

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:4923

29 11 2022

विषय: संशोधन संख्या 02 से आईएस 4923:2017 के कार्यान्वयन के लिए दिशानिर्देश

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/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:4923

29 11 2022

Subject: Guidelines for implementation of Amendment No.02 to IS 4923:2017

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/LRMD

CENTRAL MARKS DEPARTMENT-2

OurRef:CMD-2/16:4923

Date: 29.11.2022

Subject: Guidelines for implementation of Amendment no. 2 to IS 4923:2017 – (Hollow Steel Sections for Structural Use- Specification)

1. Amendment no. 2 to IS 4923:2017 has been published. The amendment shall be implemented with effect from **17 April 2023**.
2. All BOs shall inform the Applicants and Licensees under their jurisdiction about implementation of the above amendment within a week of issuance of these guidelines.
3. The significant changes in the standard through this amendment 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 amendment.

Clause No.	Change
2 References	Latest versions of the reference standards have been updated Reference to Hot Rolled Medium and High Tensile Structural Steel as per IS 2062, Method of Testing Uniformity of Coating on Zinc Coated Articles as per IS 2633 , Methods for determination of mass of zinc coating on zinc coated iron and steel articles as per IS 6475 and Galvanized Structural Steel as per IS 16732 have been added
3.4 Section (Terminology)	Definitions of Cold Forming and Hot Forming have been added
6.1 Designation	02 new grade designations i.e. Yst 420 and Yst 460 have been added and it has been specified that the hollow steel sections shall be graded as Yst 210, Yst 240, Yst 310, Yst 355, Yst 420 and Yst 460 depending on the yield strength of the Hollow Steel Section
cl.7.1 Manufacture	The clause has been modified to state that the seamless steel sections shall be manufactured from steel made by any process at the discretion of the manufacturer. For welded sections, reference to IS 10748 has been deleted and it has been stated that they shall be manufactured as per IS 2062 and in case of grade Yst 210 it shall be manufactured from Hot Rolled Steel Strips with mechanical properties and chemical composition as agreed to between the manufacturer and purchaser (until a suitable grade is incorporated in IS 2062)

cl.9.1. Dimensions and Weights	The clause has been modified to state that for non-standard sizes (not mentioned under Table 1 and 2) the thickness of hollow steel sections shall not be less than the minimum thickness specified for the next higher standard size in Table 1 and 2.
cl.10.7, Fig 5 Straightness and Twist	The figure with regards to the Total Twist of Square or Rectangular Hollow Sections Key has been substituted by a new figure. Method for measurement of Straightness in Square or Rectangular Hollow Section has been specified and Figure 7 with regards to the same has been added
cl.11.1 Oiling and Painting	The clause has been modified to state that in case of galvanizing the mass of coating shall be tested as per IS 6745. The requirements of thickness and mass of coating have been specified at Annex B
cl.15.2 Mechanical Tests (Hot Formed Sections)	The reference standard for test method for tensile properties has been updated. The applicability of Yield Strength values has been added . For Elongation, the applicability of specified values in Table 3 on a gauge length of 50 mm and width of 12.5 mm has been added.
Table 3 Tensile Properties of Hot Formed Sections	The existing table has been substituted by a new table as per which tensile properties of the 02 new grades Yst 420 and Yst 460 have been specified.
cl.19.2 Mechanical Tests (Cold Formed Sections)	The reference standard for test method for tensile properties has been updated. The applicability of Yield Strength values has been added . For Elongation, the applicability of specified values in Table 3 on a gauge length of 50 mm and width of 12.5 mm has been added.
Table 3 Tensile Properties of Cold Formed Sections	The existing table has been substituted by a new table as per which tensile properties of the 02 new grades Yst 420 and Yst 460 have been specified.
Table 1 Dimensions and Properties of Square Hollow Sections	The existing table has been substituted by a new table in which new standard sizes such as 20 x 20 x 2 , 50 x 50 x t, 60 X 60 x t, 70 x 70 xt, 80 x 80 x t, 90 x 90 x t, 120 x 120 x t, 140 x 140 x t, 160 x 160 x t, 200 x 200 x t, 260 x 260 x t etc. have been added
Table 2 Dimensions and Properties of Square Hollow Sections	The existing table has been substituted by a new table in which new standard sizes such as 40 x 20 x t , 50 x 30 x t, 60 X 40 x t, 70 x 50 xt, 80 x 50 x t, 80 x 60 x t, 90 x 50 x t, 100x 40 x t, 100 x 60 x t, 100 x 80 x t,120 x 60 x t, 120 x 80 x t , 140 x 80 x t, 150 x 100 x t, 160 x 80 x t, 180 x 100 x t, 200 x 120 x t,250 x 150 x t, 300 x 100 x t etc.have been added

4. The existing Product Manual has been revised on account of this amendment and the same is being circulated separately.
5. The guidelines for implementation of the amendment are given below:

LICENSEES:

All Licensees shall implement the amendment by **17 April 2023**. 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 IS 4923 without the amendment after **17 April 2023**. **The status of implementation of the amendment shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.**

a) Actions to be taken for implementation of the Amendment

- i) BOs shall advise all licensees under their jurisdiction to procure ISI marked Hot Rolled Strips as per IS 2062:2011 for manufacture of welded sections as per IS 4923. Manufacturing of Welded Sections from Hot Rolled Strips as per IS 10748 shall only be permitted up to **16th April 2023**.
- i) Licensees would be required to submit in-house or independent test reports of sections ,manufactured from Hot Rolled Strips as per IS 2062, of sizes and grades covered under their existing scope of licence as per IS 4923 as per Grouping Guidelines, to their respective BOs for implementation of the amendment.
- ii) In case of Galvanized Sections, licensees shall be required to establish testing facilities for Mass of Zinc Coating as per IS 6745 and Coating Thickness, as per Annex B, and shall confirm the same to their respective BOs through suitable documentary evidences.
- iii) BOs shall plan an early surveillance visit, preferably within 30 days of implementation of the amendment, for verification of the procurement of raw material strips as per IS 2062 and manufacturing of welded sections from those strips as per IS 4923. Further, BOs shall verify that the licensee is not manufacturing welded sections from Hot Rolled Strips as per IS 10748 and no raw material as per IS 10748 is available with the licensee.

APPLICATIONS FOR GRANT OF LICENCE:

Existing Applications where Sample has been submitted in the Laboratory/Test Report has been issued by the Laboratory may be processed without consideration of the amendment. However, if the Applicant is desirous of considering the amendment, 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 while considering the provisions of the amendment, Licence will not be granted as per the old version.

Applications which are recorded henceforth may be processed with or without consideration of the amendment. Processing of Applications without consideration of the amendment shall be permitted only upto **16 April 2023** and for such cases Applicant shall give a declaration that they will implement the amendment by **17 April 2023**.

Beyond **17 April 2023** no Licence shall be granted without consideration of the amendment.

CHANGE IN SCOPE OF LICENCE:

For change in scope of licence, the relevant provisions as given above for Applicants shall apply.

However, processing of such applications for change in scope of licence without consideration of the amendment shall be permitted only up to the date of implementation of the amendment by the licensee or up to **17 April 2023** whichever is earlier.

6. The above guidelines shall come into force with immediate effect.

Shivam Ahuja

Sc.C.(CMD-2)

Head (CMD-2)

DDG (Certification)