

केन्द्रीय मुहर विभाग-2

हमारा संदर्भ : के.मु.वि.-2/16: 6901

16 10 2018

विषय: संशोधित IS 6901:2018/ISO 2503:2009 (Gas Welding Equipment – Pressure Regulators And Pressure Regulators With Flow Metering Devices For Gas Cylinders Used In Welding, Cutting And Allied Processes Up To 300 Bar (30 Mpa))

1. संशोधित IS 6901:2018/ISO 2503:2009 के अनुसार Scheme of Inspection and Testing (SIT) अवलोकन हेतु संलग्न है।

(आदित्य दास)
वैज्ञानिक सी (सी एम डी-2)

प्रमुख (के.मु.वि.-2)

सभी क्षेत्रीय/शाखा कार्यालयों को इंटरनेट के माध्यम से परिचालित

प्रतिलिपि:

आई टी एस विभाग - बीआईएस इंटरनेट पर अपलोड करने के लिए

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 6901

16 10 2018

Subject: Scheme of Inspection and Testing (SIT) for Revised IS 6901:2018/ISO 2503:2009 (Gas Welding Equipment – Pressure Regulators And Pressure Regulators With Flow Metering Devices For Gas Cylinders Used In Welding, Cutting And Allied Processes Up To 300 Bar (30 Mpa))

1. Please find enclosed Scheme of Inspection and Testing (SIT) for Revised IS 6901:2018/ISO 2503:2009.

(Aditya Das)
Sc. 'C' (CMD-2)

Head (CMD-2)

Circulated to all ROs/BOs through intranet

Copy to: ITS for hosting on BIS Intranet

SCHEME OF INSPECTION AND TESTING FOR CERTIFICATION OF IS 6901:2018/ISO 2503:2009 (GAS WELDING EQUIPMENT – PRESSURE REGULATORS AND PRESSURE REGULATORS WITH FLOW METERING DEVICES FOR GAS CYLINDERS USED IN WELDING, CUTTING AND ALLIED PROCESSES UP TO 300 BAR (30 MPA))

1. LABORATORY – A laboratory shall be maintained which shall be suitably equipped (as per the requirement given in Column 2 of Table-1) and staffed, where different tests given in the specification shall be carried out in accordance with the methods given in the specification.

1.1 The manufacturer shall prepare a calibration plan for the test equipment.

2. TEST RECORDS The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. LABELLING AND MARKING : The Standard Mark as given in Schedule of the license and Licence Number (i.e. CM/L.....) shall be incorporated, and the marking shall be done as per the provisions of the Indian Standard, provided always that the product thus marked conforms to all the requirements of the specification. In addition, details of BIS website shall be marked as follows: “For details of BIS certification please visit www.bis.gov.in”

3.1 Instructions for use: The manufacturer, supplier or distributor shall supply instructions for use with each pressure regulator, and with each pressure regulator with a flow-metering device as per Clause 8 of **IS 6901:2018**.

4. CONTROL UNIT: For the purpose of this Scheme, the control unit shall consist of a lot of regulators of the same type & size manufactured in a day from the material of same supplier, under similar process of production.

5. LEVELS OF CONTROL - The test and inspection indicated in Table 1 attached and at the levels of control specified therein shall be carried out on the whole production covered under this scheme and appropriate records maintained in accordance with paragraph 2 above..

5.1 MATERIAL AND TEST CERTIFICATE- Materials for pressure regulators and pressure regulators with flow-metering devices shall conform to the requirements of ISO 9539. Test Certificate shall be supplied by the supplier with each consignment for the regulator fabrication. The Bureau shall be given the opportunity of making an independent check test, if necessary. The manufacturer of the regulators should establish means to identify the regulators with the certificate

5.2 DESIGN AND CONSTRUCTION: The regulators shall conform to the requirements in Clause 5.2 of IS 6901:2018

5.3 TYPE TEST – Type test procedure shall be followed as laid down in Clause 9 of IS 6901:2018.

7. REJECTIONS–Disposal of non-conforming product shall be done in such a way so as to ensure that there is no violation of provisions of BIS Act, 2016. A separate record providing the detailed information regarding the rejected material and mode of their disposal shall be maintained. Such material shall in no case be stored together with that conforming to the specification. The Standard Mark (if already applied) on rejected material should be defaced.

**SCHEME OF INSPECTION AND TESTING
FOR CERTIFICATION OF IS 6901:2018/ISO 2503:2009**

Table 1: Levels of Control

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or)S: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Methods			No. of Sample	Frequency	Remarks
		Clause	Reference				
5.1	Materials	-	IS15946:2018/ISO 9539:2010	S	One	Each consignment	No testing is required if material is ISI Marked.
5.2	Design and Construction	5.2.1 to 5.2.11	IS 6901:2018	R	Each piece	Each Piece	
6	Physical Performance and operating characteristics	6.1 to 6.6	IS 6901:2018	R	One	Each control unit	
6.4	Pressure Relief Valve	9.7.5	IS 6901:2018	R	Each piece	Each piece	
9.8	Test for durability of markings	9.8	IS 6901:2018	R	One	Each control unit	

Note-1: Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled by the Bureau.

Note-2: Levels of control given in column 3 are only recommendatory in nature. The manufacturer may define the control unit/batch/lot and submit his own levels of control in column 3 with proper justification for approval by B.O. Head.

Note-3: One consignment of material is defined as all material of one defined type and quality, delivered to the manufacturer by one supplier according to one dispatch note.