

टेलीफोन / Tele : DOT- 91-0522-2450398(O) 2451245(Res.)  
Riy - 42120(O) 43120(Res.)  
फैक्स / Fax : 91-0522-2450398  
E-mail: edbsrdsso@gmail.com



भारत सरकार - रेल मंत्रालय  
अनुसंधान अभिकल्प और मानक संगठन  
लखनऊ - 226011  
Government of India-Ministry of Railways  
Research Design & Standards Organisation  
Lucknow- 226011

No. CBS/GSP

Dated 22-03-2016  
29

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, Bhubaneswar-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.- 10 to IRS B1 - 2001

**Ref:** Railway Board's letter No.2014/CE-III/BR/BSC/83/Seminar/pt dated 21- 03-2016.

\*\*\*\*\*

In reference to above, Addendum and Corrigendum Slip No.-10 dated 22-03-2016 to IRS B1-2001 regarding HSFG Bolts is being sent for your information and necessary action please.

**Encl.:** Copy of A&C Slip No. 10  
to IRS B1 - 2001.

*(Handwritten signature)*  
P. K. Daryar  
22/3/16  
**(A K Daryar)**  
Executive Director (B&S)  
R.D.S.O., Lucknow

Copy to :

- I OSD/ME for kind information of Member Engineering, Railway Board, Rail Bhavan, New Delhi-110001.
- II The Chief Commissioner of Railway Safety, N.E. Railway Office Compound, Ashok Marg, Lucknow-226002.
- III Additional Member (Civil Engg.), Railway Board, Rail Bhavan, New Delhi-110001.
- IV Additional Member (Works), Railway Board, Rail Bhavan, New Delhi-110001.

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 (B1-2001)

Adopted – 1934  
REVISED –2001

**Addendum and Corrigendum Slip No. 10 dated 22.03.2016**

**Replace clause 28.9.4 (ii) as follows**

**Length:** The length of bolt shall be chosen such as to hold the steel members in position, with provision for the nut, washer(s) and some projection beyond the bolt. Along with the overall length of the bolt, the thread length has to be specified. At least 4 full threads shall remain clear between the bearing surface of the nut and unthreaded part of the shank.

**Replace clause 28.9.4 (iii) as follows**

The minimum length of bolt shall be worked out on the basis of maximum grip length (covering ply thicknesses and all washers) minus one standard washer plus an additional allowance as per table 1 of IS:4000.

**Replace clause 28.10.6 (d) as follows**

**Checks after Second stage tightening:** 0.40 mm/0.25 mm thick feeler gauge shall be used to check 100% of the bolts for proper tightening. If the DTI is provided on the part (nut/bolt head) not being rotated, then 0.40 mm thick feeler gauge shall be used. Else if the DTI is being provided under the part (nut/bolt) being rotated, 0.25mm feeler gauge shall be used. If this feeler gauge cannot be inserted in the space between indicator positions on a DTI, it is called a 'refusal'. If a 0.10 mm thick feeler gauge cannot be inserted in the space between indicator positions on a DTI, it is called

'full compression of the indicator'. The joint/bolts shall be said to be properly tightened if the following condition is met with:

Number of indicator positions in DTI washer	Minimum number of feeler gauge refusals*
4	3
5	3
6	4
7	4
8	5
9	5

\*No more than 10% of the indicators in a connection bolt group shall exhibit full compression of the indicator.

X-----X

BY ORDER

*P. B. G. M. R.*  
*22/3/16*  
Executive Director (B&S)  
RDSO, Lucknow