handrail 32NB/50NB/60NB (polished) stainless steel pipe shall be provided. The spacing of vertical posts shall not be more than 1500mm. Two number of horizontal rails shall be provided including the top member. SS Toe guard, knee guard and kick plate shall be provided above the floor level.

b) All stairs shall have a maximum riser height of 175mm and a minimum tread width of 275 mm. Minimum clear width of stair shall be 1200 mm unless specified otherwise.

c) All buildings having metal cladding shall be provided with 1 meter high brick wall at ground floor level. All buildings having metal cladding shall be provided with a 150 mm high RCC toe kerb (on upper floor) at the edge of the floor along the metal cladding. 1000 mm/ 1200 mm high hand railing shall be provided on this RCC kerb, wherever required from the safety point of view.

d) In all buildings, structures, suitable arrangement for draining out water collected from equipment blowdowns, leakages, floor washings, fire fighting, etc., shall be provided for each floor. All the drains shall be suitably covered with grating or precast RCC panels.

e) RCC steps / staircase shall be provided for main entrance of all RCC construction buildings.

f) Parapet, Chajjas 450mm over window and 600mm door heads, 900mm over rolling shutters, architectural facia, projections, etc., shall be provided with drip course in cement sand mortar 1:3.

g) All fire exits shall be painted with fire resistant paint P.O red/signal red colour shade which shall not be used anywhere except to indicate emergency or safety measure. Fire safety norms shall be followed as per National Building Codes and fire safety requirements for providing fire exits, escape stairs and fire fighting equipment. In detailing of all buildings, fire safety requirements conforming to IS: 1641 and IS:1642 shall be followed.

h) (Ramps & Lifts for physically challenged persons shall be provided for barrier free access to the Service buildings,

c) Hollow (square and rectangular) steel sections shall be hot formed conforming to IS: 4923 and shall be of minimum Grade Yst 240 and minimum thickness shall be 4 mm..

d) Chequered plate shall conform to IS 3502 and shall be minimum 6 mm thick excluding projection. Steel for chequered plate shall conform to grade E250A semi killed of IS: 2062 or equivalent grade conforming to ASTM & BS standards only.

10.04.02 **Medium and High Tensile Steel**

Rolled Sections and plates shall be of grade designation E350 or higher, Quality B0 (Fully killed), conforming to IS: 2062. Plates beyond 12mm thickness and up to 40mm thickness shall be normalized rolled. Plates beyond 40mm thickness shall be vacuum degassed & furnace normalised and shall also be 100% ultrasonically tested as per ASTM –A578 level B-S2.

10.05.00 **Bricks**

Only fly ash bricks shall be used in all construction, except for elevator shafts, which can be either of burnt clay bricks or RCC construction as per functional / codal provisions. Bricks shall be table moulded/ machine made of uniform size, shape and sharp edges and shall have minimum compressive strength of 75kg/cm2. Burnt clay fly ash bricks and fly ash lime bricks shall conform to IS: 13757 and IS: 12894 respectively. Minimum fly ash content in fly ash based bricks shall be 25%.

10.06.00 **Foundation Bolts**

Material and details of foundation bolts shall conform to IS: 5624. Mild steel bars used for the fabrication of bolt assembly shall conform to grade 1of IS: 432 and/ or grade A of IS: 2062. Hexagonal nuts and lock nuts shall conform to IS: 1363 & IS: 1364 upto M36 diameter and IS: 5624 for M42 to M150 diameter.

10.07.00 **Stainless steel**

The material specification for stainless steel plates are mentioned in the design concept area of Mill Bunker building.

10.08.00 **Water**

Water used for cement concrete, mortar, plaster, grout, curing, washing of coarse aggregate, soaking of bricks, etc. shall be clean and free from oil, acids, alkalis, organic matters or other harmful substances in such amounts that may impair the strength or durability of the structure. Potable water shall generally be considered satisfactory for all masonry and concrete works, including curing. When water from the proposed source is used for making the concrete, the maximum permissible impurities, development of strength and initial setting time of concrete shall meet the requirements of IS: 456.

All materials brought for incorporation in works shall be of best quality as per IS unless specified otherwise.

10.09.00 PTFE (Poly Tetra Fluoroethylene) Bearing

The bearing shall be of reputed make and manufacturer as approved by the Engineer, for required vertical load and end displacement/rotation. PTFE bearing shall be sliding against highly polished stainless steel and the coefficient of friction between them shall be less than 0.06 at 55 kg/sq.cm. In order to prevent cold flow in PTFE surface it shall be rigidly bonded by a special high temperature resistance adhesive to the stainless steel substrata. The stainless steel surface that slides against the PTFE is mirror polished. The stainless steel shall be bonded to the top plate by special high strength adhesive. The thickness of stainless steel plate shall be between 1.0 mm to 1.5 mm.

10.10.00 **Statutory Requirements**

Bidder shall comply with all the applicable statutory rules pertaining to Factories Act, Fire

Following painting system corresponding to corrosion category as mentioned in Part A IID Civil Works of this specifications shall be adopted for the project.

CORROSSIVITY CATEGORY(as per ISO 12944-2)	PRIMER COAT	INERMEDIATE COAT	FINAL COAT
C3	All steel surfaces shall be provided with two component moisture curing zinc (ethyl) silicate primer coat (having minimum 80% of metallic Zinc content in dry film, solid by volume minimum 60% ±2%) of minimum 70 micron DFT to be applied over blast cleaned surface conforming to Sa 2 ½ finish of ISO 8501-1 with surface profile 40-60 Micron. The primer coat shall be applied in shop immediately after blast cleaning by airless spray technique. Zinc dust composition and properties shall be Type-II as per ASTM D520-00.	Primer coat shall be followed with the application of Intermediate coat of two component polyamide cured epoxy with MIO Content (containing lamellar MIO minimum 30% on pigment, solid by volume minimum 80% ±2%) of minimum 100 micron DFT. This coat shall be applied in shop after an interval of minimum 24 hours (from the application of primer coat) by airless spray technique.	Intermediate coat shall be followed with the application of finish coat of two-pack aliphatic Isocyanate cured acrylic finish paint (solid by volume minimum 55% ±2%) with Gloss retention (SSPC Paint Spec No 36, ASTM D 4587, D 2244, D 523) of Level 2 (after minimum 1000 hours exposure, Gloss loss less than 30 and colour change less than 2.0 ΔE) and minimum 70 micron DFT. This coat shall be applied shop after an interval of minimum 10 hours and within six (6) months (from the completion of Intermediate coat), Colour and shade of the coat shall be as approved by the Employer.
C5	All steel surfaces shall be provided with two component moisture curing zinc (ethyl) silicate primer coat (having minimum 80% of metallic Zinc content in dry film,	Primer coat shall be followed with the application of Intermediate coat of two component polyamide cured epoxy with MIO Content (containing lamellar MIO	Intermediate coat shall be followed with the application of finish coat of two-pack aliphatic Isocyanate cured acrylic finish paint (solid by volume minimum 55% ±2%)

	solid by volume minimum 60% ±2%) of minimum 70 micron DFT to be applied over blast cleaned surface conforming to Sa 2 ½ finish of ISO 8501-1 with surface profile 40-60 Micron. The primer coat shall be applied in shop immediately after blast cleaning by airless spray technique. Zinc dust composition and properties shall be Type-II as per ASTM D520-00.	minimum 30% on pigment, solid by volume minimum 80% ±2%) of minimum 180 micron DFT. This coat shall be applied in shop after an interval of minimum 24 hours (from the application of primer coat) by airless spray technique.	with Gloss retention (SSPC Paint Spec No 36, ASTM D 4587, D 2244, D 523) of Level 2 (after minimum 1000 hours exposure, Gloss loss less than 30 and colour change less than 2.0 ΔE) and minimum 70 micron DFT. This coat shall be applied shop after an interval of minimum 10 hours and within six (6) months (from the completion of Intermediate coat), Colour and shade of the coat shall be as approved by the Employer.

Notes:

1. For Primer, high quality surface preparation is necessary and good amount of moisture is required for proper curing. Below 70 % relative humidity, curing time may go up to 7 days or more. In such a case additional water sprinkling may be ensured for completion of curing. Additionally Inorganic zinc silicate cannot be recoated; even with itself. Typically it should be used when coating bare steel surface for first time.
2. The most frequent problem associated when top coating Primer is bubbling/pinholing especially with non-weathered zinc silicate coatings. To a great extent, this bubbling of finish paint can be eliminated by applying a mist coat of intermediate/topcoat as the first pass of the product, allow the bubbles to subside and then apply a full coat, as required.
3. In case top coating of zinc silicate with epoxy/polyurethane coatings, is expected to be delayed, it is advisable to use a suitable tie coat to avoid formation of white rust. However, if white rust forms then clean the surface with high pressure water, dry and apply the subsequent coats as required.
4. Touch up paintings on damaged areas: Surface preparation by manual tools, wire brush/ emery paper etc. Minimum 6 inches peripheral area, adjoining to damaged area to be covered. If metal surface is exposed, it is to be painted with Zinc rich epoxy (70 micron) or suitable primer with existing paint scheme. If primer is intact, intermediate & top coat to be done with specified DFT in scheme.

6.04.04 **Coating for Mild Steel parts in contact with Water**.

a) All mild Steel parts coming in contact with water or water vapour shall be hot dip galvanised. The Minimum Coating of Zinc shall be 610 g/ Sq.m. for galvanised Structures and shall comply with IS: 4759 and other relevant Codes. Galvanising shall be checked and tested in accordance with IS: 2629.