

## **PAINTING SCHEME FOR KHURJA CCR COLUMNS**

### **Primer:**

Extra over ST NO. B2301 & C2301 for blast cleaning of steel structures to near white metal surface (Sa 2 1/2 ) and applying coat of two component moisture curing zinc (ethyl) Silicate primer (solid by volume Minimum 60+/-2% & zinc dust % on dry film minimum 80 %). Zinc dust composition and properties shall be Type-II as per ASTM D520-00. Primer of minimum 70 micron DFT shall be applied over shot blast cleaned surface including touch-up painting etc all complete. Primer coat shall be applied in Shop immediately after blast cleaning by airless spray technique.

### **Intermediate Coat:**

Providing and applying (with airless spray technique) intermediate coat of two component polyamide cured epoxy with MIO Content (containing lamellar MIO minimum 30% on pigment, solid by volume minimum 80%  $\pm$ 2%) of minimum 100 micron DFT to be applied after an interval of minimum 24 hours (from the application of primer coat by airless spray technique.) and of approved make including protection and cleaning, scaffolding etc. all complete as per specification for all structures.

### **Finish Coat:**

Providing and applying Finish coat of two-pack aliphatic Isocyanate cured acrylic finish paint (solid by volume minimum 55%  $\pm$ 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  $\Delta$ E) and minimum 70 micron DFT shall be applied after an interval of minimum 24 hours (from the application of sealer coat), Colour and shade of the coat shall be as approved by the Employer) over steel sections already having intermediate coats including protection and cleaning, scaffolding etc. all complete as per specification for all structures .