

केन्द्रीय मुहर विभाग-2

हमारा संदर्भ: के.मु.वि.-2/16: 2830

08 01 2018

विषय: आई एस 2830:2012 सामान्य संरचना इस्पात हेतु पुनर्वेल्लन के लिए कार्बन ढलवों इस्पात इंगट, बिलेट, ब्लूम एवं स्लैब के लिए आकारों के समूहीकरण दिशा निर्देश।

आई एस 2830:2012 सामान्य संरचना इस्पात हेतु पुनर्वेल्लन के लिए कार्बन ढलवों इस्पात इंगट, बिलेट, ब्लूम एवं स्लैब, समूहीकरण दिशा निर्देश संलग्न हैं ।

सक्षम प्राधिकारी ने अनुपालन हेतु दिशानिर्देश को अनुमोदित कर दिया है।

सभी क्षेत्रीय और शाखा कार्यालयों से अनुरोध है की उपरोक्त दिशानिर्देश का अनुपालन तत्काल प्रभाव से सुनिश्चित करें।

(अरुण पुच्छकायला)
वैज्ञानिक.सी, के.मु.वि.-2

प्रमुख (के.मु.वि.-2)(हस्ता/-)

सभी क्षेत्रीय/शाखा कार्यालयों को परिचालित

प्रतिलिपि : आई टी एस को बीआईएस इंटरनेट पर अपलोड करने के लिए

CENTRAL MARKS DEPARTMENT-2

Our ref: CMD-2/16:2830

08 01 2018

Subject: Grouping guidelines for the product Carbon Steel Cast Billet Ingots, Billets, blooms and Slabs for Re-Rolling into Steel for General Structural Purposes as per IS 2830:2012.

Please find enclosed Grouping guidelines for the product Carbon Steel Cast Billet Ingots, Billets, blooms and Slabs for Re-Rolling into Steel for General Structural Purposes as per IS 2830:2012.

The Competent Authority has approved the Guidelines for implementation.

All ROs/BOs are requested to ensure implementation of the above guidelines with immediate effect.

(Arun Puchhakayala)
Scientist.C, CMD-2

Head (CMD-2)(sd/-)

Circulated to All ROs/BOs

Copy to : ITS for hosting on BIS Intranet

CENTRAL MARKS DEPARTMENT - 2

Our Ref: CMD-2/16:2830

Date: 08.01.2018

Subject: Grouping Guidelines for IS 2830:2012 Carbon steel cast billet ingots, billets, blooms and slabs for re-rolling into steel for general structural purposes - Specification

In order to align with existing guidelines for steel items and uniform practice is followed across ROs/BOs, the following procedure to be adopted towards grant of licence and inclusion of additional varieties. Grouping has been done on the basis of grade and designation.

SI.No.	Type	Classification										
1.	Type	(a) Cast Billet Ingot (b) Billet (c) Bloom (d) Slab										
2.	Grade (based on Sulphur and Phosphorus content)	(a) Grade A (lowest grade) (b) Grade B (c) Grade C (highest grade)										
3.	Designation (based on Carbon and Manganese content)	<table border="1"><thead><tr><th>Designation</th><th>%Mn</th></tr></thead><tbody><tr><td>(a) C15, C18, C20</td><td>0.30-0.60</td></tr><tr><td>(b) C15 MMn, C18 MMn, C20 MMn</td><td>0.60-1.00</td></tr><tr><td>(c) C15 HMn, C18 HMn, C20 HMn</td><td>1.00-1.80</td></tr><tr><td>(d) C25 HMn</td><td>1.80 Max</td></tr></tbody></table> <p>*No grade is specified against C25 HMn designation</p>	Designation	%Mn	(a) C15, C18, C20	0.30-0.60	(b) C15 MMn, C18 MMn, C20 MMn	0.60-1.00	(c) C15 HMn, C18 HMn, C20 HMn	1.00-1.80	(d) C25 HMn	1.80 Max
Designation	%Mn											
(a) C15, C18, C20	0.30-0.60											
(b) C15 MMn, C18 MMn, C20 MMn	0.60-1.00											
(c) C15 HMn, C18 HMn, C20 HMn	1.00-1.80											
(d) C25 HMn	1.80 Max											

Based on the above, the product may be divided into the following four groups:

Group-1	(a) C15,C18,C20
Group-2	(b) C15 MMn,C18 MMn,C20 MMn
Group-3	(c) C15 HMn,C18 HMn,C20 HMn
Group-4	(d) C25 HMn

- 1) One sample may be drawn from each group as above for **chemical testing only**, to cover all the designations of the product within that group. The sample drawn from each group shall meet following criteria:
 - a) If sample of grade-C has been tested and found conforming, the scope may cover grades A and B also. Similarly, if sample of grade B has been tested and found conforming, grade A may also be covered in the scope of licence.
 - b) In case a manufacturer applies for GOL/Inclusion of more than one product type (Cast Billet Ingot, Billet, Bloom or slab) for the same Grade and Designation, separate samples from each product type for chemical test shall not be drawn.
 - c) In case applicant /licensee intend to cover designations in the group with micro-alloying the sample to be drawn, for independent testing from each group for chemical tests only as mentioned above, shall be with micro-alloying.
 - d) In case applicant intends to cover designations with Cu-bearing quality in the group, one additional sample of Cu-bearing quality shall be drawn from the group.

- 2) For testing of Dimensions, Microscopic defects, Shape for considering GOL, one sample of any size, grade, designation of each product type intends to be covered in the licence may be tested in the factory. Separate samples are not required to be tested for physical parameters for each size/grade/designation.

However, while considering inclusion of a new variety (product type/grade/designation), licensee shall submit factory test report for physical parameters if the physical parameters are different from the ones already tested.

- 3) If mutually agreed between purchaser and manufacturer for carrying out Sulphur print and macro-examination tests in case of cast billet ingots, separate samples for each size, irrespective of grade/designation may be drawn for testing in-house. In case no test facilities are available, details may be sought from the applicant with respect to the arrangement proposed for testing of optional requirements. In the absence of conduct of these tests in-house/arrangement for testing, the manufacturer shall submit an undertaking that no claim for conformity of the product to such requirements will be made.
- 4) While drawing samples for independent testing, applicable declaration as per Notes given under Table-1 of IS 2830:2012 may be obtained and reflected in the test request appropriately.
- 5) If the above sample passes, then licence may be granted/inclusion be done for the Designations of the Group. However, it shall be ensured that the firm is having all necessary manufacturing and testing facilities for the Grades/Designations /Product type of carbon Steel to be included in the licence.
- 6) Recommendation may be made for GOL/Inclusion in the following manner considering the manufacturing infrastructure and test results of sample drawn as per the grouping guidelines:

“GOL/inclusion for use of standard mark as per IS 2830 may be considered for the following:

Product Type	Carbon Steel Cast Billet Ingot or/and Billet or/and Bloom or/and Stab
Grade	A, B, C
Designation	C15, C18, C20, C15 MMn, C18 MMn, C20 MMn, C15 HMn, C18 HMn, C20 HMn, C25 HMn
Alloying	With micro-alloying or excluding micro-alloying

(only applicable product type, grade, designation and alloying may be mentioned)

- 7) During the operation of license, BO shall ensure that all Grades & Designations covered in the license are drawn for independent testing on rotation over a period of time.
- 8) The above guidelines shall come into force with immediate effect.

(Arun Pucchakayala)
Scientist-C, CMD-2

Head(CMD-2) (sd/-)

DDG(certification) (sd/-)

All ROs/BOs