
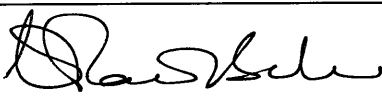
 BHARAT HEAVY ELECTRICALS LIMITED PIPING CENTRE, CHENNAI- 17 QUALITY ASSURANCE & CONTROL DEPT.			PAINTING SCHEME FOR LP PIPING (CW / ACW / ECW / Plant water, Air Piping, etc...,) KORBA STPP STAGE III (1 X 500MW) MPP Customer Nos:-0634,6893,6894									QPNo: 6893:QPC:12 REV.NO: 01 Dt : 22.10.2007	
Sl. 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 - 1000 mm and above)	Blast Cleaning SSPC SP-10 SA 2½ (Refer Note 1)	Epoxy based Zinc rich Primer (Refer Note 2)	1 (50 Microns Min. per coat)	----	----	----	Coal tar epoxy (Refer Note 2)	2 (75 Microns Min. per coat)	----	200 Microns (Refer Note 3)		
	(b) Holiday test (Refer Note 3)	Holiday testing by low voltage (75 Volts Min.) wet sponge Holiday detector or by High voltage (Voltage per micron of DFT is as recommended by Paint Manufacturer subjected to minimum of 5V / Micron). Holiday test Equipment to be calibrated before testing.											
2	External Surface of CW --Buried Piping / Encased in concrete (a) Temporary Protection to be done at works.	SSPC-SP3 / Power Tool Cleaning	Red Oxide Zinc Phosphate (Alkyd base to IS 12744)	1 (30 Microns per coat)	----	----	----	----	----	----	30 Microns		
	(b) Protection coating to be done by BHEL Erection Group at site.##	SSPC-SP3 / Power Tool Cleaning	Coal Tar Primer	2 (30 Microns per coat)				Coal tar tape conforming to IS 10221	2 Layers		3200 (3.2mm)	## by site.	
3	External Surface (over ground piping) of CW, ACW. (For all diameters)	SSPC-SP3 / Power Tool Cleaning	Red Oxide - Zinc Phosphate (Alkyd base to IS: 12744)	2 (25 Microns per coat)	----	----	----	Synthetic enamel Long oil Alkyd to IS: 2932	3 ** (35 microns per coat) (2 at shop + 1 at site)	Smoke Grey (Shade No. 692 of IS: 5)	120 at shop + 35 at site	** 1 coat of DFT- 35 microns finish coat at site	
4	External Surface of ECW, Plant water (For all diameters)	SSPC-SP3 / Power Tool Cleaning	Red Oxide - Zinc Phosphate (Alkyd base to IS: 12744)	2 (25 Microns per coat)	----	----	----	Synthetic enamel Long oil Alkyd to IS: 2932	3 ** (35 microns per coat) (2 at shop + 1 at site)	Smoke Grey (Shade No. 692 of IS: 5)	120 at shop + 35 at site	** 1 coat of DFT- 35 microns finish coat at site	
5	Potable water, Instrument air & Service air piping	No painting for Galvanised pipes and components used . For buried portion of this piping ,Slno: 2(b) coaltar coating is applicable.											
Notes: 1. Blast cleaning to near white metal to obtain roughness as per epoxy paint data sheet. 2. Application of Epoxy based Zinc rich Primer, Coal Tar Epoxy 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. No painting for Galvanised and Stainless steel piping.													
 PREPARED and REVIEWED BY : R.JANARTHANAN, DM / QA			NTPC Doc. no. 2140-108-110-34PC-PVM-W-001								PAGE : 1 / 1		