केन्द्रीय मुहर विभाग –2

संदर्भ -: के.मू.वि. -2/16:1875 28.01.2026

विषय: **संशोधित IS 1875:2025 के अनुपालन हेतु 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।

रंजीत कुमार
वैज्ञानिक 'ई'

प्रमुख (के.मू.वि.- 2)
सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:1875 28.01.2026

Subject: Guidelines for implementation of Revised IS 1875:2025.

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.

(Ranjit Kumar)
Scientist 'E'

Head (CMD-2)

All ROs/BOs/Labs/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref:CMD-2/16:1875 **Date: 28.01.2026**

Subject: Guidelines for implementation of Revised IS 1875:2025 (Steel Ingots, Billets, Blooms, Slabs and Bars for Forging) and switchover of BIS licence from IS 4368:1967 & IS 13352:1992 to revised IS 1875:2025.

1. IS 1875:1992 has been revised and published as IS 1875:2025. This standard will supersede IS 4368: 1967 'Specification for alloy steel billets, blooms and slabs for forging for general engineering purposes' and IS 13352: 1992 'Stock for forgings produced from continuously cast blooms, billets and slabs – Specification' as all the requirements of these two standards have been amalgamated in this standard. The last date for implementation of the revised Standard is **23th March 2026** after which the old Standard shall stand withdrawn.

2. All BOs shall inform the Applicants and Licensees under their jurisdiction about implementation of the revised Standard within a week of issuance of these guidelines.

3. The significant changes in the revised Standard as listed in the Table below 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) /Table (s) as per IS 1875:2025	**Change**
Title	Title of the standard has been modified from "Carbon Steel Billets, Blooms, Slabs and Bars for Forgings" to **"Steel Ingots, Billets, Blooms, Slabs and Bars for Forging"**
1 Scope	The scope has been enhanced to include low and medium alloyed steel grades and ingots as well, in addition to the existing unalloyed Steel Billets, Blooms, Slabs and Bars for Forgings.
4 Supply of Material	The Clause 4 has been modified, and the standard now refers to **IS 8910 "General Technical Delivery Requirements for Steel and Steel Products"** in place of the earlier referenced IS 1387 "General Requirements for the Supply of Metallurgical Materials" for general requirements relating to the supply of steel.
5 Manufacture	The Clause 5 has been modified to include the processes used for **making steel shall be left to the discretion of the manufacturer**. It is also specified that when so desired, the purchaser and

	manufacturer may agree to a particular secondary steel making/refining technology including degassing etc. Further, **the requirement of total reduction for the stocks made from ingot, continuously cast billet, bloom or slab have also been specified.**
6 Freedom from Defects	The clause has been modified to widen its scope and make it more descriptive. Fig.1 & Fig.2 specifying the reference for acceptance criteria based on inspection by sulphur print and macro-etching methods for stock produced from continuous-cast steel, have also been added. **The requirement of Macrostructure was earlier specified under Supplementary Requirements.**
7 Chemical Composition	Earlier only 9 grades of unalloyed steel were specified. In the revised standard, in addition of unalloyed steel, 16 additional categories of steel (low alloyed and medium alloyed steel) have been added covering a total of 129 grade designations as under: (1) Unalloyed Steel- 23 Grades (including 09 old grades) (2) Resulphurized Steel- 06 Grades (3) Silicon Alloyed Steel- 02 Grades (4) Nickel Steel- 01 Grade (5) Chromium Steel- 14 Grades (6) Silicon Manganese Steel- 01 Grades (7) Manganese Chromium Steel- 04 Grades (8) Silicon Chromium Steel- 02 Grades (9) Nickel Molybdenum Steel- 01 Grades (10) Manganese Molybdenum Steel- 02 Grades (11) Nickel Chromium Steel- 14 Grades (12) Chromium Molybdenum Steel- 21 Grades (13) Chromium Vanadium Steel- 05 Grades (14) Nickel Chromium Molybdenum Steel- 23 Grades

	(15) Chromium Molybdenum Vanadium Steel- 01 Grades (16) Chromium Molybdenum Aluminium Steel- 02 Grades (17) Steels with Boron-07 Grades In view of the addition of new grades, the Table on Chemical Compositions have also been modified.
8 Dimensional Tolerance	The clause 8 has been modified to include the dimensional tolerances for length (billets, blooms and slabs), bend (slabs), camber (slabs), corner radius (rolled square billets), straightness have been added in additions to Tolerances on width/thickness.
9 Conditions of Delivery	A new clause 9 specifying Conditions of Delivery has been added.
10.1 Tensile Test	The tensile properties of newly added grades shall be **mutually agreed between the purchaser and the supplier.**
10.2 Hardness Test	The hardness test has been relaxed and now the hardness requirements of the test piece **shall be mutually agreed.**
10.3 Hardenability test	A new clause specifying requirements of hardenability test has been added. The complete end quench hardenability band and hardness, at fixed distance shall be **as agreed to between the manufacturer and the purchaser** or **else as given in Table 5.**
10.4 Grain Size	The requirement of Grain Size determination which was earlier specified under optional tests has now been included in primary tests.
11 Sampling	The sampling requirements have been modified to include provisions for check analysis, as well as sampling requirements for material supplied on the basis of maximum hardness and under other delivery conditions.
13 Optional requirements	New tests have been included in the 'Optional requirements' clause as under: (a) Hot Upset Test (b) Inclusion Rating (c) Decarburization Depth

	(d) Step machined test (e) Macrostreak flaw test (f) Blank hardening test for core strength guarantee (g) Microstructure for machinability including banding
14 Marking	The marking clause has been modified.

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 1875 has been revised which is being circulated separately.

5. The guidelines for implementation of the revised Standard is given below:

A. LICENSEES:

i) Switchover of Existing Licensees of IS 1875:1992

a) For switchover to revised standard, Licensees shall submit evidence of conformity to the additional/modified requirements through In-house/Independent Test Reports.

b) Licencee shall submit declaration for additional Testing equipment/arrangement in Form no. II as applicable.

c) All Licensees shall implement the revised Standard by **23rd March 2026.** Any difficulty in implementation shall be brought to the notice of CMD-2 immediately after issuance of these guidelines, and in any case, not later than seven days prior to the implementation date. BOs shall ensure that no Licences are under operation as per old Standard after 23rd March 2026. The status of implementation of the revised Standard shall be confirmed by Head (BO) to CMD-2 within one week of the last date of concurrent running.

ii) Switchover of Existing Licensees of IS 4368:1967 & IS 13352:1992 who does not hold licence as per IS 1875:

a) For switchover to revised standard IS 1875:2025, licensees shall be required to classify the steel grades/designations, covered under the existing scope of licence and re-designate them as per clause-7 and Table 1 & 2 of IS 1875:2025. Subsequently, licensees shall submit declaration with regards to their equivalent scope of licence as per IS 1875:2025 (Refer Scope of Licence specified in the Product Manual of IS 1875:2025).

b) Licencee shall submit declaration for additional Testing equipment in Form no. II as applicable.

c) Submit In-house/Independent Test Reports of the re-designated grades under applicable groups of steel as per IS 1875:2025.

iii) 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:

i) 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.

ii) 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 22nd March 2026 and for such cases Applicant shall give a declaration that they will implement the revised Standard by **23rd March 2026.**

iii). Beyond 23rd March 2026 no Licence shall be granted as per the old Standard.

C. CHANGE IN SCOPE OF LICENCE:

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

ii) 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 23rd March 2026 whichever is earlier.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)

ROs/BOs