

NO COMMENTS

BHARAT HEAVY ELECTRICALS LIMITED
 PIPING CENTRE, CHENNAI- 17
 QUALITY ASSURANCE & CONTROL DEPT.

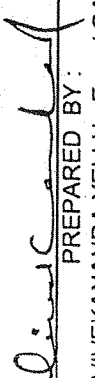

PAINTING SCHEME FOR LP PIPING
 (CW / ACW / ECW / Plant water, Air Piping, etc....)
PROJECT NAME : - YERAMARUS TPP (RPCL)- 2 X800 MW
BHEL CUSTOMER Nos. : 7135, 7136.

QPN No: 7135:QPC:12
 REV.NO: 00
 Dt : 14.11.2011

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) (b) Holiday test (Refer Note 3)	Blast Cleaning SSPC SP-10 SA 2½ (Refer Note 1) 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.	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)	
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)	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	2 (35 microns per coat)	Smoke Grey (Shade No. 692 of IS: 5)	120 Microns	
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	2 (35 microns per coat)	Smoke Grey (Shade No. 692 of IS: 5)	120 Microns	
5	Galvanised and Stainless steel Piping											No painting

Notes:

- 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 / recommendation, meeting the thickness requirements as per this document.
- Witness by BHEL / BHEL nominated inspection agency.


 PREPARED BY: VIVEKANANDA YELLU Engr / QA.

 APPROVED BY: G. PANNEER SELVAM. DGM / QA.
 For Customer use:

Approval Category: Approval Category 'A' APPROVED AS SUBMITTED.
 Release distribution prints.
 Transmittal No: E072-BHEL-0-O-11-503
 Date: 08-12-2011

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