4 NO SI. W. C. E. E. Galvanised and Stainless steel Piping External Surface of ECW, Plant water ( SSPC-SP3 / For all diameters) Blast cleaning to near white metal to obtain roughness as per epoxy paint data sheet. (a) Internal Surface - CW Pipe (for pipe SSPC SP-10 external Surface (over ground piping) of CW,ACW.( For all diameters) by BHEL Erection Group as per Contract requirement. to site). \*\*Further protection to be done Protection for transportation from works External Surface of CW -- Buried Piping | SSPC-SP3 / (b) Hoilday test (Refer Note 3) 1000 mm and above) Encased in concrete (For pipe dia-QUALITY ASSURANCE & CONTROL DEPT. ELECTRICALS LIMITED PGMA / Description BHARAT HEAVY (Temporary Cleaning Cleaning Cleaning SSPC-SP3 Power Tool Power Tool Holiday testing by low voltage (75 Volts Min.) wet sponge Holiday detector or by High voltage (Votage per micron of DFT is as recommended by Paint Manufacturer SA 21/2 (Refer Note 1) Surface Profile Preparation & base to IS: 12744) base to IS: Phosphate (Alkyd Red Oxide - Zinc Phosphate (Alkyd Red Oxide - Zinc Phosphate (Alkyd Red Oxide Zinc (Refer Note 2) BHEL CUSTOMER Nos: 7104,7105,7106,7107,7108. IS 12744) base to Zinc rich Primer Epoxy based PROJECT NAME: - NASIK THERMAL POWER PROJECT- (5X 270 MW) Primer Primer coat subjected to minimum of 5V / Micron). Holiday test Equipment to be calibrated before testing Min. per coat) (25 Microns (30 Microns (25 Microns (50 Microns No of coats per coat ) per coat ) per coat ) ( CW / ACW / ECW / Plant water, Air Piping, etc..., ) PAINTING SCHEME FOR LP PIPING cn Paint 0 Intermediate coat No of Shade No painting 00 enamel Long oil Alkyd to IS: 2932 oil Alkyd to IS: 2932 Synthetic Coal tar epoxy (75 Microns (Refer Note 2) Min. per Synthetic ename! Long Paint 9 per coat ) (2 at shop + per coat ) (2 at shop + (35 microns (35 microns No of coats 1 at site) 1 at site) 3 \*\* 3 \*\* 0 Finish coat (Shade No. 692 of IS: 5) 692 of IS: 5) Smoke Grey (Shade No. Smoke Grey Shade 1 120 at shop + 35 at site 200 Microns (Refer Note 3) 120 at shop + 35 at site Date : 01.12.2010 REV.NO:00 QPNO : 7104:QPC:12 30 Microns Total DFT Microns (Min.) 12 coat at site 35 microns finish 35 microns finish coat at site \*\* 1 coat of DFT-1 coat of DFT-REMARKS 13

PREPARED and REVIEWED BY: VIVEKANANDA YELLU, Engr / QA

APPROVED BY: G.PANNEER SELVAM, DGM / QA

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3. Witness by BHEL / BHEL nominated inspection agency.

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

	PRE	Notes:	5	4	ω	N		_	_	N S	2		
	PREPARED and REVIEWED BY : VIVEKANANDA YELLU, Engr / QA	s:  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.	Galvanised and Stainless steel Piping	External Surface of ECW, Plant water (SSPC-SP3 For all diameters) Cleaning	External Surface (over ground piping) of CW,ACW.( For all diameters)	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.	(b) Hoilday test (Refer Note 3)	(a) Internal Surface - CW Pipe (for pipe - dia - 1000 mm and above)	2	PGMA / Description		BHARAT HEAVY  "" ELECTRICALS LIMITED  PIPING CENTRE, CHENNAI- 17  QUALITY ASSURANCE & CONTROL DEPT	
			No painting		SSPC-SP3 / Power Tool Cleaning	SSPC-SP3 / Power Tool Cleaning	Holiday testing b	Blast Cleaning SSPC SP-10 SA 21/2 (Refer Note 1)	3	Preparation & Surface Profile	Surface	ED 1-17 LDEPT.	
	LLU, Engr/QA			Red Oxide - Zinc Phosphate (Alkyd base to IS: 12744)	Red Oxide - Zinc Phosphate (Alkyd base to IS: 12744)	Red Oxide Zinc Phosphate (Alkyd base to IS 12744)	y low voltage ( 75 \	Epoxy based Zinc rich Primer (Refer Note 2)	4	Primer	Primer coat	PROJECT NAME:-BHEL CUSTOMER N	
	APPROVED BY: G.PANNEER SELVAM, DGM / QA.			2 (25 Microns per coat )	2 (25 Microns per coat )	1 (30 Microns per coat)	(50 Microns Min. per coat) Volts Min. ) wet s	ĊT	No of coats	coat	PAINT (CW/A) ME:- AMR MER Nos:		
				-	-	_	sponge Hol		6	Paint	Intermediate coat	PAINTING SCHEME FOR LP PIPING  (CW / ACW / ECW / Plant water, Air Piping, etc,)  PROJECT NAME: - AMRAVATI THERMAL POWER PROJECT-(5X 270 MW)  BHEL CUSTOMER Nos: 7109, 7110,7111,7112,7113.	
					-		iday detec: V / Micron)		7	No of coats			
						_	tor or by Hi . Holiday t		8	Shade	coat		
				Synthetic enamel Long oil Alkyd to IS: 2932	Synthetic enamel Long oil Alkyd to IS: 2932		olts Min.) wet sponge Holiday detector or by High voltage (Votage per micron of DFT is as n subjected to minimum of 5V / Micron). Holiday test Equipment to be calibrated before testing.	Coal tar epoxy (Refer Note 2)	9	Paint	Finish coat		
				3 ** (35 microns per coat ) (2 at shop + 1 at site)	3 ** (35 microns per coat ) (2 at shop + 1 at site)		age per micron be calibrated	2 (75 Microns Min. per coat)	10	No of coats			
				Smoke Grey (Shade No. 692 of IS: 5)	Smoke Grey (Shade No. 692 of IS: 5)		of DFT is as rebefore testing.	-	11	Shade			
				120 at shop + 35 at site	120 at shop + 35 at site	30 Microns	ecommended b	200 Microns (Refer Note 3)	12	Total DFT Microns (Min.)		QPNO : 71 REV.NO: 00 Date : 01.	
PAGE :1/1		nent.		** 1 coat of DFT- 35 microns finish coat at site	** 1 coat of DFT- 35 microns finish coat at site		Holiday testing by low voltage ( 75 Volts Min. ) wet sponge Holiday detector or by High voltage ( Votage per micron of DFT is as recommended by Paint Manufacturer subjected to minimum of 5V / Micron). Holiday test Equipment to be calibrated before testing.		REMARKS			: 7109:QPC:12 ): 00 : 01.12.2010	