

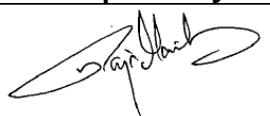
	Bharat Heavy Electricals Limited Boiler Auxiliaries Plant Ranipet – 632 406	BHEL DOC NO.	PS : BHUS :FGD: R4U8
		REVISION NO.	02
		DATE	19.10.2019

BHUSAWAL TPS (1X660MW) FGD PACKAGE

PAINTING SCHEME FOR FGD SYSTEM

CUST ORDER REF: 48/PPMM/SE-IV/Panki Extn.dt. 31.03.2018

BHEL RANIPET Customer No(s).: R4U8& R673 (for GAD)

Prepared By	Reviewed & Approved By
	
Rajamanickam M Dy. Mgr/QA	K.C. Gandhi Parimalam DGM/QA

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (μ m min.)
				PAINT	DFT (μ m min.)	PAINT	DFT (μ m min.)	

RECORD OF REVISION

REV NO	DATE	DETAILS OF REVISION
00	25.04.2019	Original Issue - First Submission
01	08.05.2019	Revised Issue- Changes as per the comments incorporated in the document
02	19.10.2019	Revised Issue- New PGMA's added under FGD system and Engg has deleted some PGMA's too as they have been amalgamated , hence addition & deletion of new PGMA's done under SI nos: 3,5,13, 15, 17, 19, 20, 22, 23, 24, 26, 27, 29, 31, 36, 37, 40, 41, 45, 46& 48 under FGD and resubmitted for your kind approval. There is no change in the painting scheme, only the PGMA's are added/deleted under the above mentioned SI nos. We request you to kindly review and approve our painting scheme.

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				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	

1. FGD SYSTEM

1	Slurry recirculation pump System	FW 212	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
2	Absorber system internals (Structural items)	FW 213	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
3	Mist eliminator & Accessories, Absorber baffle support, Mist eliminator support& Spray pipe support (Structural Items)	FW 215 FW 216 FW 217 FW 218	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
4	Absorber System- Base (Structural CS surfaces)	FW 219	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
5	Absorber system structures & Absorber shear plate	FW 220 FW 231	Blast Cleaning to Sa 2.5 Near White metal with surface	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	250

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	
			roughness profile to 40-60 µm	Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat		Finish coat at site: One coat of Two pack Aliphatic Acrylic PU finish Paint to IS 13213 (solid by volume- 40% (min)), DFT = 35 µm per coat; DFT- 35 µm Shade: Grey white (RAL 9002)	35	
6	Absorber system casing bottom (Outside surfaces)	FW 221	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
7	Absorber system casing top (Outside surfaces)	FW 222	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
8	Absorber system accessories Temp<90°C	FW 223	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	
				by volume- 80% (min)) DFT = 100 µm per coat				
15	Duct support between Absorber & Stack	FW 234	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
16	Structures for RC Pump house	FW 236	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
17	Slurry distribution & Oxidation Air distribution system, Viewing ports& Handling equipment Temp<90°C	FW 239 FW 243 FW 244 FW 249	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
18	Expansion joint between bypass Temp- 150°C	FW 251	Power Tool Cleaning to St3 (SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (two coats)	70	NIL	--	70
			Power Tool Cleaning to St3 (SSPC-SP3)	HR Aluminium paint to IS 13183 Gr.II (upto 400 deg C) (Two coats)	40	NIL	--	40

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)	
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)		
19	Expansion joint between absorber (Structural portion) Temp-60°C	Flue gas swept surface (Inside)	FW 252	Power Tool Cleaning to St3 (SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two coats)	70	NIL	--	70
		Insulated surfaces		Power Tool Cleaning to St3 (SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
20	Ducts between Bypass& Absorber Temp-120°C	Flue gas swept surface (Inside)	FW 255	Power Tool Cleaning to St3 (SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two coats)	70	NIL	--	70
		Insulated surfaces		Power Tool Cleaning to St3 (SSPC-SP3)	HR Aluminium paint to IS 13183 Gr.II (upto 400 deg C) (Two coats)	40	NIL	--	40
21	Ducts between Absorber& Stack Temp-55°C to 60°C	Flue gas swept surface (Inside)	FW 257	Power Tool Cleaning to St3 (SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two coats)	70	NIL	--	70
		Insulated surfaces		Power Tool Cleaning to St3 (SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
22	Duct structure between bypass & Absorber, Absorber & Stack	FW 260 FW 262	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002 Finish coat at site: One coat of Two pack Aliphatic Acrylic PU finish Paint to IS 13213 (solid by volume- 40% (min)), DFT = 35 µm per coat; DFT- 35 µm Shade: Grey white (RAL 9002)	40 35	250	

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	

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SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	
31	Handling Equipment in FGD- Chain pulleys, Hoists& Manhole door, Air cannon silo, Bag filter& fan assy, Nozzles and Flanges	FW 713 FW 714 FW 717 FW 723 FW 724 FW 725	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
32	Agitator support	FW 721	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
33	Limestone silo structures	FW 730	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002 Finish coat at site: One coat of Two pack Aliphatic Acrylic PU finish Paint to IS 13213 (solid by volume- 40% (min)), DFT = 35 µm per coat; DFT- 35 µm Shade: Grey white (RAL 9002)	40 35	250
34	Limestone Silo- Outside surfaces	FW 731	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40- 60µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	
				Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat				
35	Lime stone Silo- Inside surfaces	FW 731	Blast cleaning to Sa 2½ (Near white metal) with surface profile 35-50µm	Primer Coat: Two coats of Red Oxide Zinc phosphate primer to IS 12744 DFT- 70µm (min) (SS lining is inside the Limestone silo, hence primer is only envisaged)	70	NIL	--	70
36	Lime stone Mill- Outside surfaces & Accessories	FW 735	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
37	Lime stone Mill- Inside surfaces	FW 735	Power Tool Cleaning to St3 (SSPC-SP3)	Primer: Two coats of Red Oxide Zinc phosphate primer to IS: 12744	70	--	--	70
38	Gypsum belt filter and accessories- Structural Mechanical items	FW 738	Power tool cleaning to St3(SSPC-SP3	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
39	Lime stone slurry storage tank, Auxiliary absorber tank, Filtrate tank, Wastage water tank, Secondary Hydro cyclone feed tank, Process Water tank, Belt filter washing tank, Clarified water tank Neutralization Tank Outside surfaces	FW 742 FW 743 FW 744 FW 745 FW 747 FW 748 FW 785 FW 800 FW 802	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	
40	Lime stone slurry storage tank, Auxiliary absorber tank, Filtrate tank, Wastage water tank, Secondary Hydro cyclone feed tank, Process Water tank, Belt filter washing tank, Clarified water tank Neutralization Tank& Internal structures Inside surfaces	FW 742 FW 743 FW 744 FW 745 FW 747 FW 748 FW 749 FW 785 FW 800 FW 802	Blast cleaning to Sa 2½ (Near white metal) with surface profile 35-50µm	Primer: Two coats of Red oxide Zinc phosphate primer to IS 12744 DFT- 70µm (min) (Liner is given in the inside surfaces of tank)	70	--	--	70

41	Process water pipe accessories& cooling water pipe accessories (Temp<90°C)	FW 751 FW 752	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
42	Slurry pipe accessories (Temp<90°C)	FW 753	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
43	Service Air pipe accessories (Temp<90°C)	FW 754	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
44	Instrument air pipe accessories (Temp<90°C)	FW 755	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140

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				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	
45	All Valves and fittings (Temp <95°C)	FW 815 to FW 851	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
46	Structure for Pipe racks, Sub pipe racks Trestle for pipe racks	FW 761 FW 765 FW 768 FW 769	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002 Finish coat at site: One coat of Two pack Aliphatic Acrylic PU finish Paint to IS 13213 (solid by volume- 40% (min)), DFT = 35 µm per coat; DFT- 35 µm Shade: Grey white (RAL 9002)	40 35	250
47	Structures inside Gypsum Dewatering Building & Ball Mill Building	FW 787	Blast Cleaning to Sa 2.5 Near White metal with surface roughness profile to 40-60 µm	Primer: One coat of Inorganic Zinc silicate primer to IS 14946, (Solid by volume- 60% (min)), DFT = 75 µm per coat; DFT- 75µm Intermediate: One coat of Polyamide cured Epoxy based MIO pigmented Intermediate coat (solid by volume- 80% (min)) DFT = 100 µm per coat	75 100	Finish: One coat of Polyamide cured Epoxy based finish coat (solid by volume- 40% (min)) DFT = 40 µm per coat Shade: Grey white RAL9002	40	215
48	Tools, Air receivers, commissioning spares, Mandatory spares	FW 798 FW 988 FW 996	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	

2. GATES & DAMPERS (Released under R673 WO)

01	Gates & Dampers > 95° C Insulated Surfaces	57 363 57 413 57 560 57 570 57 583 57 603 57 613	Power tool cleaning to St3 (SSPC-SP3)	HR Aluminium paint to IS 13183 Gr. II	40	--	--	40
02	Ladder, Cage for Ladder, Toe Guard Plate Floor Grill, Hand Rails, Hand Rail Post,	57 566 57 666	Hot Dip Galvanizing to 610 gm per Sq. Meter (minimum) and to a coating thickness of 87 µm (minimum)					
03	Other Structural Items – other than sl.no. 3 of above.	57 566 57 666	Power tool cleaning to St3(SSPC-SP3)	Red Oxide Zinc Phosphate Primer to IS: 12744 (Two Coats)	70	Synthetic enamel to IS 2932 grey shade 692 of IS 5 (Two coats)	70	140
04	Ducts Commissioning Spares	57 988	As per respective items mentioned in this Painting Scheme					

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (μm min.)
				PAINT	DFT (μm min.)	PAINT	DFT (μm min.)	

3. PAINTING OF DAMAGED AREAS

Areas where paint has deteriorated badly by erosion and areas where the paint film has lost its adhesion property and where the steel has got rusted appreciably - these areas are to be repainted as per the following procedure:

SL NO	SURFACE LOCATION	SURFACE PREPARATION	PRIMER, INTERMEDIATE & FINISH
1	Paint damaged Components falling under FGD SI nos. 4,5,6,7, 9,14,15,16,22,24,27,30,32,33,34, 39, 46& 47	Hand/ Power Tool cleaning to Bare metal to minimum 6 inches peripheral area adjoining to damaged area	Primer: Epoxy Zinc rich primer to IS 14589, DFT-70μ (If Metal surface exposed) followed by intermediate & finish coat as per respective scheme If primer is intact- Intermediate & finish as per respective scheme
2	Paint damaged components failing under other SI nos of FGD& GAD	Power Tool Cleaning to Bare metal	Primer and Finish : As given in respective scheme

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	

GENERAL NOTES

1. No painting is required for Galvanized, non-ferrous & stainless steel items, except as indicated above.
2. Machined items are to be applied with coat of temporary rust preventive oil
3. PGMA's covered in sub-supplier (ie., Purchased) items viz., Agitator and other sub-delivery components etc., are not indicated in the above list. However, the Painting Schedule for all items supplied by all sub-suppliers and BOI under the scope of BHEL shall be same as for main equipment covered in this document.
4. In sub-assy, wherever plates / sheets of thickness less than or equal to 5mm and rods are used, very minor items like clamps, small items etc - Power Tool or Hand Tool Cleaning to SSPC - SP 3 / SP 2 shall be followed and painting under SI no:01 of FGD shall be followed.
5. Ground shade/colour of finish paints and identification tag/band for equipments, piping, pipe services, supporting structures and other components is followed as per the color coding practice at site.
6. All components covered under different PGMA's are to be painted. In case any component is left out, the same shall deemed to be included under the relevant section.
7. All threaded and other surfaces of foundation bolts and its materials, insulation pins, Anchor channels, Sleeves shall be coated with temporary rust preventive fluid and during execution of civil works; the dried film of coating shall be removed using organic solvents.
8. All steel structures shall be provided with painting as given in the specification. Further, painting system shall also meet the requirements of corrosivity category C3 (durability high) as per ISO 12944.
9. Finish coat to be applied after an interval of min 10 hrs and within 6 months (after completion of intermediate coat).
10. Bottom of base plate including below zero level portion marked in Supporting Columns of structures which will be embedded in concrete, those surfaces shall be prepared by manual cleaning to ST3 and provided with primer coat of chlorinated rubber based zinc phosphate primer of min. 50 µm DFT.

SI No	SURFACE LOCATION	PGMA	SURFACE PREPARATION	PRIMER		FINISH		TOTAL DFT IN (µm min.)
				PAINT	DFT (µm min.)	PAINT	DFT (µm min.)	

PAINTING SCHEME- DETAILS OF PROCUREMENT & APPLICATION PROCESSES

SL NO	TYPE OF PAINT	SPECIFICATION OF PAINT	NO OF PACK	VOLUME OF SOLIDS (% Min)	MODE OF APPLICATION	MIN. OVER COATING INTERVAL (hours)	SHADE
01	Inorganic Zinc silicate primer	IS 14946	2	60	Airless Spray only	24	
02	Epoxy High solid- Polyamide cured Epoxy based MIO pigmented intermediate coat	--	2	62	Airless Spray only	16	Brown
03	Aliphatic isocyanate acrylic polyurethane paint	IS 13213	2	40	Spray	16	Corresponding shade no
04	Epoxy based polyamide cured finish paint	IS 14209	2	40	Brush/Spray	24	Corresponding shade no
05	Heat resistant aluminium paint	IS 13183 Grade II	1	--	Brush/ Spray	24	--
06	Long oil alkyd Synthetic enamel finish paint	IS 2932	1	35	Brush/ Spray	12	Corresponding shade no
07	Red oxide Zinc phosphate primer	IS 12744	1	--	Brush/ spray	12	--