केन्द्रीय मुहर विभाग-2

हमारा संदर्भ: के.मु.वि.-2/16: 7904 05 07 2018

विषय: आई एस 7904:2018 उच्च कार्बन इस्पात के तर सरिये के लिए आकारों के समूहीकरण

आई एस 7904:2018 उच्च कार्बन इस्पात के तर सरिये,समूह के 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 पुछकायला)
वैज्ञानिक सी

प्रमुख (के.मु.वि.-2) (हस्ता/-)

सभी क्षेत्रीय/शाखा कार्यालयों को परिचालित
प्रतिलिपि : आई टी एस को बीआईएस इंट्रानेट पर अपलोड करने के लिए

CENTRAL MARKS DEPARTMENT-2

Our ref: CMD-2/16:7904 05 0 7 2018

Subject: Grouping of sizes for the product "High Carbon Steel Wire Rods" as per IS 7904:2018.

Please find enclosed the Grouping guidelines for the product "High Carbon Steel Wire Rods"as per IS 7904:2018. The Competent Authority has approved the Guidelines for implementation.

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

(Arun Pucchakayala)
Scientist C

Head (CMD-2) (sd/-)

Circulated to All ROs/BOs

Copy to : ITSD for hosting on BIS Intranet

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:7904 18 06 2018

Subject: Grouping Guidelines for certification of High Carbon Steel Wire Rods as per 7904:2018

Clause 5.1 and Table 1 of IS 7904:2018 classifies grades of High Carbon Steel Wire Rods as per chemical composition and Clause 5.2 and Table 2 of IS 7904:2018 classifies grades of wire rods on tensile strength basis. Further, IS 7904:2018 includes wire rods of sections such as square, hexagonal, rectangular etc, alongside round wire rod. The requirement of non-metallic inclusions and Maximum resolvable Pearlite limits are to be carried out only if agreed to between the manufacturer and purchaser. The classification of grades on the basis of surface defects/ non-metallic inclusions has been subsided in the revised IS 7904:2018.

In addition, grades classified on the basis of chemical composition can be supplied in two varieties namely with suffix-A, B based on Mn content, or with suffix-Cr based on Cr content. This will be essential to allow the manufacturer to supply steel wire rods with different combinations of Mn% and Cr% or micro-alloying elements for a given range of C% and other elements for achieving the desired property as per end use of the wire rod.

1. In view of the above and in order to follow a uniform policy for the purpose of grant of licence/inclusion of additional varieties in the existing licence, for drawl of samples for independent testing as per IS 7904:2018, the following is to be considered:

i. For grades classified on the basis of Chemical Composition: One sample each of grade with lowest specified carbon limit and highest specified carbon limit for each shape (viz. Round, Hexagon, Square, rectangular) and of any size intended to be covered shall be tested for covering all grades including and falling between those carbon limits. The samples drawn as above may be preferably of grade B and/or micro-alloyed high carbon steel. In case wire rods of Type –X are to be covered then the above samples drawn shall be of Type-X.

ii. For grades classified on the basis of Tensile Strength: One sample each of grade with lowest minimum tensile strength and highest tensile strength for each shape (viz. Round, Hexagonal, Square, rectangular) and of any size intended to be covered shall be tested for covering all grades including and falling between those Strength limits. The samples drawn as above may be preferably of grade B and/or micro-alloyed high carbon steel. In case wire rods of Type –X are to be covered then the above samples drawn shall be of Type-X.

2. It shall, however, be ensured that firm has necessary manufacturing and testing facilities for the entire range of sizes/classes proposed to be covered under the scope of licence.
3. The scope of licence shall clearly indicate sizes, shape (round/hexagonal/square etc.) against the grades of steel wire rods classified on chemical composition basis **and/or**
   sizes, shape(round/hexagonal/square etc.) against the grades of steel wire rods classified on tensile strength basis.
4. During the operation of license, BO shall ensure that all sizes / grades covered in the license are drawn for independent testing on rotation over a period of time.

(Arun Pucchakayala)
Scientist.C

Head (CMD-2) (sd/-)

DDG(cert.) (sd-)