
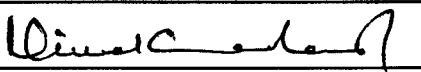
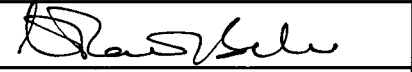


As Per P & ID the Primer coat is Red Oxide Zinc Chromate primer confirming to IS: 2074 is indicated, whereas in painting schedule Red Oxide Zinc Phosphate (alkyd base) confirming to IS: 12744 has been indicated .The P & ID is already approved in Category-A. However the drawing shall be revised & resubmitted for records.

 <b>BHARAT HEAVY ELECTRICALS LIMITED</b> PIPING CENTRE, CHENNAI- 17 QUALITY ASSURANCE & CONTROL DEPT.			<b>PAINTING SCHEME FOR LP PIPING</b> ( CW / ACW / ECW / Plant water, Air Piping, etc..., ) <b>PROJECT NAME : - KPCL BELLARY TPS - UNIT-III ( 1 X 700 MW)</b> <b>BHEL CUSTOMER Nos : 7149.</b>								QPNo: 7149:QPC:12 REV.NO: 02 Dt :25.06.2012		
SI. NO	PGMA / Description	Surface Preparation & Surface Profile	Primer coat		Intermediate coat			Finish coat			Total DFT Microns (Min.)	REMARKS	
			Primer	No of coats	Paint	No of coats	Shade	Paint	No of coats	Shade			
1	2	3	4	5	6	7	8	9	10	11	12	13	
1	(a) Internal Surface of Carbon steel piping for CW & ACW system	Blast Cleaning SSPC SP-10 SA 2½ (Refer Note 1)	POLY - URETHANE COATING OF 2000 MICRONS -DRY FILM THICKNESS. (Refer Note 2)									2000 Microns (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 ( Votage 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 CW --Buried Piping / Encased in concrete (For pipe dia- 1000 mm and above) (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 (over ground piping) of CW,ACW.( 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	2 (35 microns per coat )	Smoke Grey (Shade No. 692 of IS: 5 )	120 Microns		
4	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	2 (35 microns per coat )	Smoke Grey (Shade No. 692 of IS: 5 )	120 Microns		
5	Galvanised and Stainless steel Piping	No painting											
<b>Notes:</b> 1. Blast cleaning to near white metal to obtain roughness as per epoxy paint data sheet. 2. Application of Poly-Urethane coating shall be done as per manufacturer's data sheet / recommendation, meeting the thickness requirements as per this document. . 3. Witness by BHEL / BHEL nominated inspection agency.													
 PREPARED BY : VIVEKANANDA YELLU Sr.ENGR/QA			 APPROVED BY: G. PANNEER SELVAM. SDGM / QA			For Customer use :			TRACTEBEL Engineering GDF SVZ				
						Approval Category: 'A' DRAWING APPROVED AS SUBMITTED. RELEASE DISTRIBUTION PRINTS Transmittal No: P . 001794/TE-IN/BHEL/PC/004 Date: 14.08.2012			Name of person approving the drwg. / doc. Kamalakkannan M				