

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:2041

19 09 2024

**विषय: संशोधित IS 2041:2024 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 सी**

**प्रमुख (केमूवी 2)**

**सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LPPD**

**CENTRAL MARKS DEPARTMENT-2**

Our Ref: CMD-2/16:2041

19 09 2024

**Subject: Guidelines for implementation of Revised IS 2041:2024**

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: 2041

19 09 2024

**Subject: Guidelines for implementation of Revised IS 2041:2024(Steel Plates and Strips for Pressure Vessels Used at Moderate and Lower Temperature — Specification)**

1. This has reference to the above.
2. IS 2041:2009 has been revised as IS 2041:2024 and the date of withdrawal of IS 2041:2009 is **25<sup>th</sup> January,2025**.
3. 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 2041:2024	Change
1 Scope	Scope has been modified to <i>include plates produced from strips and strips</i> for fabrication of fusion welded pressure vessels for moderate and low temperature service
5 Grades	2 new Room Temperature Quality Grades i.e. R205 and R240 have been added and their Chemical Composition and Mechanical Properties have been specified at Tables 1 and 3 respectively.
6.1.1 Manufacture	A new clause has been added giving reference of IS 14650:2023 (Unalloyed and Alloyed Steel Ingot and Semi-finished products for Re-Rolling purposes – specification) for conformity of steels used for manufacturing of the product
6.1.2 Manufacture	A new clause specifying austenitic grain size requirements of the material has been added
6.4 (a) to (g)	Conditions for permitting lower reduction ratio than that specified in cl.6.2 have been specified
8 Heat Treatment	The clause has been modified to specify Heat Treatment supply conditions for Plates above 40 mm in thickness and Plates below 40 mm in Thickness.  Conditions of Supply of Plates in Normalized Condition have been modified.  Additional Testing requirements ( as per cl.12.1.1) for plates produced from strips and furnished “with heat treatment” or “without heat treatment” or “with stress relieving only” have been specified.
10 Dimensions and Tolerances	Clause has been modified to specify nominal dimensions and tolerances of levelled and flattened plates that have been cut to length from a coiled product as per IS 1852 and plates as-rolled from the slab or directly from an Ingot as per IS 16988

12.3 Low Temperature Charpy Impact Test	Clause has been modified to state that Charpy impact test shall be conducted for Grades H235, H265, H295 and H355. Also, the same can also be conducted for Grades R205, R220, R240, R260, R275 and R355, if agreed to at time of ordering.
13 Ultrasonic Testing	<p>Clause has been modified to state that the Ultrasonic Test shall be carried out in accordance with IS 11630 or equivalent national/international standard. Requirements of the test carried out as per IS 11630 have been specified in clauses 13.1.1, 13.1.2 and 13.1.3.</p> <p>Acceptance Standards for the test have been specified under cl.13.2.</p>

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 2041 has been revised which is being circulated separately.
5. The guidelines for implementation of the revised Standard is given below:

**A. LICENSEES:**

- i) For switchover to revised standard, Licensees shall submit evidence of conformity to the additional/modified requirements through In-house/Independent Test Reports.
- ii) All Licensees shall implement the revised Standard by **25<sup>th</sup> January 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 **25<sup>th</sup> January 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.**
- iv) 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 up to **24<sup>th</sup> January 2025** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **25<sup>th</sup> January 2025**.

3. Beyond **25<sup>th</sup> January 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 **25<sup>th</sup> January 2025** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja  
Sc. C

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