

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:6528

12 02 2025

विषय: संशोधित IS 6528:2024 के अनुपालन के दिशा निर्देश

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 आहूजा
वैज्ञानिक डी**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:6528

12 02 2025

Subject: Guidelines for implementation of Revised IS 6528:2024 (Stainless Steel Wire-Specification)

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 D**

Head (CMD-2)

All ROs/BOs/Labs/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 6528

12 02 2025

Subject: Guidelines for implementation of Revised IS 6528:2024 (Stainless Steel Wire-Specification)

1. This has reference to the above.
2. IS 6528:1995 has been revised as IS 6528:2024 and the date of withdrawal of IS 6528:1995 is **15th April 2025**.
3. Presently, for IS 6528:1995, 18 licences are operative domestically and 07 licences are operative under FMCS.
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 6528:2024 | Change |
|--|--|
| 1 Scope | Scope has been modified to include shaped wires (such as square, hexagonal, rectangular or any other shape wire) |
| Table 1, 7.1., Chemical Composition | Few of the existing Grades have been re-designated. New Grades of Stainless Steel have been added in the Table. New classes of steel i.e. austenitic-ferritic (duplex) steels and precipitation hardening steels have been added. |
| 8.1 Heat Treatment | Clause has been modified to specify that the Stainless Steel Wires shall be supplied in 3 conditions as per cl.13. i.e. Condition +A –Annealed, Condition +AT –Solution Annealed, Condition +C –Cold Drawn, as per the tensile strength levels given in Table 7 and Table 8 |
| 9 Dimensional Tolerances, Table 3 to Table 6 | Table 3 (Size Tolerance for Round Wire) has been modified to specify Normal(N) and Restricted Tolerances (R) on Diameter for Round Wires of Diameter from 0.050 mm to 16.00 mm Limits of Out of Roundness for Round Wires have been modified to specify at cl.9.1 that “The out-of-roundness shall not exceed half the total diameter tolerance specified for round wires” It has been added in the clause that “For other shaped or sized wires, for which tolerances are not covered in Table 4 to Table 6 , the tolerances shall be agreed upon at the time of ordering”. |
| Table 7, 10.1, 10.1.1, Mechanical Properties | Mechanical Properties of existing Grades have been modified. Requirements of 0.2 % Yield Strength and Reduction in Area have been omitted. Mechanical Properties (Tensile Strength and Elongation) at Room Temperature for Steel Grades in the form of Round Wires in the Solution-Annealed (+AT) or Annealed (+A) Condition have been specified in the Table. |

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| | <p>For non-round wires, it has been specified that the Mechanical Properties shall be as per agreement between the manufacturer and purchaser.</p> <p>Further, it has been added through cl.10.1.1 that Tensile properties for grades/sizes other than mentioned in Table 7 shall be mutually agreed to between the purchaser and the supplier.</p> |
| cl.10.1.2, Table 8, Mechanical Properties | <p>Tensile Strength Range for Wires Supplied in the Cold Drawn Condition have been specified in Table 8.</p> <p>Further , a new clause has been added specifying that “As the mechanical properties of hard-drawn (Cold Drawn +C) wire given in Table 8 will depend on the degree of work hardening, the specific type of steel, and the processing of the material and not that all the tensile strength levels can be achieved for all grades, the required tensile-strength level as per Table 8 shall be agreed between the manufacturer and the purchaser at the time of ordering”.</p> |

5. Consequent upon the issuance of the revised Standard, the existing product manual of IS 6528:2024 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 6528:1995 to revised IS 6528:2024

i) Consequent to revision of IS 6528:1995 to IS 6528:2024, new Grades of Stainless Steel and 2 new class of Stainless Steel (Austenitic-Ferritic(Duplex) and Precipitation Hardening) have been added. Further, few of the existing grades have been also re-designated. Further, Mechanical Properties of existing Grades have been modified as specified at Tables 7 and 8.

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 per IS 6528:1995, (as per Table 1 of IS 6528:2024) and prepare a revised scope of licence (equivalent to the existing scope) as per the Product Manual of IS 6528:2024.

b) Submit the revised scope of licence along with in-house/independent test reports of the existing Grades /Conditions/Sizes/Shapes of Wires, as per the Grouping Guidelines specified in the Product Manual of IS 6528:2024, to the concerned BO.

iii) On receipt of the above evidences of conformity, BOs shall issue endorsement for switchover of the licence to IS 6528:2024 along with revised scope of licence. BOs shall ensure that the revised scope of licence shall not be granted beyond the Grades/ Conditions/Sizes/Shapes of Wires, covered/verified at the time of grant of licence as per IS 6528:1995.

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

v) All Licensees shall implement the revised Standard by **15th April 2025**. 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 **15th April 2025**. **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 **14th April 2025** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **15th April 2025**.
3. Beyond **15th April 2025** 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 **15th April 2025** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja
Sc. D

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