

BHARAT HEAVY ELECTRICALS LIMITED, HPVP UNIT, VISAKHAPATNAM
PAINTING SCHEDULE FOR ATMOSPHERIC COLUMN FEED HEATER FOR ONGC, HAZIRA
DOCUMENT NO:HTCS-7791-A-001, REV:A

S NO	DESCRIPTION	SURFACE PREPARATION & SURFACE PROFILE	PRIMER COAT		FINISH PAINT		TOTAL DFT (µm/min)
			PAINT	NO OF COATS/DFT	PAINT	NO OF COATS/DFT	
1	External surfaces of Heater Casing/Stack/Flue gas ducts and structural members in direct contact with hot surfaces;	SA2 ½ Blast cleaning to near white metal SSPC-SP-10;	F-9, Two component Inorganic zinc silicate coating with minimum 80% zinc content on dry film and suitable to 400 deg cent	1 65-75µ DFT/coat	F-12, Heat resistant silicone aluminium paint to IS 13183 Grade-2 up to 250 deg cent dry temperature.	2 20µ DFT/coat (2x20µ)	105-115µ
2	Heater inside surfaces in contact with Ceramic fibre/CF board. **	SA2 ½ Blast cleaning to near white metal SSPC-SP-10;	1 Coat of self priming epoxy phenolic primer	1 75µ DFT/coat	2 coats of Epoxy phenolic coating	2 75µ DFT/coat	225 µ**
3	All other Steel works						
a)	Ladders, Rungs & Railing, Vertical posts	Black	F-9, Two component Inorganic zinc silicate coating with minimum 80% zinc content on dry film and suitable to 400 deg cent	1 65-75µ DFT/coat	F-6A: Two Coats of Epoxy high build paint + F-2: One coat of Acrylic PU finish paint	2 100µ DFT/coat + 1	345-355 µ
b)	Hand rail, middle rail, Toe plate, Ladder vertical posts	Signal Red	+ P-6, One coat of Epoxy zinc phosphate primer	1 40µ DFT/coat		2 40µ DFT/coat	
c)	Steel columns, brackets, duct os, beams, bracings	Dark admiralty Gray					
4	Cold duct (In side)	SA2 ½ Blast cleaning to near white metal SSPC-SP-10;	F-9: One coat of inorganic zinc silicate primer.	1 65-75 µ DFT/Coat	F-6A: One Coats of poly amine cured high build epoxy paint + F-2: One coat of Acrylic Polyurethane top coat.	1 100µ DFT/coat + 1	215-225 µ

Notes:

- 1) All externally insulated surfaces to be provided with Primer coats only suitable for 400 degrees centigrade.
- 2) For fabricated box sections & Construction of similar nature, primer coat shall be given inside the surfaces before fabrication.
- 3)**SL No:2: Paint is in Refractory vendor Scope.

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