



No. CBS/GSP

Dated -08-2013

Principal Chief Engineer:

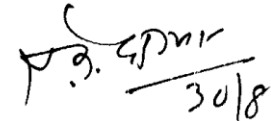
1. Central Railway, Mumbai CST-400 001.
2. Eastern Railway, Fairlie Place, Kolkata-700 001.
3. East Central Railway, Hazipur-844 101.
4. East-Coast Railway, Bhubaneshwar-751 016.
5. Northern Railway, Baroda House, New Delhi- 110 001.
6. North-Central Railway, Allahabad-211 001.
7. North Eastern Railway, Gorakhpur-273 001.
8. North-Western Railway, Jaipur-302 001.
9. Northeast Frontier Railway, Maligaon, Guwahati-781 011.
10. Southern Railway, Park Town, Chennai-600 003.
11. South Central Railway, Rail Nilayam, Secunderabad-500 371.
12. South East Central Railway, Bilaspur-495 004
13. South Eastern Railway, Garden Reach, Kolkata-700 043
14. South-West Railway, Hubli-580 023.
15. Western Railway, Mumbai-400 020.
16. West-Central Railway, Jabalpur-482 001.

Sub: Addendum and Corrigendum Slip No.05 to Specification for Fabrication and Erection of Steel Girder Bridge and Locomotive Turn-Tables (Fabrication Specification) Serial No. IRS:B1-2001.

Ref: Railway Board's letter No. 2011/CE-I/BR/BSC/81/Seminar dated 23-08-2013.

In reference to above, Addendum and Corrigendum Slip No. 05 dated 30-08-2013 to Specification for Fabrication and Erection of Steel Girder Bridge and Locomotive Turn-Tables (Fabrication Specification) Serial No. IRS:B1-2001 is being sent for your information and necessary action please.

Enc.: 1 Copy of A&C Slip No. 05
to Fabrication Specification IRS:B1-2001.


30/8

(A.K.Dadarya)
Executive Director (B&S)
For Director General

**GOVERNMENT OF INDIA
MINISTRY OF RAILWAYS
(Railway Board)**

**INDIAN RAILWAY STANDARD
SPECIFICATION FOR FABRICATION AND ERECTION OF STEEL GIRDER
BRIDGES AND LOCOMOTIVE TURN-TABLES**

Fabrication Specification (IRS:B1-2001)

ADOPTED – 1934
REVISED – 2001

ADDENDUM & CORRIGENDUM SLIP NO. 5 Dated 30-08-2013

(i) Existing Para 0.3.3 is to be replaced as under:

Para 0.3.3

RDSO's Specifications:

M&C/PCN/102/2009	Epoxy zinc phosphate primer.
M&C/PCN/103/2011	Epoxy micaceous iron oxide.
M&C/PCN/109/2009	Polyurethane red oxide.
M&C/PCN/110/2006	Polyurethane aluminium.
M&C/PCN/111/2006	High build Epoxy paint.

(ii) Existing Para's 8.1, 8.2, 8.3 and 8.4 are to be replaced as under:

8.1 IS:2062, Quality "A" Grade Designation E250 as rolled semi-killed or killed shall be used for foot-over bridges and other structures subjected to non-critical loading.

8.2 IS:2062, Quality "B0" Grade Designation E250 fully killed and with normalizing/ normalizing rolling/ controlled rolling where service temperature does not fall below 0°C, shall be used for welded/riveted girders subjected to Railway loading. Plates less than 12mm thick need not be with normalizing/ normalizing rolling/ controlled rolling.

8.3 IS:2062, Quality "C" Grade Designation E250 fully killed and with normalizing/ normalizing rolling/ controlled rolling ensuring impact properties at (-) 20°C shall be used for sub-zero temperature areas for welded/riveted girders subjected to Railway loading. Plates less than 12mm thick need not be with normalizing/ normalizing rolling/ controlled rolling.

NOTE: 1. In case Rolled Steel Section confirming to **IS:2062 Quality "B0" or "C"** are not available in market, CAO(C)/CBE may permit use of steel confirming to **IS:2062 Quality "BR"** on case to case basis by satisfying himself about non availability of quality "B0" or "C".

2. In case Rolled Steel Section confirming to **IS:2062 Quality "BR"** is also not available in market, CAO(C)/CBE may permit use of steel confirming to **IS:2062 Quality "A"** on case to case basis, by satisfying himself about non availability of quality "BR".

8.4 High tensile steel shall comply in all respects with the requirement of **IS:2062 Grade Designation E 410 Quality B0 or C** (copper bearing quality) for the welded work.

(iii) Existing Para 39.2.3.(b) is to be replaced as under:

Para 39.2.3(b)

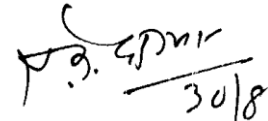
Finishing Coat

Two finishing coats of red oxide paint to IS:13607 with colour/shade to be specified by Zonal Railway or of any other approved paint shall be applied over the primer coats. One coat shall be applied before the fabricated steel work leaves the shop. After the steel work is erected at site the second finishing coat shall be applied after touching up the primer and the finishing coat if damaged in transit.

Note: (i) The colour/shade of finishing coat should be generally matching with the Smoke Grey colour/shade No. ISC 692 mentioned in IS:5-2004.

(ii) The colour/shade can be changed by CBE as per the local requirements.

BY ORDER



(A.K.Dadarya)
Executive Director(B&S)

LUCKNOW

Dated: 30-08-2013