

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



भारतसरकार-रेलमंत्रालय  
अनुसंधान अभिकल्प और मानक संगठन  
लखनऊ- 226011  
Government of India-Ministry of Railways  
Research Design & Standards Organisation  
Lucknow- 226011

No. CBS/GSP

Dated 16-01-2015

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.

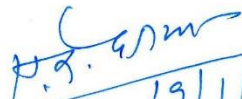
**Sub:** Addendum and Corrigendum Slip No.9 to IRS B1-2001.

**Ref:** Railway Board's letter No.2012/CE-I/BR/BSC/81/Seminar/Pt. III dated 12-01-2015.

\*\*\*\*\*

In reference to above, Addendum and Corrigendum Slip No. 9 dated 16.01.2015 to IRS B1-2001 regarding HSFSG Bolts is being sent for your information and necessary action please.

**Encl.:** Copy of A&C Slip No. 9  
To IRS B1-2001.

  
19/1/15  
**(A K Dadarya)**  
Executive Director (B&S)  
R.D.S.O., Lucknow

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. 9 dated 16.01.2015

**Replace clause 28.10.5 (ii) as follows**

The members being joined shall be held in position by insertion of few HSFG bolts (tightened to first stage (as defined in para 28.10.6 and 28.10.7) only. These bolts shall not be tightened to second stage as defined in para 28.10.6 and 28.10.7 till all the bolts in a joint are inserted and tightened to first stage.

**Replace clause 28.10.7 i as follows**

**First Stage Tightening:** In the first stage, a calibrated wrench with an accuracy of  $\pm 10\%$  shall be set to 75% of the torque computed for the complete tightening of the bolt. The torque computed shall be as per bolt fabricator recommendations (subject to limits given in IS: 1367 part 8, table C-1), duly certified to impart the bolt tension specified in para 7.12.6 of IRS Steel Bridge Code. All the bolts in the joint shall be tightened to this torque in proper sequence for tightening. After checking all bolts after the first stage, permanent marks shall be made with suitable marker on the bolt as well as nut steel member to indicate the relative position of the two. The mark shall be such that the same shall be visible for inspection upto 1 year after the date of installation.

**Replace clause 28.10.7 ii a) as follows**

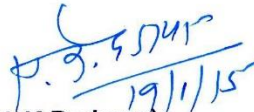
The steel members that make up the plies of the joint with HSFG bolts shall be checked for proper contact as specified in para 28.10.5 (iv).

**Replace clause 28.10.7 ii b) as follows**

10% bolts, subject to minimum 2 per joint shall be tried to be rotated with a separate calibrated torque wrench set at 75% of torque computed for the complete tightening of the bolt. Any bolt turning by more than  $15^{\circ}$  during the check shall be rejected. If the improperly tightened bolts thus found are more than 5 but less than 1% of the total, another 10% of the bolts shall be checked. If the total improperly tightened bolts thus found exceed 1% of the total, the tightening procedure and personnel involved shall be reviewed, the torque wrench used for tightening shall be calibrated afresh and the entire lot shall be checked for tightness.

x-----x

BY ORDER

  
**(A K Dadarya)**  
Executive Director (B&S)  
RDSO, Lucknow