



**BHARAT HEAVY
ELECTRICALS LIMITED**
PIPING CENTRE, CHENNAI- 17
QUALITY ASSURANCE & CONTROL DEPT.

STANDARD PAINTING SCHEME FOR PIPING

QPNo: SPS 01

REV.NO: 04

DT.: 14.07.09

Sl. NO	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat			Finish coat			Total DFT Microns (Min.)	REMARKS
			Primer	No of coats & DFT	Paint	No of coats & DFT	Shade	Paint	No of coats & DFT	Shade		
1	2	3	4	5	6	7		9	10	11	12	13
1	Insulated Piping, components (MS / HRH / CRH / Aux Steam lines, ... IBD,CBD tanks)	SSPC-SP3/ Power Tool Cleaning	Red oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744	2 (30 microns per coat.)	----	----	----	----	----	----	60	
2	Uninsulated Piping, components (Spray Water / Condensate lines ..., Tanks & Vessels)	SSPC-SP3/ Power Tool Cleaning	Red oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744	1 (30 microns per coat.)	----	----	----	Synthetic enamel paint long oil alkyd to IS 2932	2 (20 Microns per Coat)	Smoke Grey Shade No 692 of IS 5	70	
3	Structures	SSPC-SP3/ Power Tool Cleaning	Red oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744	1 (30 microns per coat.)	----	----	----	Synthetic enamel paint long oil alkyd to IS 2932	2 (20 Microns per Coat)	Smoke Grey Shade No 692 of IS 5	70	
4	Hangers & Supports - (CLH)	Abrasive Blast cleaning to Sa 2 1/2 (35-50 microns)	Epoxy Zinc rich primer to IS 14589 Gr.II,% VS = 35 Min	1 (40 microns per coat)	----	----	----	Aliphatic Acrylic Polyurethane paint ,%VS = 40 min	1 (30 microns per coat)	Phirozi Blue Shade No.176 of IS 5	70	
5	Hangers & Supports - (VLH)	SSPC-SP3/ Power Tool Cleaning	Red oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744	1 (30 microns per coat.)	----	----	----	Synthetic enamel paint long oil alkyd to IS 2932	2 (20 Microns per Coat)	Smoke Grey Shade No 692 of IS 5	70	
6	Pipe Clamps.	SSPC-SP3/ Power Tool Cleaning	Red oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744	1 (30 microns per coat.)	----	----	----	Synthetic enamel paint long oil alkyd to IS 2932	2 (20 Microns per Coat)	Note 1	70	
7	Stainless steel / Galvanized items	No paint										

Note 1 - Smoke grey shade for Carbon Steel ; White shade for Alloy Steel Clamps.

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