		ST Preparation of
Intermediate coat	Primer coat	Surface
s : 6972	BHEL CUSTOMER Nos : 6972	
PROJECT NAME: HAZIRA - CCCP (1 X 350 MW)	PROJECT NAME : HAZ	QUALITY ASSURANCE & CONTROL DEPT.
(CW / ACW / ECW / Plant water,	()	HAN ELECTRICALS LIMITED
PAINTING SCHEME FO		BHARAT HEAVY

PAGE:1/1		APPROVED BY: G.R.SRINIVASAN, AGM/Q	G.R.SRINIVA	PPROVED BY: G.R	A		·		1, SM/QA	ANNEER SELVAN	PREPARED and REVIEWED BY : G.PANNEER SELVAM, SM/QA	REPARE	PR
	ment.	ation, meeting the thickness requirements as per this document.	ness requiremen	eeting the thickr	dation, m	/ recommend	rer's data sheet	ata sheet. Is per manufactur	is per epoxy paint di xoxy shall be done a	obtain roughness a Primer, Coal Tar Ep inspection agency.	Blast cleaning to near white metal to obtain roughness as per epoxy paint data sheet. Application of Epoxy based Zinc rich Primer, Coal Tar Epoxy shall be done as per manufacturer's data sheet / recommend: Witness by BHEL / BHEL nominated inspection agency.	Notes: 1. Blas 2. Appl 3. Witr	No
				Q	No painting	z					Galvanised and Stainless steel Piping	5 Galvar	(Jn
	225 Microns	Smoke Grey (Shade No. 692 of IS: 5)	(50 Microns per cot)	Epoxy based finish paint		(75 microns per coat)	Epoxy based r TIO2 intermediate paint	2 (50 Microns per coat)	Epoxy based Zinc rich Primer	Blast Cleaning SA 2½ (Refer Note 1)	External Surface of ECW, Plant water (Extern For all	-14
	225 Microns	(Shade No. 692 of IS: 5)	(50 Microns per cot)	finish paint	ļ	(75 microns per coat)	TIO2 intermediate paint	2 (50 Microns per coat)	Epoxy based Zinc rich Primer	Blast Cleaning SA 21/2 (Refer Note 1)	External Surface (over ground piping) of Blast Cleaning SA 2½ (Refer Note 1)	Externi CW,A0	ω
	30 Microns	O TOP			.			(30 Microns per coat)	Red Oxide Zinc Phosphate (Alkyd base to IS 12744)	SSPC-SP3 / Power Tool Cleaning	External Surface of CWBuried 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.	Extern / Encas 1000 n Protec to site) by BHE Contra	2
		ing.	wet sponge Holiday detector or by High voltage (votage per fitted to the first as as to minimum of 5V / Micron). Holiday test Equipment to be calibrated before testing.	ment to be calib	igh voltag test Equip	tector or by Hi	inge Holiday dei ium of 5V / Micr	Its Min.) wet spo	Holiday testing by low voltage (75 Volts Min.) wet sponge Holiday detector or by High voltage (Votage per mid on the last as a second or to minimum of 5V / Micron). Holiday test Equipment to be calibrated before testing.	Holiday testing by	(b) Hoilday test (Refer Note 3)	(b) Hoi	
chirer subjected	(Refer Note 3)		(100 Microns Min. per coat)	Coal tar epoxy (Refer Note 2)			1	1 (50 Microns Min. per coat)	Epoxy based Zinc rich Primer (Refer Note 2)	Blast Cleaning SSPC SP-10 SA 2½ (Refer Note 1)	CW Pipe (for pipe - bove)		→ .
13	12	11	10	9	8	7	6	5	4	3	2		
	Microns (Min.)	Shade	No of coats	Paint	Shade	No of coats	Paint	No of coats	Primer	Preparation & Surface Profile	PGMA / Description	5 %	SI.
REMARKS) coat	Finish coat			Intermediate coat	Inter	coat	Primer coat	Surface			
						350 MW)	. CCCP (1X)72	ME: HAZIRA -	PROJECT NAME: HAZIRA - CCCP (1 X 350 MW) BHEL CUSTOMER Nos: 6972	L DEPT.	QUALITY ASSURANCE & CONTROL DEPT.	<u>و</u>	Ĭ
<u></u>	REV.NO: 00 Dt: 22.09.2009		; G	ater, Air Piping, etc,	Yater, A	CHEME // Plant w	PAINTING SCHEME (CW / ACW / ECW / Plant w	(cw /		D I	BHARAT HEAVY ELECTRICALS LIMITED	11441	7
:QPC:12	QPNo: 6972:QPC:12		5	3	1								

		1 2					N _O	Sl. 1	a. U
		2132 x 18 UG						Sl. Pipe Size	a. Under Ground
	USE EXCEL I	1 2132 x 18 UG 1593871500UG						Material Code Total Qty Base Price of Extra	
	FILE -PRIC	240					in Mtrs Pipe	Total Qty	As per SI
FOR GI	E FORMAT- G		TDG:07:05	TDC:	Works) as per	Rate/Mtr (Ex-	Pipe	Base Price of	.no. 1 and 2 of 1
FOR GIVING YOUR OFFER	IVEN BY US (R		Microns) - Prim	Primer - 1 x 5	based Zinc Ric	Rate/Mtr (Epor	Coating		As per Sl.no. 1 and 2 of Painting Scheme
FER	EFER ENCLOSE		er – Over Coat	0 x 100 Microns)	h Tar Epoxy – 2	ty Rate/Mtr (Coal	Coating	inside Extra inside Extra	
	USE EXCEL FILE -PRICE FORMAT- GIVEN BY US (REFER ENCLOSED PRICE FORMAT)		Microns) – Primer – Over Coat Microns) – Primer	12744 - 1 x 3	Zinc Phosphate - 1	Rate/Mtr (Ex- Rate/Mtr (Epoxy Rate/Mtr (Coal Rate/Mtr (Red Oxide Cost/Mtr	Coating		
		a		0 Hazira Site	S Finished Pipe	de Cost/Mtr	Transportation	Outside Extra	
					to	of			

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

		1 1422						No	Sl. Pipe Size
		x 14 OG							
		1422 x 14 OG 1593871400OG							Material Code Total Qty Base Price of Extra
	USE	140						in Mtrs Pipe	Total Qty
	USE EXCEL FILE -PRICE FORMAT- GIVEN BY US (REFER ENCLOSED PRICE FORMAT)			TDG:07:05	TDC:	Works) as per based Zinc Rich Tar Epoxy - 2 based Zinc	Rate/Mtr (Ex-Rate/Mtr (Epoxy Rate/Mtr (Coal Rate/Mtr	Pipe	Base Price of
	PRICE FOR		Coat	Microns) – I	Primer – 1	based Zinc	Rate/Mtr (Coating	
FOR GI	MAT- G			rimer –	x 50 x	Rich T	Epoxy R	<u> </u>	inside Extra
FOR GIVING YOUR OFFER	IVEN BY U			Over Coat	100 Micror	ar Epoxy –	ate/Mtr (Cc	Coating	
OFFER	S (REFER EN		Coat	Microns) -	Primer - 1 x 50 x 100 Microns) Primer - 2 x	2 based Zii	al Rate/Mtr	Coating	inside Extra
	CLOSED			Primer	×	nc Rich	(Epoxy		Outside Extra
	PRICE FOR			Intermediate	50 Microns)	based TIO2	Rate/Mtr	Coating	Extra
	CMAT)		- Tes	Paint		-1×75	(Epoxy I		Outside I
			Microns) - Finish Paint	Microns) - Primer - Over Coat Microns) - Primer Intermediate Paint per IS 5 - 1 x 50	 Grey Shade No. 692 as to Hazira Site 	Rich based TIO2 - 1 x 75 Finish Paint - Smoke Finished Pipe	(Epoxy Rate/Mtr (Epoxy Rate/Mtr (Epoxy based Cost/Mtr of		Outside Extra Outside Coating Extra
					s to Hazira Site	Finished Pipe	1 Cost/Mtr of	Transportation	Extra

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



Price Format for Rayalseema Cooling Water Piping
Painting QP Reference No. 6928: QPC: 04 Rev 00 Dt. 05.12.07
Under Ground - As per Sl.no. 2.1 a & b and 3.2 of Painting Scheme

									N _O	S
		1 254							0	SI. Pipe Size
		2540 x 20 UG								Size
		UG								
		159								Ma
	USE E	1593859900UG								Material Code
	XCEL	00UG								Code
	, FILE							Ħ.		To
	-PRIC	67						in Mtrs		tal Qty
	E FOR				TDG:	TDC:	Work	Rate/1	Pipe	Base
FOR	MAT-				07:05		s) as po	Mtr (E)		Price o
SIVIN	GIVE]				TDG:07:05 Coat	Mici	er Prim	⊱ Rate	Coating	Total Qty Base Price of Extra
G YOU	NBY				•	ons) -	er-1	/Mtr (ing	22
FOR GIVING YOUR OFFER	US (RE					Microns) - Primer 60 Microns)	Works) as per Primer-1 x 30 Tar Epoxy - 2	Rate/Mtr (Ex-Rate/Mtr (Coal Tar Rate/Mtr		insi
FER	EFER I		· · · · · · · · · · · · · · · · · · ·		Ονι	er 60	30 Tar	ar Rat	Cog	inside Extra
	ENCL				Over Coat	Mici	Epox	e/Mtr	Coating	ra
	OSED		۸			(sno	y - 2	(C)		insi
	PRIC			Mi	20.	-Ch	x Oxide)al Ra	Co	inside Extra
	USE EXCEL FILE -PRICE FORMAT- GIVEN BY US (REFER ENCLOSED PRICE FORMAT)			Microns) – Primer	2074 - 1 x 25	Chromate	ide	(Coal Rate/Mtr	Coating	tra
	MAT)			– Prin	×		~	<u> </u>		Out
				ler —	25	IS Site	Zinc P	Red C		side E
						ite	Zinc Pipe to Rayalseema	(Red Cost/Mtr of Finished		Outside Extra Transportation
) Raj	of		anspor
							yalseen	Finish		tation
							na	pe		

Work Order Details

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