केन्द्रीय रेल विद्युतीकरण संगठन
Central Organisation for Railway Electrification
1-Nawab Yusuf Road, Civil Lines, Prayagraj (UP)-211001
Email: dyceemp@gmail.com

No. ELCORE/MP/Vendor app process

Date: 01.12.2021

ED (QA)
RITES Ltd.
ROC-1
Gurgaon-122001

Sub: Modification in the instruction for CORE approved re rollers regarding "IR" marking.

Ref: (i) This office letter No ELCORE/MP/Vendor confidential/2018 dated 10.12.2020

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Vide ref under ref (i), instructions for marking, weighment & Inspection process for Galvanised Steel structure (GSS) were issued, wherein re-rollers are required to emboss/engrave following marking during rolling:

(i) Name/Code of manufacture,
(ii) Section classification code and size,
(iii) Name of purchaser i.e. **"IR"**

Various references have been received by the CORE approved re rollers for review of above instruction and allowing the marking of **"IR"** through engraving/punching after rerolling for smaller quantities of purchase orders.

The matter has been examined after detailed discussion with CORE approved re rollers and it has been decided by the competent authority that for **smaller qty of purchase order say up to 50 MT, punching/engraving may be permitted , only for "IR", after the rolling.**

DA: As above.

02.12.2021

(Kalyan Singh)
Dy. Chief Electrical Engineer (MP)
For CAO/CORE/Prayagraj

Copy to:

i. **All CPDs/RE - For inf. and necessary action please.**
ii. **GGM (Insp.) RITES Ltd., (ER, WR, SR, NR & CR) - For inf and necessary action please.**

3394113/2024/O/o CAO/CORE/PRYJ

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केन्द्रीय रेल विद्युतीकरण संगठन
Central Organisation for Railway Electrification
1-Nawab Yusuf Road, Civil Lines, Prayagraj -211001
Email: ceehq.core@gmail.com
cee_mp@core.railnet.gov.in

No. ELCORE/MP/Vendor/Confidential/2018 Date: 10.12.2020

Executive Director/QA
RITES LTD
New Delhi

Sub: ***Modified Instruction for Marking, Weighment & Inspection process for Galvanised Steel Structure (GSS)***

Ref: i) Instructions for marking, weighment & inspection process for Galvanised steel Structure (GSS) issued vide CORE even letter, dtd. 11/11/2020.
ii) Representations received from Re-rollers &Fabricators.
iii) Video conference held with members of IEEMA on 09/12/2020 along with CORE & M/s RITES.

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Reference above, various representations were received regarding difficulties being faced in implementation of revised instructions for marking, weighment & inspection process for Galvanised steel structure (GSS) issued vide letter under ref (i).

A Video Conference was also held with members of IEEMA in presence of CORE & M/s RITES on dtd. 09/12/2020 to discuss the technical issues in implementation of revised instructions.

As per the feedback received from stake holders, the marking, weighment and inspection process have been simplified and revised as under:

		Existing	Modified
a	**Stage Inspection of black steel:**		
	i	Stage inspection shall be carried out at re-roller premises as per the IS/RDSO specifications and drawings and the extant guidelines issued by railway board.	Stage inspection shall be carried out at re-roller premises as per the IS/RDSO specifications and drawings and the extant guidelines issued by railway board. However, rerolled sections purchased from SAIL/IISCO/TISCO/RINL may be inspected at fabricator's works.
	ii	Re-roller's marking – Following shall be embossed/engraved on each section at every one to three (1-3) mtrs during rolling in minimum 20 mm figure letters. ❖ Name of manufacturer ❖ Month and year of manufacture ❖ Name of purchaser –IR ❖ Grade of material and section classification code and size (e.g. MC-150)	Re-roller's marking – Following shall be embossed/engraved on each section at least at one suitable location during rolling in minimum 16-20 mm figure letters. Marking should be such that it is clearly visible after galvanizing. ❖ Name/Code of manufacturer ❖ Name of purchaser –IR ❖ Section classification code and size. **(XXXXX MC-150 IR)**

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	iii	RITES' stamping only by (punching /engraving) near one of the re-rollers' marking for easy access and durability/longevity is to be done after stage inspection.	RITES stamping only by (punching /engraving) near one of the re-rollers' marking for easy access and durability/longevity is to be done after stage inspection. In case of smaller sections like angles, offered in bundles, RITES stamping is to be done at exposed portion of random samples.
b	**Final Inspection**		
	i	Final inspection shall be carried out at fabricators premises as per the RDSO specification & drawing and the extant guidelines issued by Railway board.	Final inspection shall be carried out at fabricators premises as per the RDSO specification & drawing and the extant guidelines issued by Railway board.
	ii	In addition to the embossing/engraving of fabricator's name/code (to be issued by CORE) and month & year of manufacturing as per the RDSO & Railway Board guidelines, the following marking shall be used on final structures weighing more than 50 Kgs. ***On each structure a Name Plate bearing Name of the Purchaser (e.g. KEC/L&T/KPTL etc), Name of the Fabricator, Purchase Order / LOA No, actual weight of the structure and its' unique serial number (e.g. YYMM0001) to be riveted at the location mentioned in the drawing, to be issued by RDSO subsequently.*** ***Name Plate should be as per the TI Specification no. ETI /OHE /33A (12/97) Rev.8 and Riveting is to be done with hollow rivet in cold condition using same material i.e. plate.***	In addition to the embossing/engraving of fabricator's Name/Code & year of manufacturing as per the RDSO & Railway Board guidelines, the following marking shall be used on final structures weighing more than 50 Kgs. ***On each structure a Name Plate bearing Manufacturer's Name/Code, OHE Contractor's name (e.g. KEC/L&T/KPTL etc), Group/Section name, Actual weight of the galvanised steel structure and its' unique Serial No.- YYMM0001 to be riveted at the suitable location preferably in the middle of the structure.*** ***Name Plate should be as per the RDSO Drawing no. TI/DRG/CIV/NAME PLATE/RDSO/00001/20/0 dtd: 25.11.2020.*** ***Note:*** *May please note that actual weight of galvanised structure has to be written in place of standard weight as mentioned in drg.*
	iii	RITES stamping only by punching/engraving along with RITES Hologram shall be put on the name plate.	RITES stamping only by punching/engraving along with RITES Hologram shall be put on the name plate.
	iv	Stock Register for each section shall be maintained by the Fabricator which will be reviewed by RITES IE during the course of inspection.	Stock Register for each section shall be maintained by the Fabricator which will be reviewed by RITES IE during the course of inspection.
c	**Weighment**		
	i	Issuance of weight of black steel structure as well as galvanised structures on each of the drawings will follow.	Weight of Galvanisation on the structures is being issued by RDSO.

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	ii	For the purpose of accurate measurement, an electronic weighing bridge with suitable capacity and minimum 2 digit display after decimal point in kg, is necessary at fabricator's premises. The fabricator shall make available 3-4 standard weights for verification of weighing scale.	For the purpose of accurate measurement, an electronic weighing machine/ bridge duly calibrated by NABL accredited Lab with suitable capacity and minimum 01 digit display after decimal point in kg, is necessary at fabricator's premises. The fabricator shall make available 3-4 standard weights for verification of weighing scale.
	iii	However, existing method (crane weighing scale) may be permissible as a short term practice subject to weighing scale being duly calibrated through an ISO/IEC 17025 accredited labs (like NABL accredited lab). In long term, (by 31.3.2021) fabricators to arrange a stationary weigh scale as above for the weighment of structures during RITES inspection.	
	iv	Fabricator will weigh each structure and submit weight report (Serial Number wise weight) to Inspection Engineer of RITES during inspection.	Fabricator will weigh each structure and submit weight report (Serial Number wise weight) to Inspection Engineer of RITES during inspection.

The vendors have also raised the issue of short period of time given by the CORE for implementing the Instructions. In the light of above, the Competent Authority has decided for implementation of revised guidelines/instructions with effect from 15th January 2021.

It may please be noted that all the inspections calls placed on M/s RITES before 15th January 2021 (for both black as well as fabricated galvanized steel structure) to be carried out as per the earlier inspection plan.

This supersedes all earlier instructions issued in reference to marking, weighment and inspection process for black as well as galvanised steel structure (GSS).

These issues with the approval of competent authority.

10/12/2020

(D.K. Srivastava)
Chief Electrical Engineer/MP
For Chief Administrative Officer
CORE / Prayagraj (U.P)

Copy to:

1. ED/RE/RB: for kind information of Member Infrastructure please.
2. ED/TI/RDSO: - for kind information please.
3. All PCEEs/Zonal Railways: for kind information please.
4. All CPDs/RE: for information and necessary action please.
5. All Approved Re-roller & Fabricators: for information and necessary action please