

TABLE 1 : Painting scheme for Pipes & Pipe Fittings

Sl.No.	Description	Surface Preparation & Surface Profile (At Shop)	Initial Coat-Primer (At Shop)	Finish Coat (Post- Erection/ Field)	Total DFT in Microns(Min.)	Remarks	Ground / Finish Colour (Post- Erection/ Field)
1	Pipelines,Vessels,Columns,Tank,Heat Exchangers,Fire water lines,Pumps,Compressors(Temperatures up to 80 deg C,)Steel structures,Cable Trays) (Pipes,Pipe fittings, Flanges, Valves, Strainer)	SSPC-SP-2/SSPC-SP-3; 1 coat of High solids surface tolerant Epoxy 100-125 µ DFT/coat	1 coat of High solids surface tolerant Epoxy 100-125 µ DFT/coat	1 coat of Aliphatic Acrylic Polyurethane 50-60 µ DFT/coat	250-300 µ	-	Refer Annexure-1 Color Coding
2	Cold and Sweating line.extremely cold line	SSPC-SP-2/SSPC-SP-3; 1 coat of surface tolerant,solvent less,epoxy or glass filled epoxy 150-200 µ DFT/coat	None	1 coat of surface tolerant,solvent less,epoxy or glass filled epoxy 150-200 µ DFT/coat	300-350 µ	-	Refer Annexure-1 Color Coding
3	Water logged Area(Tankproof) and underground Pipeline	SSPC-SP-2/SSPC-SP-3; 1 coat of glass flake filled High build surface tolerant epoxy 150-200 µ DFT/coat	None	1 coat of glass flake filled High build surface tolerant epoxy 150-200 µ DFT/coat	300-350 µ	-	Refer Annexure-1 Color Coding
4	Pipelines,Vessels,Columns,Tank,Heat Exchangers,Fire water lines,Pumps,Compressors(Temperatures operating at 80 deg C-250 deg C,) (Pipes,Pipe fittings, Flanges, Valves, Strainer)	SSPC-SP-2/SSPC-SP-3;	None	Multi matrix Co-polymer based heat resistant coating	75-125 µ	-	Refer Annexure-1 Color Coding

NOTES:

- 1) All coating system including surface preparation, primer, and finish coat for Piping shall be done at field only
- 2) If the Pre-erection/Pre-fabrication & Shop Primer is completed, the same shall not be repeated again in the field.
- 3) This schedule has been prepared in line with ONGC-IEOT Painting scheme for Uran Plant