

Rev 01	11/05/2025	M Manoj Pandi	K Saranya	S Jegan	Clarification to customer comments
Rev 00	20/05/2025	M Manoj Pandi	K Saranya	S Jegan	First Issue
Revision	Rev Date	Created by	Checked by	Approved by	Description
Revision history					
CUSTOMER NO.:		1848-1849			
CUSTOMER DOC NO.:		1848:QPC:12			
OWNER 	DAMODAR VALLEY CORPORATION				
PROJECT	2X800 MW DVC KODERMA TPS PHASE-II				
EPC Contractor 	BHARAT HEAVY ELECTRICALS LIMITED HIGH PRESSURE BOILER PLANT, TIRUCHIRAPALLI - 620014.				
	Name	Date	Title:		
Prepared by	M Manoj Pandi	11/06/2025	PAINTING SCHEME FOR LP PIPING		
Checked by	K Saranya				
Approved by	S Jegan				
REV: 01	Pages :	1			

COMMENT RESOLUTION SHEET

Date: 11.06.2025

Project Name: DVC- KODERMA TPS, PHASE-II (2X800MW)

BHEL Doc No: 1848 QPC 12 Rev:01

Doc Description: PAINTING SCHEME FOR LP PIPING

Sl. No	Clause Reference	Customer Comments	BHEL Clarifications
1	S no 2	Chlorinated Rubber based Zinc Phosphate Primer - 50 µm to be used for External Surface of ACW –Buried Piping / Encased in concrete	The painting indicated in the scheme is only for temporary protection for transit to site and storage. As indicated in the scheme, Erection group will carry out coating at site as per Contract requirement.

Based on the above clarifications Customer / Consultant is requested to approve the document.



For BHEL

INFORMATION ONLY

 BHARAT HEAVY ELECTRICALS LIMITED PIPING QUALITY, TRICHY			PAINTING SCHEME FOR LP PIPING (ACW / ECW / Plant water, Air Piping, etc...,)									QPNo: 1848:QPC:12 REV.NO: 01 Dt : 11.06.2025	
			PROJECT : DVC- KODERMA TPS, PHASE-II (2X800MW) BHEL CUSTOMER Nos : 1848,1849										
SI. NO	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat			Finish coat				REMARKS	
			Primer	No of coats	Paint	No of coats	Shade	Paint	No of coats	Shade	Total DFT Microns (Min.)		
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 (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.											
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. Shade for finish coat to be done at site shall be as per project specification/contract requirement.													
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PREPARED BY : M MANOJ PANDI MGR/Piping Quality		REVIEWED BY: K. SARANYA MGR/Piping Quality		APPROVED BY: S JEGAN SR.MGR/Piping									