



VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED

GROUP OF COMPANIES



SURFACE PREPARATION & PRIMER PAINT INSPECTION REPORT

CLIENT	Linde Engineering India Limited	PROJECT	Panipat_HGU		REPORT NO.	VE/Panipat_HGU/STR/SP/1			
WO/PO NO	2910A70M	PROCEDURE NO.	PRS/2		DATE	03/12/2024			
WEATHER CONDITION									
ACTIVITY	DATE PERFORMED	START				FINISH			
		SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C	SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C
Blasting / Surf. Prep.	03/12/2024	32	26	70.5	34.6	32.5	26.5	72	35
Primer Application	03/12/2024	34	27	72.5	35.2	33.6	28.1	74	35.9
SURFACE CONDITION									
ORIGINAL STATUS	NON COATED	METAL CONDITION		NON COATED	METAL RUST GRADE		B		
PAINT SYSTEM NO.	C4.01 STEEL STRUCTURE				BLASTING DATE		03/12/2024		
SURFACE PREPARATION									
BLASTING METHOD		AUTO BLAST	PREP. STANDARD		SA 2 1/2	ABRASIVE TYPE		MIXTURE OF GRIT & SHOT	
SURFACE PROFILE REQUIREMENT		40 - 65 microns	ACTUAL SURFACE PROFILE		45 microns				
DUST LEVEL		01	SALT TEST REQUIRED		Maximum 80 mg/m ²	SALT TEST READING		32 mg/m ²	
PRIMER COATING									
PRIMER PAINT/SHADE		Interzinc 22 / Gray	APP. METHOD		SPRAY	PRIMER DATE		03/12/2024	
PAINT MANUFACTURER		Akzonobel	DFT RANGE		50 Microns	TIME		16:00	
PAINT BATCH NO. (BASE)		AKS345	MANUFACTURE DATE		26/09/2024	SHELF LIFE		6 MONTH	
PAINT BATCH NO. (HARDNER)		AKB123							
SR. NO.	DRAWING NO.	ASSEMBLY NUMBER	GRID NUMBER	QTY(Nos)	Average DFT	ACC/REJ			
					PRIMER				
1	&VHS-(124SX-SS1)-N-ZP 2012.BE18 (EN)	124SX-S1-BE18	--	1	45,55,67,78,98,43,45	ACC			
NOTE	undefined								
	VISHAL QC				CLIENT / TPIA				
SIGN									
NAME	SHIVANG DIWAKAR								
DATE	03/12/2024								
VE-STR-16									