



केन्द्रीय रेल विद्युतीकरण संगठन
Central Organisation for Railway Electrification
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No. ELCORE/MP/Vendor/Confidential/2018

Date: 11.11.2020

***All approved Re-rollers & Fabricators
As per list attached***

Sub: Revised instructions for marking, weighments & inspection process for Galvanized Steel Structurers (GSS)

In order to address the issues of quality & traceability of Galvanized steel structures (GSS) utilized in Railway Electrification works, following instructions is being issued for marking, weighments and inspection process for re-rollers and fabricators to be effective from 01.12.2020.

a) Stage Inspection of black Steel:

- i. Stage inspection shall be carried out **at re-roller premises** as per the IS/RDSO specification & drawings and the extant guidelines issued by Railway board.
- ii. **Re-roller's marking** – Following shall be embossed/engraved on each section at every one to three (1-3) meters during rolling in minimum **20 mm figure letters**.
 - ❖ Name of Manufacturer (Code for re-rollers to be issued by CORE)
 - ❖ Month & Year of manufacture
 - ❖ Name of Purchaser – IR
 - ❖ Grade of Material & Section classification code & size (e.g. MC 150)
- 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.

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.
- 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.


- iii. 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.

c) Weighment:

- i. Issuance of weight of black steel structure as well as galvanised structures on each of the drawings will follow.
- 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.
- 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 31.03.2021) 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 Inspecting Engineer of RITES during inspection.

Note: Inspecting agency M/s RITES LTD shall issue revised inspection plan incorporating above guidelines and all the structures will be inspected as per the revised inspection plan w.e.f. 01.12.2020.

This issues with the approval of competent authority.


(D.K. Srivastava)
Chief Electrical Engineer (MP)
for Chief Administrative Officer
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