

PROJECT NAME : HAZIRA - CCCP (1 X 350 MM)
BHEL CUSTOMER Nos : 6972

Sl. NO	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat			Finish coat				REMARKS
			Primer	No of coats	Paint	No of coats	Shade	Paint	No of coats	Shade	Total DFT Microns (Min.)	
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 (100 Microns Min. per coat)	---	250 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 (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.	SSPC-SP3 / Power Tool Cleaning	Red Oxide Zinc Phosphate (Alkyd base to IS 12744)	1 (30 Microns per coat)	---	---	---	---	---	---	30 Microns	
3	External Surface (over ground piping) of CW, ACW (For all diameters)	Blast Cleaning SA 2½ (Refer Note 1)	Epoxy based Zinc rich Primer	2 (50 Microns per coat)	Epoxy based TIO2 intermediate paint	1 (75 microns per coat)	---	Epoxy based finish paint	1 (50 Microns per coat)	Smoke Grey (Shade No. 692 of IS: 5)	225 Microns	
4	External Surface of ECW, Plant water (For all diameters)	Blast Cleaning SA 2½ (Refer Note 1)	Epoxy based Zinc rich Primer	2 (50 Microns per coat)	Epoxy based TIO2 intermediate paint	1 (75 microns per coat)	---	Epoxy based finish paint	1 (50 Microns per coat)	Smoke Grey (Shade No. 692 of IS: 5)	225 Microns	
5	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 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.

PREPARED and REVIEWED BY : G.PANNEER SELVAM, SM / QA

APPROVED BY: G.R.SRINIVASAN, AGM / Q

a. Under Ground									
As per Sl.no. 1 and 2 of Painting Scheme									
Sl. No	Pipe Size	Material Code	Total Qty/ in Mtrs	Base Price of Pipe	Extra Coating Rate/Mtr (Ex-Works) as per TDG:07:05	inside Extra Coating Rate/Mtr (Epoxy Rich Tar Epoxy – 2 Primer – 1 x 50 x 100 Microns) – Primer – Over Coat	inside Extra Coating Rate/Mtr (Coal based Zinc Phosphate – IS 12744 – 1 x 30 Microns) – Primer	Outside Extra Coating Rate/Mtr (Red Oxide Finished Pipe to Hazira Site	Extra Transportation Cost/Mtr of
1	2132 x 18 UG	1593871500UG	240						
USE EXCEL FILE -PRICE FORMAT- GIVEN BY US (REFER ENCLOSED PRICE FORMAT) FOR GIVING YOUR OFFER									

Work Order Details
1. Pipe Dia 2132 x 18 - P 6972 - 1 - 80 - 468 DU 002- 240 Mtrs

b. Over Ground – As per Sl.no. 1 and 3 of Painting Scheme									
Sl. No	Pipe Size	Material Code	Total Qty/ in Mtrs	Base Price of Pipe	Extra Coating Rate/Mtr (Ex-Works) as per TDG:07:05	inside Extra Coating Rate/Mtr (Epoxy Rich Tar Epoxy – 2 Primer – 1 x 50 x 100 Microns) – Primer – Over Coat	inside Extra Coating Rate/Mtr (Coal based Zinc Phosphate – IS 12744 – 1 x 30 Microns) – Primer	Outside Extra Coating Rate/Mtr (Red Oxide Finished Pipe to Hazira Site	Extra Transportation Cost/Mtr of
1	1422 x 14 OG	1593871400OG	140						
USE EXCEL FILE -PRICE FORMAT- GIVEN BY US (REFER ENCLOSED PRICE FORMAT) FOR GIVING YOUR OFFER									

Work Order Details
1. Pipe Dia 1422 x 14 - P 6972 - 1 - 80 - 468 DU 001-140 Mtrs



Sl. No	Pipe Size	Material Code	Total Qty in Mtrs	Base Price of Pipe Rate/Mtr (Ex-Works) as per TDC: TDG:07:05	Extra Coating Rate/Mtr (Coal Tar Primer-1 x 30 Microns) – Primer Coat	inside Extra Coating Rate/Mtr (Coal Tar Epoxy – 2 x 60 Microns) Over Coat	Extra Coating Rate/Mtr (Coal Oxide Chromate - 1 x 25 Microns) – Primer	Outside (Red Zinc Pipe to Rayalseema Site	Extra Transportation of Finished
1	2540 x 20 UG	1593859900UG	67						
USE EXCEL FILE -PRICE FORMAT- GIVEN BY US (REFER ENCLOSED PRICE FORMAT) FOR GIVING YOUR OFFER									

Work Order Details
1. Pipe Dia 2540 x 20 - P 6928 - 1 - 80 - 468 DU 059 - 67 Mtrs

