



Vendor  	<b>ABT 360 KT/Y PP PLANT Project</b>		Owner   سراج گستران رجال SERAJ GOSTARAN REJAL (سهامی خاص)
	Painting procedure		
	Vendor's Doc. No.: 23249-18 PPEC Doc. No.: L03-RE037-QC-PCJ-004	Rev.: 00	

**PPEC REQ. NO. : L03-RE037-QC-PCJ-004**

**ITEM NO. :**

**TOTAL PAGES : 08**

NO COMMENT

- **NO COMMENTS :** Documents/Drawings Were Checked By PPEC And Further Step Can Be Followed.
- **COMMENTED AS MARKED:** Documents/Drawings Were Checked By PPEC And Marked Comments Must Be Considered By Vendor. Vendor Shall Revise Documents/Drawing As Per Comments And The New Revision Of Documents/Drawings Must Be Revised Prior To Fabrication.
- **REJECTED:** Documents/Drawings Were Checked And It Is Not In Comply With Purchase Requisition Requirements.
- **ACCEPTABLE WITH COMMENTS:** Documents/Drawings Were Checked By PPEC And Comments Must Be Considered By Vendor. Fabrication Can Proceed Accordingly. Revised Document To Be Issued Either For Review Or As Final Certified. However PPEC Will Check The Revised Document For Proper Incorporation Of Comments.
- **NOT RETURNED:** Document Was Received For Information And Not Returned To The Vendor.


Name :  
Signature:  
Date :

Req. No. :



Seq. No.:

PPEC review & comments does not absolve the vendor of the responsibility for the corrected design, manufacturing and operation of the equipment

00	18-04-2025	Issue for Engineering	S.K.	S.K.	J.J.	
REV.	DATE	Description	Prepared by	Checked by	Approved by	Authorized by

Vendor	ABT 360 KT/Y PP PLANT		Contractor (DEC)	Owner
	Painting procedure			
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		FIRST ISSUE	SECOND ISSUE	THIRTH ISSUE	FOURTH ISSUE	FIFTH ISSUE	SIXTH ISSUE	
		REV.00	REV.01	REV.02	REV.03	REV.04	REV.05	
1		X						
2		X						
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## 1. References

Reference is made to the following documents.

- Offer 23249-COM

## 2. General

Our paint system is based on brush/roller application. Painting will be done by Airpack painting specialists. As offered, Airpack equipment will be painted according to the paint schedule below.

- Galvanized steel grating does not require painting.
- Zinc plated and stainless steel bolts do not require painting.
- Stainless steel equipment does not require painting.
- Instrumentation paint will be according manufacture standard.

## 3. Surface preparation



- All structures and equipment are designed and built-in accordance with ISO standards for high durability of the paint systems.
- All oil or grease shall be removed by washing the item to be painted with appropriate solvents or any other suitable means before beginning blast cleaning operations. This includes bolt holes in piping assemblies.
- Weld spatter and remains of temporary welds, deposits or surface defects shall be eliminated appropriately.
- Airpack shall protect all equipment that is not to be painted or liable to be affected by the presence of abrasives or paint. Special attention will be paid to avoid splashes of zinc paint on equipment made of austenitic steels.
- Surface preparation shall be inspected by Airpack Quality Control prior to application of paint.
- Airpack will not perform any mechanical changes to flanges and flange bolt holes and use the delivered flanges.

## 4. Blast cleaning of carbon steel

All surfaces to be coated, will be blast-cleaned according to:

- the grade of cleanliness, SA 2.5
- the surface profile, to be evaluated using ISO 8503-2
- as painting is Airpack standard, no blast clean record is available.

After blast-cleaning, all dust must be removed using a vacuum cleaner before applying the paint. All blast-cleaned surfaces shall be coated before the deterioration of the "grade of cleanliness". In any case, any surface that has been blast-cleaned shall be coated on the same day.

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## 5. Paint Application

Coating system will be from paint manufacturer Jotun.

The products shall be delivered in their original sealed packaging and stored in such conditions as to avoid their degradation. The packaging shall be clearly marked with the product description, the batch number, the fabrication date and the expiration date. Paint shall always be applied to surfaces that are dry, clean and degreased, for both coating on substrate and previous coat.

Painting work shall not proceed if:

- Temperature of the substrate is less than 3°C above the dew point;
- The relative humidity is more than 85% RH (90% RH for inorganic zinc silicates);
- The weather is rainy or foggy, except under shelter, and subject to verification of the atmospheric conditions;
- The minimum or maximum temperature of the ambient atmosphere and the substrate are outside the limits given in the product data sheets.

Application shall be by brush/roller. Stripe coats shall be applied by brush to all angles, corners, and all the welds with the same product than this to be applied on the surface to be painted. Different colours shall be used for all successive coats of the paint system. The finishing coat of the required colour shall be opaque to cover the shade of the undercoat. The thickness of each coat, including frequency shall be checked by Airpack. The values will be recorded and made available.

## 6. Painting report



A paint report as attached (see attachment 1) will be provided with a final coating check during FAT. Dry film thickness will be checked using a calibrated Quanix Automation 1311669. Calibration certificate will be made available during FAT.

## 7. Paint systems

For a detailed overview of each item please refer to below paint schedule.

## 8. Repair procedure



In case a deviation or non-conformity has been found, this will be repaired as per below procedure. Where the coating has been scratched off, flaked, or in any other way damaged as to hamper its protective function, the coating will be grinded off 5 cm around the defect and paint will be re-applied to conform with the painting system defined in this painting procedure. In case more than 5% of the equipment surface is not conform specifications, the entire part will be blasted and re-coated. Where blasting is not feasible, paint will be grinded off until the bare metal, after which it is re-coated.

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## Paint schedule

	MATERIAL	DESCRIPTION	SYSTEM	TDFT [ $\mu\text{m}$ ]	FINAL COLOR
C1	Cast iron	MAIN E-MOTOR	Mfr. std.	Mfr. std.	RAL-5015
C2	Carbon Steel	STRUCTURAL STEEL	1	320	RAL-6013
C3	Carbon Steel	VALVES	1	320	RAL-7038
C4	Carbon Steel	PRESSURE SAFETY VALVE COLD	1	320	RAL-1007
C5	Carbon Steel	PIPING COLD	1	320	RAL-7038
C6	Carbon Steel	PIPING COOLING WATER	1	320	RAL-7038
C7	Carbon Steel	PULSATION DAMPER COLD	1	320	RAL-7038
C8	Carbon Steel	MOISTURE SEPARATOR	1	320	RAL-7038
C11	Carbon Steel	COOLERS COLD	1	320	RAL-7038
C9	Carbon Steel	PULSATION DAMPER HOT	3	150	Metallic Gray
C10	Carbon Steel	COMPRESSOR HOT PARTS	3	150	Metallic Gray
C12	Carbon Steel	PRESSURE SAFETY VALVE HOT	3	150	Metallic Gray
C13	Carbon Steel	PIPING HOT	3	150	Metallic Gray
C14	Carbon Steel	LOCAL CONTROL PANEL*	Mfr. std.	Mfr. std.	RAL-7035
C15	Stainless Steel	GENERAL	Not painted	-	

\* Possibilities for painting of materials with ATEX certification is limited

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#### Paint system 1 (acc. ISO 12944-2 C5M)


- Structural steel & Carbon steel piping
- Surface preparation Sa 2½
- Temperatures up to 120°C

Layer	Type of paint	Make	DFT
1	epoxy mastic	Jotamastic Smart Pack	90 µm
2	epoxy mastic	Jotamastic Smart Pack	90 µm
3	epoxy mastic	Jotamastic Smart Pack	90 µm
4	Polyurethane	Hardtop XP	50 µm
		<b>Total DFT</b>	<b>320 µm</b>

#### Paint system 3 (acc. ISO 12944-2 C5M)

- High temperature / Carbon steel cycling use
- Surface preparation Sa 2½
- Temperatures -185 up to 650°C
- Available colours: Metallic Gray (matte)

Layer	Type of paint	Make	DFT
1	Multipolymeric Matrix coating	International Interbond 1202UCP	75 µm
2	Multipolymeric Matrix coating	International Interbond 1202UCP	75 µm
		<b>Total DFT</b>	<b>150 µm</b>

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## PAINT REPORT

Customer : Seraj Gostaran Rejal  
Purchase order number : 1402-SGE-088 Rev 01  
Equipment : 1x gas booster compressor package  
Equipment item no. : PK-6801  
Airpack ref. no. : 23249-COM  
Serial no. : T-2025-00821  
Test location : Zierikzee  
Test date : DD-MM-YYYY

Item : SKID  
Paint system : 1 & 3

### MEASUREMENTS According to Attachment #1

## Attachment #1 EXAMPLE

## Paint measurements of skid

## Paint system

Batch Number

Projectnummer 23249-COM

1st layer

Start date ....-....-.....

3rd layer		
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Material Temp.	Ambient temperatuur °C
10	10
20	20
30	30
40	40
50	50
60	60
70	70
80	80
90	90
100	100

5th layer		
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Specification layer Thickness	minimum of	...	μ
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Finish date \_\_\_\_\_

Measurements in  $\mu$

[illegible]

### Measurements in $\mu$ during FAT

[illegible]