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DRAFT AMENDMENT NO. 2

TO

**IS 6419 : 1996 WELDING RODS AND BARE ELECTRODES FOR GAS SHIELDED
ARC WELDING OF STRUCTURAL STEEL — SPECIFICATION**

(*First Revision*)

ICS 25.160.20; 77.140.40

Welding General and its Applications Sectional Committee, MTD 11	Last date for receipt of comment is 05 July 2024
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(*Page 1, clause 2*) — Substitute the following for the existing:

‘2 REFERENCES

The standards listed below contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below:

<i>IS No.</i>	<i>Title</i>
IS 228 (relevant parts)	Methods of chemical analysis of steels
IS 812 : 1957	Glossary of terms relating to welding and cutting of metals
IS 1387 : 1993	General requirements for the supply of metallurgical materials (<i>second revision</i>)
IS 1608 (Part 1) : 2022/Metallic materials — Tensile testing: Part 1 Method of test at room ISO 6892-1 : 2019	temperature (<i>fifth revision</i>)
IS 1757 (Part 1) : 2020/Metallic Materials — Charpy pendulum impact test: Part 1 Test ISO 148-1 : 2016	method (<i>fourth revision</i>)
IS 2002 : 2009	Steel plate for pressure vessel for intermediate and high temperature service including boilers (<i>third revision</i>)
IS 2062 : 2011	Hot rolled medium and high tensile structural steel — Specification (<i>seventh revision</i>)
IS 3039 : 1988	Specification for structural steel for construction of hulls of ships (<i>second revision</i>)

(*Page 1, clause 3*) — Substitute ‘IS 812’ for ‘IS 812 : 1957’.

(*Page 1, clause 4*) — Substitute ‘IS 1387’ for ‘IS 1387 : 1993’.

(Page 1, Clause 5, Table 1) — Substitute the following with existing Table:

SI No.	Nominal Diameter	Tolerance, mm	
		Plus	Minus
	mm		
(1)	(2)	(3)	(4)
i)	0.6	0.01	0.03
ii)	0.8	0.01	0.04
iii)	0.9	0.01	0.04
iv)	1.0	0.01	0.04
v)	1.2	0.01	0.04
vi)	1.4	0.01	0.04
vii)	1.6	0.01	0.04
viii)	1.8	0.01	0.04
ix)	2.0	0.01	0.07
x)	2.4	0.01	0.07
xi)	2.5	0.01	0.07
xii)	2.8	0.01	0.07
xiii)	3.0	0.01	0.07
xiv)	3.15	0.01	0.07
xv)	3.2	0.01	0.07
xvi)	4.0	0.01	0.07
xvii)	5.0	0.01	0.07

(Page 2, Clause 8.1, Table 2) — Add following Note under Table 2:

NOTE — Other dimensions can be as agreed between the purchaser and the manufacturer.

(Page 3, Clause 10.2) — Substitute ‘Cast and Helix of Wire’ for ‘Temper, Cast and Helix of Wire’.

(Page 3, Clause 10.2.1) — Delete.

(Page 4, Table 5) — Delete.

[(Page 5, Table 6, row(i), col(3))] — Substitute ‘Cast *Min*, mm’ for ‘Cast, mm’.

[Page 5, Table 6, col(3), row(iii) and row(iv)] — Add ‘*Min*’.

[Page 5, Clause 13.1, Informal Table, row (i), col (3)] — Substitute ‘*Tensile Strength, Min* MPa’ for ‘*Tensile Strength* MPa’.

[(Page 5, clause 13.1, row(ii), col(2))] — Substitute ‘400’ for ‘420’.

[(Page 5, clause 13.1, row(ii), col(3))] — Substitute ‘490’ for ‘500-640’.

[(Page 6, Table 7, row(vi), col(2))] — Substitute ‘0.06 to 0.15’ for ‘0.07 to 0.15’.

(Page 7, clause 17.2) — Substitute the following for the existing clause:

‘17.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.’

(Page 7, clause A-1.1) — Substitute ‘IS 2062, IS 2002, IS 3039’ for ‘IS 2062 : 1992, IS 2002 : 1992, IS 3039 : 1988’.

(Page 8, clause A-5) — Substitute ‘IS 1608 (Part 1)’ for ‘IS 1608 : 1995’.

(Page 9, clause A-6) — Substitute ‘IS 1757 (Part 1)’ for ‘IS 1757 : 1988’