

Total Weight ~ 350 Kg

| Row | DESCRIPTION | WEIGHT(S) |
|-----|---------------------------|------------------|
| 5 | L 100*100*10 s137 | 100 |
| 4 | Pipe 8" s137 | 0.2 m |
| 3 | Flange Din1092 PN16 DN200 | 1 pcs |
| 2 | Hot rubber lining 6 mm | 5 m ² |
| 1 | Plate 6 mm S137 | 240 |

CLIENT : RAHBARAN FOOLAD ISFAHAN Co.

CONTRACTOR :

PROJECT TITLE : 860 KIPPY IRON ORE CONCENTRATOR PLANT

DRAWING TITLE :

Collecting Tank

| DRAWN | DESIG. | CHK'D. | APP. | DATE | REV. |
|-------|--------|--------|------|------|------|
| | | | | | |

DRAWING NUMBER : NO CONSTRUCTION PERMITTED UNLESS DWG. APPROVED

DRAWING SIZE : UNIT : mm SCALE : SHEET : 8000

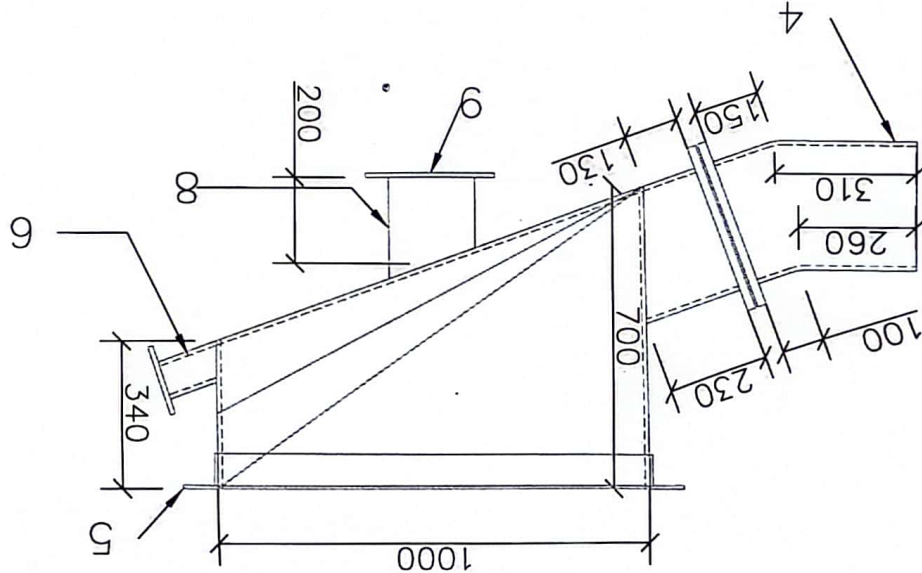
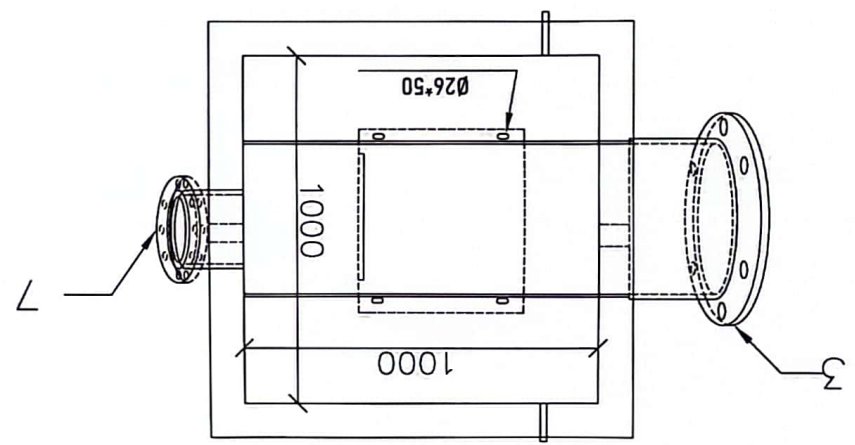
ستون درختی - ST37 - 6mm فولاد سرد

سطح داخلی را با گریز گریم با ضخامت 6mm
 * سطح خارجی رنگ اپوکسی (رنگ لایه 180 میکرون)

[Handwritten Signature]

RAL7039

Handwritten signature



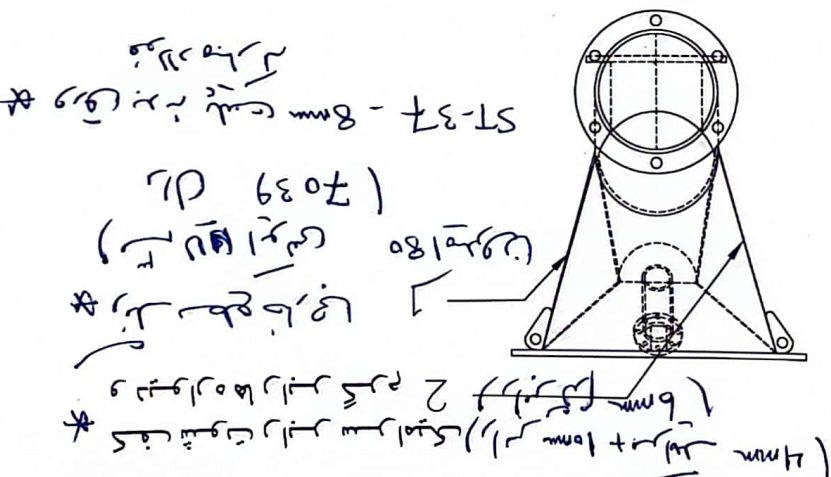
DRAWING NUMBER: DRAWING-TITLE: 250 KTPY IRON ORE CONCENTRATE PLANT
 NO CONSTRUCTION PERMITTED UNLESS DWG. APPROVED
 DRAWING TITLE: Inlet chute for ball mill




| | | |
|--|----------------|-----------------|
| UNIT: mm | SCALE: SCALE | SHEET: SHEET |
| DRAWING NUMBER: | DRAWING-TITLE: | DRAWING NUMBER: |
| NO CONSTRUCTION PERMITTED UNLESS DWG. APPROVED | | |
| DRAWN | DESIGN | CHECKD |
| DATE | DATE | DATE |
| APP. | APP. | APP. |
| REV 02 | REV | REV |

CONTRACTOR: RAHBARAN FOOLAD ISFAHAN CO.
 CLIENT:

| Row | DESCRIPTION | WEIGHT(kg) |
|-----|------------------------------|------------------|
| 1 | PL 8 mm St 37 | 240 |
| 2 | Rubber lining&rubber ceramic | 3 m ² |
| 3 | Flange EN1092 PN16 DN300 | 1 pcs |
| 4 | Pipe 12" st37 | 0.7 m |
| 5 | L 80*80*8 st37 | 50 |
| 6 | Pipe 4" st37 | 0.4 m |
| 7 | Flange EN1092 PN16 DN100 | 1 pcs |
| 8 | Profile 400*400*10 | 40 |
| 9 | PL 550*550*20 St 37 | 50 |

Total Weight ~ 400 Kg



| | | |
|---|--|---|
| Client / Owner  راهبران فولاد اصفهان | 250KTPY Iron Ore Concentrate Plant (Line 1) | MC/ Consultant:   |
| DOCUMENT TRANSMITAL | | |

| | | |
|----|---|---|
| To | Company Name: Rahbaran foolad isfahan Company Address: tooka buliding/Estifen alley/ nazar gharbi st/isfahan Tel. No.: 98-8175794161 Fax. No.: 98-3136240835 | Transmittal No.: P1-KCE-RFI-T-0254 Date of Issue : 1402/05/30 Contractor Ref. No.: 00/002/1000 |
|----|---|---|

| | |
|-------------|-------------|
| Attention : | MR. M.SALEH |
| CC : | |
| CC : | |

| | | |
|-------------|---|--|
| Project : | 250KTPY Iron Ore Concentrate Plant (Line 1) | |
| Discipline: | <input checked="" type="checkbox"/> Mechanical <input type="checkbox"/> Original <input type="checkbox"/> Print/Copies <input type="checkbox"/> CD/DVD <input type="checkbox"/> Email/FTP | |

| Item No | Document No | Rev. | Document Title | DOC/DWG/Class | Status Code | DOC/DWG Size | Total Pages | Previous Letter / Trans. No. |
|---------|--------------------------|------|------------------------|---------------|-------------|--------------|-------------|------------------------------|
| 1 | P1-KCE-M14-60AA00-01-B01 | 01 | Painting Specification | FC | IFC | DOC | 16 | - |
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Tel: 98-44806070
 Fax: 9821-44808166
 Email: rfisfahan@kce.ir

Project Manager:


| | | | | | |
|--------------------------------|--|-----------------------|--|----------------------------|--|
| Document Class: | | R: Review | | I: Information | |
| A: Approval | | | | | |
| Status Code: | | | | | |
| AFC: Approved For Construction | | ASB: As-Built | | | |
| IFA: Issue For Approval | | IFR: Issue For Review | | IFI: Issue For Information | |
| Received by: | | Date: | | | |



شرکت مهندسين مشاور کاوشگران

250 KTPY Iron Ore Concentrate Plant

Painting Specification

کد مدرک : P1-KCE-M14-60AA00-01-B01



راهبران فولاد اصفهان

Painting Specification

ISSUED FOR Construction

| | | | | |
|-----|------------|-------------|------------|-----------|
| 00 | 1402/05/29 | A.Neshati | A.Neshati | A.Neshati |
| REV | DATE | Prepared by | Checked By | APPROVED |



Rahbaran Foolad Isfahan



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1. Introduction

The project is **Rahbaran Foolad Isfahan** Project in the center part of Iran. Construction items include grinding, magnetic separation, classification, dewatering tailing via thickener, filerpress, dewatering concentrate via drum filter.

1.1 Site conditions

General Characteristics and

| | | | | |
|-------------------------------|--|---------------------------------|------------------------------|---------------------------------|
| 1- Location | Latitude | Longitude | Elevation (m) | |
| | N 30°48' 14.7" | E 53°33' 42" | 1495 | |
| | Abarkooh city in Yazd province in central part of Iran | | | |
| 2-Temperature | Max. Recoded in Summer (°C) | Max. Considered for design (°C) | Min. Recorded in Winter (°C) | Min. Considered for design (°C) |
| | 43 | 43 | -10 | -7 to -10 |
| 3-Rainfall | | | 4-Snow | |
| Average yearly/Max daily (mm) | | 60/36 | Snow Load (KN/m2) | ---- (0.5-1) |
| 5- Humidity | | 6- Pressure | | |
| Ave. Relative (%) | Max. Relative (%) | Barometric Pressure (mbar) | | --- |
| 10-50 | 69 | | | |
| 7- Wind | Design wind velocity (m/sec) | | 26-40 (100) | |

2. Principles

2.1 Field of Application

Instruction which will be used for local supply defines specification for corrosion protection of machines, pipes, pipelines, vessels, electrical equipment and steel structure components **unless otherwise** specified in drawings or other manufacturing documents.



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2.2 Fundamental Definitions

- All Surfaces in steel (except high grade steel) of machine or structural steel elements shall be provided with a coat of paint and all other unpainted component in steel (except high grade steel) shall be provided with preserving agent
- All colors shall be the glossy type
- All parts which have to remain without coat shall be preserved with TECTYL 502-C or equivalent products, with the same specification, after surface cleaning; drawing indication is required



2.3 Exceptions

Unless otherwise specified the following surfaces are not to be coated.

- **Anchor plates and anchor bolts** for casting in concrete are blasted only to remove rolling skin and annealing scale from surface. These parts are neither coated nor preserved to achieve better adhesion to the foundation. Unless those sections, be out of the foundation and exposed, which will be provided with a coat of “ZINGA”
- All parts in **stainless steel and Acid-resistant** steels are neither coated nor preserved.
- Structure made of aluminum, brass, bronze, copper, stainless and galvanized steel, other metallic materials corrosion resistant, rubber components and insulating items in general, threads of screws, tie rods, mechanical items, lubricated components, sliding and rolling parts, lubricators, insulated areas, etc.

2.4 Indication in Drawings and Other Manufacturer Documents

Apart from the basic exceptions described in item 0, indications in drawings and other manufacturing documents are required when deviations from the standard specifications given in painting specifications groups, specification of painting for each layer, are required for functional reasons.

| | | |
|---|---------------------------------------|--|
|  <p>AFICO راہبران فولاد اصفهان</p> | <p>Rahbaran Foolad Isfahan</p> |  |
| <p>250 KTPY Iron Ore Concentrate Plant of Rahbaran Foolad Isfahan</p> | <p>Painting Specification</p> | <p>Doc No: P1-KCE-M14-60AA00-01-B01 Rev: 01 Date:1402/05/29 Page: 6 of 16</p> |

3. Surface Condition

3.1 Surface Preparation

All Surfaces to be provided with coat or preserving agent shall be cleared of annealing colors, rust, slag, rolling skin, mill scale, dirt, dust, oil, grease, old paint, cooling lubricants, etc.

Blasting operation shall be done at a surface temperature above dew points.

3.2 Preparation by Blasting

Preparation grade is required according to the contract. This abbreviate used should be clean and free of oil, grease and salt.

The following conditions are required according to DIN EN ISO 12944-4.

- **Sa 2 ½**; Scale, rust and coats have been removed to such an extent that reminders on the steel surface are visible only as spots of slight shading due to discoloring of pores.

3.3 Preparation by Manual De-Rusting

Preparation grade St3 is required for machine components, which cannot be blasted due to their sizes, or weights, for example mill housing.

The following conditions are required according to DIN EN ISO 12944-4.

- **St 3**; loose scale or coats have been removed. Rust has been removed to such an extent that the steel surface after subsequent cleaning shows a clear luster given by the metal itself.

4. Coating

4.1 Basic Specifications

- Upon preparation of the steel substrate, the first coat shall be applied **within 6 hours** to prevent new formation of rust and this first coat prevents of cooling during machining



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- Depending on the degree of damage to the primer by finish-machining or welding, the first coat is either touched up or newly applied
- The weld seam area shall be cleaned with particular care to remove the alkaline ore acid filler metal constituents and to avoid their destructive effects
- The second coat is applied upon completion of workshop assembly or functional or acceptance testing, immediately before application of the final coat. It shall be ensured that the surface to be coated are free of grease, oil, dirt and dust
- As a rule, the top coat is applied only upon proper application on the first and second coats stated in painting specification and on completion of assembling or functional or acceptance testing of the machine

4.2 Painting Application

- Paint shall be applied by complying with the painting specification shown in section 4.4.
- Paint to be applied by airless spray methods in order to obtain an evenly coating on 100% of the surface to be painted.
- Paint application shall be stopped in the following events;
 - By ambient temperature less than $+5^{\circ}\text{c}$ and more than $+45^{\circ}\text{c}$
 - By a support temperature of more than $+55^{\circ}\text{c}$
 - By humidity of more than 80%
 - In case of rain, fog and smog
 - Substrate is wet or humid
 - Any case when the **dew point** doesn't exceed the substrate temperature of at least 3°c
- Measure shall be taken for the wet paint freshly applied to be set to dry in case of inclement weather. The areas damaged because of the weather inclemency to be



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removed, surface to be prepared once again and then re-painted identical to the undamaged areas

- Each coat to be applied as a continuous film, evenly thick and with no pores
- Each coat of paint to be enough dry and/or hardened before applying the subsequent coats, so as the coat will be evenly. It is also to understand that the thickness indicated for each coat of every cycle are minimum values to be kept with, and therefore the applier shall take care to keep thickness within maximum values so as to guarantee a complete drying of the coat also deeply as well as the full evaporation of solvents. For all what above said the instruction of manufacturer shall be respected and looking jointly at the weather as well.
- Angles and corners should be coated carefully with the same coating system

4.3 Equipment and Application

- The applier shall adopt the most suitable painting equipment depending on the paint to be applied, coat thickness and on the support on which paint will be applied
- For any other rust preventing paint spray application allowed only on a bare sand blasted support (SA 2 ½) and on a support sandblasted to a lower degree or brushed application usually made by paintbrush.
- For all priming products application by paint roller strictly not allowed
- The applier shall employ skilled labor familiar with any application methods being used
- All other consideration for coating, storage, handling, suitable environmental condition, safety and hazardous comments are stated in the paint manufacturer's specification

4.4 Paint Specification

4.4.1 Specification No.1



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This specification shall be used for general purposes to prevent surfaces against corrosion. All machinery, steel structure components, pipelines and vessels in steel are included in this category.

| Process | Description | Treatment and Paint Name | Painting Method | Minimum Dry Film Thickness (µm) | Interval | | |
|---------------|----------------------|---|----------------------------|---------------------------------|--------------|-------------|---|
| | | | | | Min. (Hours) | Max. (Days) | |
| Shop Painting | Surface preparation | Blast Cleaning (SIS SA 2 ½) | | | | | |
| | 1 st Coat | Zinc Rich Epoxy Primer | Airless Spray ¹ | 50-70 | 16 | 90 | |
| | 2 nd Coat | Epoxy Mid Coat | Airless Spray | 50 | 16 | 30 | |
| | 3 rd Coat | Interior | Epoxy Finish Coat | Airless Spray | 50 | 16 | - |
| | | Exterior | PU Finish Coat | Airless Spray | 50 | 16 | - |
| Site Painting | Surface Preparation | Power Tool Cleaning (SIS St 3) For damaged area, at site welding area and other areas to be painted at site. Rust preventive material for site welding area shall be completely removed | | | | | |
| | Touching Up | Same as Shop painting excepting shop primer | | | | | |
| | | | | Total D.F.T. | 160 ± 10 | | |

¹ Painting method is stated in the paint manufacturer's specification while here airless spray is suggested.



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4.4.2 Specification No.2

This specification shall be used for conveyors, chutes, ducts and bins, which are stated in dusty environments.

| Process | Description | Treatment and Paint Name | Painting Method | Minimum Dry Film Thickness (μm) | Interval | |
|------------------|------------------------|---|-------------------------------|---|---------------------|----------------|
| | | | | | Min. (Hour s) | Max. (Days) |
| Shop Painting | Surface preparation | Blast Cleaning (SIS SA 2 ½) | | | | |
| | 1 st Coat | Zinc Rich Epoxy Primer | Airless Spray ² | 50-70 | 16 | 90 |
| | 2 nd Coat | Epoxy Mid- Coat | Airless Spray | 50 | 16 | 30 |
| | 3 rd Coat | Poly Urethane | Airless Spray | 50 | 16 | - |
| Site Painting | Surface Preparation | Power Tool Cleaning (SIS St 3) For damaged area, at site welding area and other areas to be painted at site. Rust preventive material for site welding area shall be completely removed | | | | |
| | Touching Up | Same as Shop painting excepting shop primer | | | | |
| | | | | Total D.F.T. | 160 ± 10 | |

² Painting method is stated in the paint manufacturer's specification while here airless spray is suggested



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5. Color Coding

5.1 Structure Components

| Item No. | Application | Specification No. | RAL Code | Color | Remark |
|----------|--|-------------------|----------|-------------------|---|
| 1 | Steel structure, Profiles & Purlins | 1 | 5010 | Gentian Blue | - |
| 2 | Galleries, Trestle & Racks | 1 | 5010 | Gentian Blue | - |
| 3 | Supporting Structure | 1 | 5010 | Gentian Blue | - |
| 4 | Handrail & Ladder | 1 | 1017 | Saffron Yellow | - |
| 5 | Maintenance Deck & Stairs | 1 | 5010 | Gentian Blue | Step walkway shall be provided with galvanized gratings |
| 6 | Corrugated plats and covers | 1 | 5010 | Gentian Blue | - |



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5.2 Mechanical Equipment

| Item No. | Application | Specification No. | RAL Code | Color | Remark |
|----------|--|-------------------|----------|----------------|-------------------------------|
| 1 | General Machinery & Motors | 1 | 6017 | May Green | - |
| 2 | Indoor Crane | 1 | 1021 | Rape Yellow | - |
| 3 | Outdoor Crane | 1 | 6017 | May Green | - |
| 4 | Equipment handrails | 1 | 1017 | Saffron Yellow | - |
| 5 | Dust Collection Fans | 1 | 6017 | May Green | - |
| 6 | Bag Filter | 1 | 7039 | Quartz Grey | - |
| 7 | Slurry Collector, distributor and Tank | 1 | 7039 | Quartz Grey | Only for dry (outer) surfaces |
| 8 | Water Tank and Basin | 1 | 7039 | Quartz Grey | Only for dry (outer) surfaces |
| 9 | Conveyors Mechanical Parts | 2 | 7039 | Quartz Grey | - |
| 10 | Chute, Duct & Bin | 2 | 7039 | Quartz Grey | - |
| 11 | Gates and valves | 1 | 6017 | May Green | - |



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5.3 Electrical & IC Equipment

| Item No. | Application | Specification No. | RAL Code | Color | Remark |
|----------|--|---------------------|----------|----------------|----------------------------|
| 1 | Power Panel Outer/Inner | 1 | 7032 | Pebble Grey | - |
| 2 | Control Panel Outer/Inner | 1 | 7032 | Pebble Grey | - |
| 3 | DC/AC Motors, Generators & Gear motors | Supplier's Standard | | | - |
| 4 | Transformers | Supplier's Standard | | | - |
| 5 | Pull Boxes | 1 | 7001 | Silver Grey | - |
| 6 | Control Desk | 1 | 7032 | Pebble Grey | - |
| 7 | Instrument Frame | 1 | 7032 | Pebble Grey | - |
| 8 | Wire Conduit duct | 1 | 7032 | Pebble Grey | Except Galvanized ducts |

5.4 Fluids

| Item No. | Application | Specification No. | RAL Code | Color | Remark |
|----------|-----------------------|-------------------|----------|------------|--------|
| 1 | Row Water & Makeup | 1 | 5012 | Light Blue | - |



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| 2 | Industrial & Service Water | 1 | 6002 | Leaf Green | - |
| 3 | Potable Water | 1 | 6002 | Leaf Green | - |
| 4 | Fire Fighting Water | 1 | 3011 | Brown Red | - |
| 5 | Concentrate Slurry Pipelines | 1 | 5021 | Water Blue | With Green Bands |
| 6 | Tail Pipelines | 1 | 9007 | Grey Aluminum | With Green Bands |
| 7 | Tail Slurry Pipelines | 1 | 7016 | Anthracite Grey | With Green Bands |
| 8 | Air Pipelines | 1 | 5013 | Cobalt Blue | - |
| 9 | Hydraulic Lines | 1 | 1019 | Grey Beige | - |
| 10 | Lubricating Oil Pipelines | 1 | 8001 | Brown | - |
| 11 | Flocculent & Additive Pipelines | 1 | 1012 | Lemon Yellow | - |
| 12 | HVAC | 1 | 7032 | Pebble Grey | - |
| 13 | Grease | 1 | 1003 | Signal Yellow | - |



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| | | | | | |
|----|------------------------------|---------------------|------|----------------|---|
| 14 | Dust Collection Pipelines | 1 | 7032 | Pebble Grey | - |
| 15 | Air Compressor | Supplier's Standard | | | - |
| 16 | Main Pumps | Supplier's Standard | | | - |
| 17 | Special Valves | Supplier's Standard | | | - |

6. Inspection and Testing

- Required tests and inspection steps will be considered according to ITP for each equipment.
- The sub-contractor shall furnish to the purchaser test certificates, inspection and test report to confirm compliance to the standards specified such as profile, film painting measurement and adhesion test (if necessary)
- Paint manufacturer lab test certificates to show the quality of materials used in the paint shall be furnished (Mechanical, Physical, chemical and corrosion resistivity)
- The inspection and test reports shall include grade of surface preparation, paint system adopted, name of paint manufacturer, dry film thickness of each coat as measured.
- Following items shall be considered due to inspection of rubber sheeting
 - The sheeting shall be free from blisters and any other imperfections that would affect its performance
 - Tolerances on the nominal thickness shall be within $\pm 5\%$ for raw sheet and $\pm 10\%$ for finished product



250 KTPY IRON ORE CONCENTRATE PLANT OF
RAHBARAN FOOLAD ISFAHAN



Comment / Reply Sheet

| | | | |
|---------------------|-------|----------------------|-------------------|
| To: | RFI | Ref Transmittal No.: | PI-KCE-RFI-T-0254 |
| CC: | KCE | Transmittal Date.: | 1402/05/30 |
| Comment Sheet No.: | | Reply Sheet No.: | |
| Comment Sheet Date: | | Reply Sheet Date: | |
| Page: | | | |

| Item | Doc. Number | Doc. Description | Doc. Rev. | Purpose of Issue | Comment Status |
|------|--------------------------|------------------------|-----------|------------------|----------------|
| 1 | P1-KCE-M14-60AA00-01-B01 | Painting Specification | 01 | IFC | |

| | | |
|------|-----------------------------|------------------|
| Item | Client / Consultant Comment | Consultant Reply |
| 1 | | |

| Comment Sheet | Reply Sheet | Recipient Acknowledgment: |
|--------------------|----------------|---------------------------|
| Prepared By: | Prepared By: | |
| Checked By: | Confirmed By: | |
| Approved By: | Authorized By: | Date of Receipt: |

Comment Status: COM: Commented
APP: Approved
CAN: Cancelled

REJ: Rejected
AWC: Approved with Comment

AFD: Approved for Design
NOC: No Comment

AFD: Approved for Design
NOC: No Comment