

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:6603

18 07 2024

विषय: संशोधित IS 6603:2024 के अनुपालन के दिशा निर्देश (स्टेनलेस स्टील अर्ध-तैयार उत्पाद बार, वायर रॉड और ब्राइट बार) (आईएस 6603:2001 और आईएस 6527:1995 का स्थान लेते हुए)

यह उपरोक्त विषय के संदर्भ में है।

सक्षम अधिकारी द्वारा अनुमोदित दिशानिर्देश अनुपालन हेतु संलग्न है।

सभी क्षेत्रीय/शाखा कार्यालयों से अनुरोध है की दिशानिर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

**शिवम आहुजा
वैज्ञानिक सी**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:6603

18 07 2024

Subject: Guidelines for implementation of Revised IS 6603:2024 (Stainless Steel Semi-Finished Products Bars, Wire Rods and Bright Bars) (superseding IS 6603:2001 and IS 6527:1995)

This has reference to the subject mentioned above.

The Competent Authority has approved the enclosed Guidelines for implementation.

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

**(Shivam Ahuja)
Scientist C**

Head (CMD-2)

All ROs/BOs/Labs/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 6603

18 07 2024

Subject: Guidelines for implementation of Revised IS 12658:2024 (Stainless Steel Semi-Finished Products Bars, Wire Rods and Bright Bars) (superseeding IS 6603:2001 and IS 6527:1995)

1. This has reference to the above.
2. IS 6603:2001 and IS 6527:1995 have been revised as IS 6603:2024 and the date of withdrawal of IS 6603:2001 and IS 6527:1995 is **22nd October 2024**.
3. Presently, 46 licences (15-domestic, 21-foreign) are operative for IS 6603:2001 and 15 licences (11- domestic, 04-foreign) are operative for IS 6527:1995.
4. The significant changes in the revised Standard as listed in the Table are given for the purpose of general guidance. BOs shall ensure that the product conforms to all the requirements, as applicable, as per the revised Standard.

Clause(s) as per IS 6603:2024	Change
1 Scope	Earlier only Hot finished/Cold finished Stainless Steel Bars and Flats were covered under the standard. Now, the scope has been revised to cover various forms of Hot formed and cold finished products such as semi-finished products, hot or cold formed bars, wire rods and bright bars
4.2 Supply of Material	Clause has been amended to cover delivery conditions as per existing industrial practices
5 Manufacture	Clause has been modified to specify reference to IS 14650 (UNALLOYED AND ALLOYED STEEL INGOT AND SEMI-FINISHED PRODUCTS FOR RE-ROLLING PURPOSES - SPECIFICATION) for conformity of Steels used for the manufacturing of the products covered under the standard.
6 Freedom from Defects ,Table 1, Types of Process Routes and Surface Finish of Long Products, Table 2 Maximum Depth of Acceptable Discontinuities for Bars, Rods and	Criteria for Freedom from Defects has been modified. A new Table (Table 1) specifying the available Surface Finishes for Product Forms ,covered under the standard, in the applicable Supply/Manufacturing Condition and Process Route has been added. A new Table (Table 2) specifying Maximum Depth of Acceptable Discontinuities for Bars, Rods and Sections has been added.

Sections	
7, Chemical Composition, Table 3	<p>A no. of new grades have been added and their Chemical Composition (Ladle Analysis) has been specified under Table 3.</p> <p>Grades X07Cr18Ni9 and X10Cr17Mn6Ni4N have been removed.</p> <p>Grades X07Cr17, X12Cr12, X15Cr16Ni2 and X108Cr17Mo have been re-designated as X04Cr17, X12Cr13, X17Cr16Ni2 and X110Cr17 respectively;</p>
9 Mechanical Properties	<p>Mechanical Properties for Steels supplied in various conditions have been specified from Tables 5 to Table 9 for Semi-finished products/Hot formed steel and Tables 15 to Table 19 for Cold Formed Steels/Bright Bars.</p> <p>It has also been specified that Mechanical properties for grades/sizes other than that mentioned in Table 5 to Table 9 or Table 15 to Table 19 shall be mutually agreed to between the purchaser and the supplier</p> <p>In these Tables, requirement of Elongation has been replaced by Elongation at Fracture.</p> <p>Requirements of Resistance to Intergranular Corrosion, to be tested as per ISO 3651 (Part 2), have been specified in Tables 5, 6 &7, as per mutual agreement between the manufacturer and purchaser</p>
11 Conditions of Supply	<p>The clause has been amendment to include a no.of other supply conditions based upon the various forms of Stainless Steel covered under the revised standard.</p>
12 Dimensions and Tolerances	<p>Dimensional tolerances for the bars and flats have been specified from Table 26 to Table 36.</p> <p>Further, other dimensional tolerances are also permitted on mutual agreement</p>

5. Consequent upon the issuance of the revised Standard, the existing product manual of IS 6603 has been revised which is being circulated separately.
6. The guidelines for implementation of the revised Standard is given below:

A. LICENSEES:

a) Switchover of existing Licensees of IS 6603:2001 and IS 6527:1995 to revised IS 6603:2024

i) IS 6603:2001 covered Stainless Steel Bars and Flats. IS 6527:1995 covered Stainless Steel Wire Rods, Now, both Bars, Flats and Wire Rods have been covered under IS 6603:2024. A no of new grades have been added in IS 6603:2024, a few grades have been re-designated and 02 existing Grades have been omitted (X07Cr18Ni9 and X10Cr17Mn6Ni4N).

ii) For switchover, the licensees shall be required to do the following tasks:

a) Re-designate the Grades covered under existing scope of licence as given under IS 6603:2001/IS 6527:1995, as per Table 3 of IS 6603:2024 and prepare declaration with regards to intended revised scope of licence (equivalent to the existing scope) as per IS 6603:2024. (Guidance with regards to scope of licence as per IS 6603:2024 may be taken from the Product Manual).

b) Submit the declaration with regards to revised scope of licence along with in-house/independent test reports of the Grades/Conditions/Sizes etc. as per the Grouping Guidelines specified in the Product Manual of IS 6603:2024 to the concerned BO.

c) Prepare Test Equipment List (as per Form-II) as per the requirements of IS 6603:2024 and submit the same to the concerned BO.

iii) On receipt of the above evidences of conformity, BOs shall issue endorsement for switchover of the licence to IS 6603:2024 along with revised scope of licence. In case same manufacturing unit holding licences for both IS 6603:2001 and IS 6527:1995, preferably, the licence as per IS 6603:2001 shall be switched over to IS 6603:2024 and post switchover, the other licence shall be processed for cancellation/expiry. BOs shall ensure that the revised scope of licence shall not be granted beyond the Grades/Conditions/Sizes etc. covered in existing scope of licence(s).

iv) Inclusion of new Grades/Conditions/Sizes etc. shall be dealt as per the existing Guidelines for Change in Scope of Licence (CSoL).

v) All Licensees shall implement the revised Standard by 22nd October 2024. Any difficulty in implementation shall be brought to the notice of CMD 2 at the earliest but in any case at least 30 days before the last date of implementation. BOs shall ensure that no Licences are under operation as per old Standard after 22nd October 2024. The status of implementation of the revised Standard shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.

vi) BOs shall plan an early surveillance visit for verification of the implementation of the revised standard preferably within 30 days of switchover by the licensee.

B. APPLICATIONS FOR GRANT OF LICENCE:

1. Existing Applications where Sample has been submitted in the Laboratory/Test Report has been issued by the Laboratory may be processed as per the old Standard. However, if the Applicant is desirous of considering the Application as per the revised Standard, a declaration may be obtained from the Applicant to that effect and the Application may be processed accordingly. An undertaking shall also be obtained from such Applicants that if the sample fails in new test requirements, Licence will not be granted by BIS as per the old version.
2. Applications which are recorded henceforth may be processed as per the old Standard or the revised Standard. Processing of Applications as per the old Standard shall be permitted only upto **21st October 2024** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **22nd October 2024**.
3. **Revised version IS 6603:2024 covers Stainless Steel Semi-Finished Products as well apart from Bars, Wire Rods and Flats. Stainless Steel Semi-Finished products are also covered in IS 14650:2023, intended for rolling purposes and IS 6529:1996, intended for forging purposes.**

Thus, in order to avoid duplicacy of certification, all Applications received for Grant of Licence, wherein Semi-Finished products have been applied under scope, as per IS 6603:2024 shall not be processed and the applicant/manufacturer shall be guided to apply for Stainless Steel Semi-Finished products covered under IS 14650:2023 (UNALLOYED AND ALLOYED STEEL INGOT AND SEMI-FINISHED PRODUCTS FOR RE-ROLLING PURPOSES – SPECIFICATION) and IS 6529:1996 (Stainless Steel Blooms, Billets and Slabs for Forgings) , as applicable.

4. Beyond **22nd October 2024** no Licence shall be granted as per the old Standard.

C. CHANGE IN SCOPE OF LICENCE:

1. For change in scope of licence, the relevant provisions as given above for Applicants shall apply.
2. However, processing of such applications for change in scope of licence as per the old Standard shall be permitted only up to the date of implementation of the revised Standard or up to **22nd October 2024** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja
Sc. C

Head (CMD-2)
DDG (Certification)
ROs/BOs