



A Maharatna Company

एन टी पी सी लिमिटेड

(भारत सरकार का उद्यम)

NTPC Limited

(A Govt. of India Enterprise)

(Formerly National Thermal Power Corporation Ltd.)

(केंद्रीय कार्यालय नोएडा)

Corporate Center NOIDA

Reference : CC-ENGG-9587-001-102-PVM-B-001B

Date : 27/07/2024

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ENGINEER

To : BHARAT HEAVY ELECTRICALS LTD
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Subject : EPC Package

Please find enclosed following drawings/ documents for necessary action at your end.

Vendor Drg. No. : HPBP-00-9587-315
Orgn. Drg. No. : 9587-001-102-PVM-B-001B
Revision No. : 01
Drg. Title : PAINTING SCHEME FOR LP PIPING
App. Category : CAT-I
Release Date : 27/07/2024



Scan to verify

Comments : No comments



Engineering Division
ISO 9001:2008 Certified



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COMMENT RESOLUTION SHEET

Dt : 19-07-2024

PROJECT : NTPC LARA SUPER THERMAL POWER PLANT - STAGE II (2X800 MW)

BHEL Doc No : 1834:QPC:12 Rev 01

NTPC Doc No : 9587-001-102-PVM-B-001B

Document Description : PAINTING SCHEME FOR LP PIPING

Sl. No.	NTPC COMMENT	BHEL's REPLY
1	Pl. add Colour shade shall be as per NTPC colour coding scheme	Noted and updated in Note No: 4 of the Painting scheme for LP Piping.

Based on the above clarifications, NTPC is requested to approve the quality plan.



For BHEL



 BHARAT HEAVY ELECTRICALS LIMITED PIPING QUALITY ASSURANCE & CONTROL DEPT, TRICHY			PAINTING SCHEME FOR LP PIPING (ACW / ECW / Plant water, Air Piping, etc...,) PROJECT : NTPC LARA SUPER THERMAL POWER PLANT - STAGE II (2X800MW) BHEL CUSTOMER Nos : 1834, 1835								QPNo: 1834:QPC:12 REV.NO: 01 Dt : 19.07.2024	
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 - ACW 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 (75 Microns Min. per coat)	----	200 Microns (Refer Note 3)	(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 (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.										
2	External Surface of ACW --Buried Piping / Encased in concrete (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 a) Over ground piping of ACW.(For all diameters) b) 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	3 ** (35 microns per coat)	Smoke Grey (Shade No. 692 of IS: 5)	120 at shop + 35 at site	** (2 coat at shop + 1 coat at site)
4	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. Testing requirements like DFT, holiday test shall be as per BHEL approved QP with Witness by BHEL / BHEL nominated inspection agency. 4. Colour shade shall be as per NTPC colour coding scheme.												
				For NTPC use MDL No : 9587-001-102-PVM-B-001B								Page 1/1
PREPARED BY :		APPROVED BY:										
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