

BHARAT HEAVY ELECTRICALS LIMITED

Tiruchirappalli - 620 014

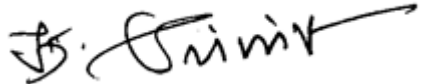


**UPRVUNL - PANKI THERMAL POWER STATION EXTN., 1X660MW,
KANPUR NAGAR DIST, U.P.**

CUSTOMER NO: U6/1728

PAINTING SCHEDULE

NTPC Drawing No: 9962-001-TR-102-PVM-B-800

Prepared by	K. Srinivasan Senior Engineer/ Plant Lab		Document No: PL: C3 - PS/ 1728
Reviewed by	S Thiagarajan AGM/ PE/ FB		Revision No: 03 Dated: 21-01-2019
Approved by	A. Santhakumari AGM / Plant Lab		Sheet No. 01 of 13

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RECORD OF REVISIONS

Rev. No	Date	Details of revision	Remarks
00	15-09-2018	New	Prepared in line with bid resolutions between UPRVUNL/ DCPL & BHEL on BID spec No. 14A14-SPC-G-0001 Ref: Annexure – I C, SG-Quality, SG-Paints 1x660MW PANKI TPS.
01	19-11-2018	Sheet 3, Sheet 4, Sheet 5 – Scheme modified in sl.no.1 & 4. Sheet 8 – DFT indicated in sl. no. 11. Sheet 9 – Scheme modified in sl.no.13. Sheet 13 – Painting of damaged areas included.	Modified as per comments for CAT. II approval by NTPC 'Transmittal for comments on subject PANKI, EPC-SG painting scheme – Boiler Ref: null 102: 408 Dt. 25.10.2018 & NTPC drawing no: 9962-001-TR-102-PVM-B-800.
02	11-12-2018	Sheet 3 – Scheme modified in sl.no.3. Spec. clause indicated in sl.no.1 & 3. Sheet 4 – insulated components included in sl.no.4 Sheet 5 – two coats of primer indicated in sl.no.7. Sheet 6 – bid resolution reference indicated in sl.no.8 Sheet 7 – comments included in sl.no.10. Sheet 8 - Grade I & II indicated according to temperature. Sheet 12 – DFT changed in sl.no 9 & 10.	Modified as per comments for CAT. II approval by NTPC 'Transmittal for comments on subject PANKI, EPC-SG painting scheme – Boiler Ref: null 102: 814 Dt. 07.12.2018 & NTPC drawing no: 9962-001-TR-102-PVM-B-800.
03	21-01-2019	Sheet 4 – (min) included for all coats of sl. no. 3.	Included as per comments for CAT. II approval by NTPC 'Transmittal for comments on subject PANKI, EPC-SG painting scheme – Boiler Ref: null 102: 1132 Dt. 09.01.2019 & NTPC drawing no: 9962-001-TR-102-PVM-B-800.

Sl. No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
1 PS1Z3	Collector & Separator Vessels, temperature $>400^{\circ}\text{C}$ & $<500^{\circ}\text{C}$ (Except Internals), (Spec. Sl. No. 3, sheet 12 of 15, chapter 7, Vol.II) 04-321,323;	Blast cleaning to SA2 $\frac{1}{2}$ (Near white metal) with surface profile 35-50 μm	Inorganic Ethyl Zinc Silicate Primer DFT=60 μm per coat	1	--	--	--	--	GREY	60
2 PS5B	Collector & Separator Vessels internals and DD (Direct dispatch) items (threaded and machined surfaces only) 04-347;07-331,360,361,362,393; 08-911,912,913;09-304; 12-306,314,317,324,327,328,344,348,354,393; 17-304,306,319;19-306,307;21-602,605,700; 24-352,700,803,818,827,842;28-700; 32-700;35-190,700,701;36-700;39-700; 41-710;42-700,710;43-710;45-710; 47-710;48-019,700;65-710;67-710; Foundation materials: 35-010, 39-012	SSPC – SP3 Power Tool Cleaning	Rust Preventive Fluid to PR: CHEM: 09 – 04 DFT=20 μm per coat	2	--	--	--	--	--	40
3 PS19C5	Structural components, temperature $<120^{\circ}\text{C}$ (Spec. Sl. No. 1, sheet 12 of 15, chapter 7, vol. II) Buck stays 08-001,003,006,007,111,501,503,901, 910; Boiler supporting structures, Columns, Girders, Bracings 34-100,200,300,390,400,500;35-111,112, 35-121,122,130,140,141,150,211, 35-212,213,214,221,222,231,232,311,312, 35-321,322,331,332,341,342,351,352,361, 35-362,381,382,383,384,385,386,387,390, 35-441,442,443,444,445,446,447,451,452, 35-453,454,455,456,457,511,512,513,514,	Blast cleaning to SA2 $\frac{1}{2}$ (Near white metal) with surface profile 35-50 μm	Inorganic Ethyl Zinc Silicate Primer DFT=80 μm per coat. (min)	1	Epoxy Based MIO Pigmented Intermediate Coat DFT=120 μm per coat (min)	1	Aliphatic acrylic Polyurethane paint to DFT 30 μm (min)	2	Dark admiralty Grey Shade No: 632 of IS5	260

S. No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
3 PS19C5 (Contd.)	35-515,516,517,521,522,523,524,525,526,527 35-531,532,533,534,535,536,537,993,995; <u>Galleries, Stair-ways & inter connecting Walkways</u> 36-110,130,150,311,312,313,314,315,316,321, 36-322,323,324,325,326,331,332,333,334,335, 36-336,337,338,341,342,343,344,345,346,351, 352,353,354,355,356,361,362,363,364,365, 36-366,391,392,393,394,395,610,613,620,740; 38-210,299,310,381,410,510,610,611,710; <u>ID system structures.</u> 39-101,102,141,142,150,299,300,301,304, 39-305,306,993; <u>Duct supports</u> 48-015,115,145,205,225,235,265,345,355, 48-365,385,435,465,485,495,665;	Blast cleaning to SA2 ½ (Near white metal) with surface profile 35-50 μm	Inorganic Ethyl Zinc Silicate Primer DFT=80 μm per coat (min)	1	Epoxy Based MIO Pigmented Intermediate Coat DFT=120 μm per coat (min)	1	Aliphatic acrylic Polyurethane paint to DFT 30 μm (min)	2	Dark admiralty Grey Shade No: 632 of IS5	260
4 PS1Z3	<u>Components >95° C Insulated other than components in Sl.No.7 &9</u> <u>(Spec. Sl. No. 3, sheet 12 of 15, chapter 7, vol.II)</u> Ring Headers, Down Comers, Hot air Headers outside the gas path etc. 05-155,227,231,251,327,330,350; 07-102,110,125,217,223,231,232; 10-135,174,176,178,191,235,274,276,278, 10-283,284,285,291;12-178,850,852,900; 15-136,178,236,278;17-407,476,807; 18-001,002,010,701;19-701,702,903;21-600; 24-800, 805, 808,809,811,815,824,828, 836, 24-837,840; 42-020,030,065,070,120,128,150,154,158; 45-802,804,805; Cold air duct: 48-012,014,112,114; Tempering Air: 48-142,144;	Blast cleaning to SA2 ½ (Near white metal) with surface profile 35-50 μm	Inorganic Ethyl Zinc Silicate Primer DFT=60 μm per coat	1	--	--	--	--	GREY	60

Sl. No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate Coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
4 PS1Z3 (Contd.)	Hot Air: 48-018,202,204,207,208,212,214; 48-222,224,232,234,262,264,267,662,664,667; Flue Gas: 48-342,344,352,354,362,364,372,382,384,388, 48-389,432,434,462,464,482,484,492,494,498;	Blast cleaning to SA2 ½ (Near white metal) with surface profile 35-50 μm	Inorganic Ethyl Zinc Silicate Primer DFT=60 μm per coat	1	--	--	--	--	GREY	60
5 PS 9	<u>Components >95° C uninsulated other than components coming in gas path.</u> (bid resolutions annexure – I C (SG quality), Sl. No. 4.) <u>Temp: >95°C & <400°C</u> 20-511;24-807,820,860,865,867;42-200,300,358; Instrument tappings, doors: 48-200,915;	SSPC-SP3/ Power Tool Cleaning	Heat Resistant Aluminium Paint to IS 13183 Gr. II DFT=20 μm per coat	1	--	--	Heat Resistant Aluminium Paint to IS 13183 Gr. II 20 μm per coat	1	Aluminum	40
6 PS 10	<u>Components uninsulated other than components coming in gas path.</u> Temp: >400°C & <600°C (bid resolutions annexure – I C (SG quality), Sl. No. 4.) 09-003,004,005; 28-220;	SSPC-SP3/ Power Tool Cleaning	Heat Resistant Aluminium Paint to IS 13183 Gr. I DFT=20 μm per coat	1	--	--	Heat Resistant Aluminium Paint to IS 13183 Gr. I 20 μm per coat	1	Aluminum	40
7 PS2A	<u>Loose tubes, SH, RH & Eco. Coils (exposed to gas path)</u> 11-074,078,374,378,406,467,469,487,491,494,606, 11-608,684,694,716,717,718,767,768,769,787,791, 11-916,917,918,967,968,969,987,991;12-179,181, 12-184,187,368,405,514,524,544,554,600,800,803, 12-805,862,903,914,917,924,927,928,944,948,954, 12-968;16-201,202,203,270,278,379; 19-092,402,804,814,824,853,914,924;	SSPC – SP2 or SSPC – SP3 Hand tool / Power tool cleaning	Red Oxide Zinc Phosphate Dip coat primer to PR: CHEM: 09 – 03 DFT=35 μm per coat	2*	--	--	--	--	Red Oxide	70

*-Wherever dip painting is not possible, 2 coats of brush painting of Red oxide Zinc Phosphate primer to a coating thickness of 60 μ is also permitted in line with Sr.No.9.

Sl. No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate Coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
8 PS1A	Components uninsulated < 95° C –Other than components in Sl.No.3. (bid resolutions annexure – I C (SG quality), Sl. No. 2.) Miscellaneous and casing sheets 04-147,547; 07- 409,431,460,461,462,502,503,509,531,560; 12-506,906,907;17-919;21-601,604,606; 24-350,351,354,801,804,806, 24-810,817,825,826,835,841,855, 24-950,955,960;30-233,234;36-611,621; 39-302; 45-806; 95-088; 97-585;24-855; Spares: 41-997;42-997;43-997;45-997; 47-997;65-997;67-997; Fuel firing: 41-350,390,500; Steam blowing piping 42-001,002,005,010,046,152; 42-157; 43-004,104, 200; 45-200,801, 858; 47- 261,263,858; Duct plates, expansion joints: 48-911,912; \$ Handling Equipments: 99-099,100,300,400,502,600; Coal Feeding 65-736;67-204,272,276,283,801,802,803;95-088,089,091,485;96-186;97-585,591,592; Seal air ducting: 43-005, 105; Cold Air duct: 48-141;	SSPC-SP3/ Power Tool Cleaning	Red Oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744 DFT= 30 μm per coat	1	--	--	Synthetic Enamel paint (Long Oil Alkyd) to IS 2932 DFT= 20 μm per coat	2	Smoke Grey Shade No: 692 of IS5	70

\$ - Final Shade is Golden yellow for Under hung crane, Chain Pulley Block, Ratchet Lever and Trolley with hoist. Black shade for Hook.

Sl. No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
9 PS3	<u>Components >95° C coming in the gas path, Headers, Commissioning Spares & erection Materials etc.,</u> (bid resolutions annexure – I C (SG quality), Sl. No. 7.) 05-137,147; 06-400,401,431,434,437,441,444,447, 06-451,453,455,500,501,515,731,732,734,735, 06-737,741,744,745,747,751,752,753,755,759; 07-309,315,316,318,423,883,993; 10-182,183,184,185; 11-474;12-993; 17-174,504,506,900,903; 19-704,753,763,783,793,802,850,851,852; 20-998; 24-822,823,993; 30-103,105,211,215,219,223,224,235; 31-010,104; 32-010,210; 37-010; 42-858; 48-993; 65-200; 67-200; 96-193; 97-282,590; 99-501; 20-988; 21-987; 24-987,989; 41-988; 42-988;	SSPC-SP3/ Power Tool Cleaning	Red Oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744 DFT= 30 μm per coat	2	--	--	--	--	Red oxide	60
10 PS6	<u>Hand rails and posts, ladders / rungs & stairs (Spec. Cl. No. 17,2 –v) sheet 2 of 21, chapter 17, Vol.VI)</u> 34-820,850; 35-821,822,823,851; 36-820,851,852,853; 38-820,850; 39-820,850; <u>Floor Grills, guard plates (Spec. Sheet 8 of 15, chapter 7, Vol. II)</u> 34-810; 35 – 811,812; 36-811,812,813,814; 38 – 810; 39 – 810;	Acid pickling to SSPC-SP8	Hot dip Galvanizing to a coating weight of 610 g/m ² (minimum) and coating thickness of 80 microns (min). Immediately after galvanizing, post treatment chromating shall be applied. Refer Notes given below **							

Notes **: The Guard plates, Hood Ladders, Stringer channels, angles and plates shall be painted as per painting scheme prescribed in Sl. No: 03.

PAINTING SCHEME FOR VALVES

Sl.No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
11 @PS 9/10	<u>Cast carbon steel valves (Conventional)</u> <u>Cast alloy steel valves (Conventional)</u> <u>All API valves, QCNRV, SV & SRV Silencers,</u> 21-800,825, 24-885; Safety valves & ERV 21-850; 24-880,881;	SSPC-SP3/ Power Tool Cleaning	Heat Resistant Aluminium Paint to IS 13183 Gr. II/I DFT=20 μm per coat	1	--	--	Heat Resistant Aluminium Paint to IS 13183 Gr. II/I DFT=20 μm per coat	1	Aluminum	40
	Forged valves	Chemical cleaning	Phosphating to a coating weight of 1500 mg per Sq.ft.	--	--	--	--	--	--	--
1AS	<u>Soot Blower housing components, temperature <95 deg.C</u> 20-051,054,201,204,794,962;	SSPC-SP3/ Power Tool Cleaning	Red Oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744 DFT= 30 μm per coat	2	--	--	Syn. Enamel paint (Long Oil Alkyd) to IS 2932 DFT= 20 μm per coat	2	Verdigris Green Shade No. 280 of IS5	100
	HP / LP system	SSPC-SP3/ Power Tool Cleaning	Heat Resistant Aluminium Paint to IS 13183 Gr.I	2	--	--	--	--	--	40

@ Heat resistant aluminum paint to IS 13183 Gr.II shall be applied for temperature up to 400 deg.C, Gr. I shall be applied for temperature >400 deg.C and < 600 deg.C

Sl. No.	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat		Finish coat			Total DFT μm (min)
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
12 PS15	<u>For CLH & VLH*</u> PGs 07,08,12,17,19,21,24,45,47,48 & 80 07-402,403,405,505;12-517,528; 17-904,906 19-506,507,904,905, 906,907; 24-353; 48-206,395;	Blast cleaning to SA2 $\frac{1}{2}$ (Near white metal) with surface profile 35-50 μm	Epoxy zinc rich primer To IS 14589 Gr. II %VS=35, (min) DFT=40 microns per coat	1	--	--	Aliphatic acrylic Poly-urethane paint %VS=40.0 (min) DFT=30.0 microns per coat	1	Phirozi Blue Shade No. 176 of IS5	70
13 PS10B4	<u>Components > 95°C, un-insulated Fuel pipes</u> <u>(Spec. Sl. No. 7, sheet 12 of 15, chapter 7, Vol.II)</u> 47-200, 269;	Blast cleaning to SA2 $\frac{1}{2}$ (Near white metal) with surface profile 35-40 μm	Inorganic Ethyl Zinc Silicate Primer DFT=40 μm per coat	1	Heat Resistant Aluminium Paint to IS 13183 Gr. III DFT 20 μm per coat	1	Heat Resistant Aluminium Paint to IS 13183 Gr. III DFT 20 μm per coat	1	Aluminum	80
14 PS 1BE	All Columns below '0' level (embedded in concrete) PGs 34,35,36,38 39	SSPC-SP3/ Power Tool Cleaning	Chlorinated Rubber Based Zinc Phosphate primer DFT=50 μm per coat	1	--	--	--	--	Grey	50

*- For components other than CLH & VLH, painting scheme shall be as given in Sl. No. 8.

NOTES:

1. Rust Preventive Coating should be given on HSEFG Bolt and nut threads.

2. Machined surfaces and all retainers are to be applied with a coating of Temporary Rust Preventive oil.

3. 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.

4. Ground shade/ Colour of Finish paints & identification tag/Band for equipments, pipings pipe service, boiler supporting structures and other boiler components shall be followed as per doc. No. Vol-II Chapter 7 Painting.

5. PGMA's under Sub-Vendor items are not indicated. For all bought-out and sub-vendors items including PGMA's mentioned above falling under the scope of BHEL the same scheme as for main equipment as covered in this document shall be followed. For SCR system, vendor's painting scheme to be followed.

6. This painting Schemes is valid for only Customer No: U6/1728, UPRVUNL PANKI TPS - 1X660 MW.

7. No painting is required for Stainless Steel, non-ferrous & galvanized components.

08. Wherever inside surfaces of components under PGMA 48 – XXX & others, need protection till erection, two coats of Red-oxide zinc phosphate primer paint to IS12744 to a DFT of 60 microns shall be applied, after power tool cleaning.

09. The Temporary Rust Preventive coating that already been applied on any components, tubes, pipes etc., shall be visually inspected for good adherence. If the coating is intact, direct coating of alkyd based red oxide paints over the coating is permitted. In case, the coating has peeled off over a large area, then the coating is to be removed by suitable solvents / heating to 350 –400 °C for an hour before primer paint application –but, in this case, it should be ensured that the minimum surface cleanliness required for primer paint application shall be SSPC – SP2 (equivalent – Hand Tool cleaning).

10. In components, wherever plates / sheets of thickness less than or equal to 5 mm and rods of <25mm/tubes/drain pipes are used, power tool / hand tool cleaning to SSPC – SP3 / SP2 shall be followed and the painting shall be done as described in Sl.No.8.

11. For all commissioning components-erection materials (xx-993) two coats of Red oxide Zinc Phosphate Primer shall be applied to meet the temporary protection till erection, after power tool cleaning.

12. Touch-up paintings, making good any damaged shop painting and completing any unfinished portion of the shop coat shall be carried out as per clause applicable painting scheme.

13. All components covered under different PGMA's are to be painted. In case any component is left out, the same shall be deemed to be included under the relevant section based on paint logic approved.

14. For very small components like clamps, bent rods, small plates etc. which don't have feasible dimensions for blast cleaning, Sl.No.8 shall be followed.

15. For very small components with weldable primer at edges, the entire component shall be applied with weldable primer. Structural members having welded connections at site, relevant area can be painted with primer paint instead of Weldable primer.

16. Painting scheme for all temporary structures like 04-196, shall be PS 1AE i.e. 1 coat of Red oxide Zinc Phosphate primer (Alkyd Base) to IS 12744-DFT-30 μ and 2 coats of Synthetic Enamel paint (Long Oil Alkyd) to IS 2932-DFT-2X20 μ Shade Yellow –Shade No. 356 of IS 5- Total DFT 70 μ . These are to be cut & removed at site after erection. (It excludes components covered under Sr. No. 3 & 10 of description table).

17. For internal protection of Pipes, tubes, headers and other pressure parts, Volatile Corrosion Inhibitor (VCI) pellets shall be put (after sponge testing/ draining/ or drying) and subsequently end capped. The dosage of VCI pellets shall be approximately 100 g/ Cu.m. For tubes typically 4 – 5 tablets per end are to be put. For C & I items the dosage of self-indicating Silica Gel (colourless) shall be 250 g/ cu.m. (About 2 to 3 bags weighing approximately 100 grams each). VCI pellets shall not be used for stainless steel components and its composite associates.

18. All threaded components of spring assemblies and turnbuckles shall be galvanized and achromatized to 15 microns minimum thickness.

19. Soot blower components i.e Valve head assembly having high surface temperature (> 200 and <600 deg. C) shall be applied with protective coating as per PS9 (up to 400 deg.C) and PS10 (up to 600 deg.C)

20. Corner plate, sheet channel and fixing pins of PGMA 32-210 shall be painted as per scheme PS3 to total DFT of 60 microns.

21. It is mandatory that for finish coat each layer shall have a permanent DFT and free from any paint defects like sags, wrinkles etc. Total DFT of a component correspond to respective painting scheme has to be ensured and recorded by inspection agency as per QP.

22. For chequered plates having thickness $\leq 5\text{mm}$, surface preparation can be power tool cleaning to St3 and painting shall be in line with Sl. No. 8.

23. Handrails of PGMA under Sl. No. 3 need to be galvanized in line with scheme for handrails (i.e. Sl. No. 10).

24. Inside surfaces of fabricated structure (e.g. Box type column) shall be painted with two coats of red oxide primer paint during fit up stage.

25. Painting of bunker structures to be in line with painting scheme of supporting structures (Sl. No. 3).

26. Corrosivity environment C3 considered for painting scheme of structural components as per the requirement of technical specification.

Painting Scheme – Details for procurement & application purposes

Sl. No.	Generic nature of paint	Theoretical Covering Capacity Sq.m per Litre.	No. of pack	Volume solids, % (min)	DFT in microns per coat (min.)	Shade	Shade No. to IS5	Mode of appln.	Over coating interval, Hrs.
1	Epoxy Zinc rich primer to IS14589 Gr.II (latest)	8	2	35	40	Grey	--	Spray	24
2	Aliphatic acrylic polyurethane paint to IS 13213 (latest)	13	2	40	30	Phirozi – Blue/ Dark admiralty grey	176/ 632	Spray	24
3	Heat resistant Aluminium paint to IS 13183 Grade I/II (latest)	10	1	-	20	--	--	Brush / Spray	24
4	Red oxide zinc phosphate primer paint to IS 12744 (latest)	10	1	--	30	-	--	Brush / Spray	12
5	Red oxide Zinc Phosphate Dip coat primer paint to PR: CHEM: 09-03	10	1	--	35	--	---	Dip	12
6	Long oil alkyd synthetic enamel finish paint to IS2932 (latest)	17	1	35	20	Reqd. shade	Corrpdg. Shade no.	Brush / Spray	12
7	Temporary Rust preventive fluid to PR: CHE: 09 – 04	10	1	--	25	--	--	--	12
8	General purpose Aluminium paint to IS 2339 (latest)	10	2	--	20	Aluminum	--	Brush	12
9	Epoxy based polyamide cured MIO pigmented intermediate coat.	8	2	60	120	Brown	--	Spray	24
10	Inorganic ethyl zinc silicate primer to IS 14946 (%Zn on dry film= 75min)	8	2	60	80	Grey	--	Spray only	16
11	Chlorinated Rubber Based Zinc Phosphate Primer-Colour Grey	8	1	40	50	Grey	--	Brush / Spray	12

The covering capacity of paints specified is only approximate.

The paints and Rust Preventive fluid shall be procured from BHEL's approved suppliers.

Painting of Damaged Areas

(Areas where the paint has deteriorated badly by erosion and areas where the paint film has lost its adhesion and where the steel has rusted appreciably, should be repainted as follows)

Sl.No.	Components	Surface Prepa- ration	Primer coat		Intermediate coat		Finish coat			Total DFT μm
			Paint	No. of coats	Paint	No. of coats	Paint	No. of coats	Shade	
1	Paint damaged components fall under Sl.no: 3	Power tool cleaning to bare metal	Epoxy zinc rich primer to IS 14589 Grade II	2 T.DFT 80μ (min)	As given in scheme	1	As given in scheme	2	As given in scheme	As given in scheme