

Annexure-B

Note: Tanks for acid cleaning, neutralizing treatment and water rinsing should be made of stainless steel plates with FRP lining.

## 3) Handling, Storage and Transportation

- b) Walking on the stainless steel surface should be avoided, where unavoidable, personal should wear clean shoe covers each time. Kraft paper, blotting paper, paper board or flannel or other protective material should be laid over areas where personals are required to walk. Supplier needs to make all these arrangements.
- c) Shearing tables, press brakes, layout stand and other carbon steel work surfaces should be covered with clean kraft paper, blotting paper, paper board or flannel or other protective material to reduce the contact with carbon steel.
- d) Hand tools, brushes, molding tools and other tools and supplies required for fabrication should be segregated from similar items used in the fabrication of carbon steel equipment and should be restricted to use on one material. Tools and supplies used with other materials should not be brought into the SS fabrication area.
- e) Grinding wheels and sanding material should not contain iron, iron oxide, zinc or other undesirable materials that may cause contamination on the surface. Grinding wheels and sanding material and wire brushes previously used on other metals should not be used on stainless steel. Wire brushes should of stainless steel which is equal in corrosion resistance to the material being worked on.
- f) Measures to protect the cleaned surfaces should be taken as soon as final cleaning is completed and should be maintained during all subsequent fabrication, inspection, storage and installation. The basic guidelines are as follows:
  - g) Do not remove wrappings and seals from incoming materials that is IR-DRDO retention tanks until they are at use site, ready to be used or installed.
  - h) Do not store the finished cleaned materials and components stored directly on the ground or floor and do not permit these to come in contact with galvanized or carbon steels, Zinc, lead Brass etc.
  - i) Do not use carbon or galvanized steel wire for bundling and galvanized steel identification tags.

Prepared By



Agreed By

