

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:14650

17 11 2023

विषय: संशोधित IS 14650:2023 के अनुपालन के दिशा निर्देश (आईएस 14650:1999, आईएस 2830:2012, आईएस 2831:2012, आईएस 8052:2006, आईएस 8951:2001 और आईएस 8952:2005 का स्थान लेता है)

यह उपरोक्त विषय के संदर्भ में है।

सक्षम अधिकारी द्वारा अनुमोदित दिशानिर्देश अनुपालन हेतु संलग्न है।

आईएस 14650:1999 को आईएस 14650:2023 के रूप में संशोधित किया गया है, जो आईएस 14650:1999, आईएस 2830:2012, आईएस 2831:2012, आईएस 8052:2006, आईएस 8951:2001 और आईएस 8952:2005 का स्थान लेता है।

सभी आरओ/बीओ इन दिशानिर्देशों को तत्काल प्रभाव से सूचना और कार्यान्वयन के लिए अपने अधिकार क्षेत्र के तहत इन 6 प्रतिस्थापित भारतीय मानकों के सभी आवेदकों और लाइसेंसधारियों को प्रसारित करेंगे।

शिवम आहूजा
वैज्ञानिक सी

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:14650

17 11 2023

Subject: Guidelines for implementation of revised IS 14650:2023 (superseding IS 14650:1999 ,IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001 and IS 8952:2005)

This has reference to the subject mentioned above.

The Competent Authority has approved the enclosed Guidelines for implementation.

IS 14650:1999 has been revised as IS 14650:2023, superseding IS 14650:1999 ,IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001 and IS 8952:2005.

All ROs/BOs shall circulate these guidelines to all applicants and licensees of these 6 superseded Indian Standards, under their jurisdiction, for information and implementation with immediate effect.

(Shivam Ahuja)
Scientist C

Head (CMD-2)

All ROs/BOs/Labs/MTD/LRMD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 14650

17 11 2023

Subject: Guidelines for implementation of revised IS 14650:2023 (Unalloyed and Alloyed Steel Ingot and Semi-Finished Products for Re-Rolling Purposes — Specification) (superseding IS IS 14650:1999 ,IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001 and IS 8952:2005)

1. This has reference to the above.
2. IS 14650:1999 is under compulsory BIS Certification with 19 licences in operation presently.
3. Presently, Indian Standards pertaining to ingots/semi-finished products for particular use are covered under IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001 and IS 8952:2005. For these 05 standards, 776 licences (IS 2830-660, IS 2831-111, IS 8052-01, IS 8951-02, IS 8952-02) are operative domestically.
4. Apart from the above standards, all other semi-finished products are covered under IS 14650:1999 i.e. IS 14650:1999 covers semi-finished steel which may be used for any steel products irrespective of its use.
5. Accordingly, IS 14650:1999 has been revised as IS 14650:2023, superseeding IS 14650:1999 ,IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001 and IS 8952:2005, with its date of implementation as **28th September 2024**.
6. IS 14650:2023 is a single standard for all semi-finished products which may be used for re-rolling into any steel product irrespective of its use.
7. The salient features of revised IS 14650:2023 are given below:

Clause(s) as per IS 14650:2023	Specified Requirement
1 Scope	<p>This standard covers the requirement of unalloyed and alloyed steel ingots and semi-finished products for rolling into different products conforming to applicable Indian Standard. Semi-finished products include continuously cast products and products generally obtained by forging or rolling ingots and intended for transformation into different steel products</p> <p>The requirements of this standard shall not be applicable to carbon and alloyed steel ingots and semi-finished products for forging.</p> <p>The requirements of this standard shall not be applicable to mild steel for metal arc welding electrodes.</p>
5 Product Designation	<p>A new clause has been added as per which the designation of the semi-finished product has been defined based upon its corresponding hot rolled product standard and grade/designation of the hot rolled product.</p> <p>Examples: 1) IS 14650 CPS 2062/E250 BR</p>

	<p>2) IS 14650 CPS 1786/Fe 500D</p> <p>Steel designated as per a product standard can be used to produce another grade of product provided the chemical composition fulfills the requirement of that grade</p>
6 Manufacture	Steel shall be supplied rimmed/semi-killed/ killed as per the product standard. For cases, where it is not mentioned in product standard, it may be supplied as agreed to between the purchaser and the supplier
7 Chemical Composition	<p>The chemical composition of steel shall conform to the ladle analysis requirements of the relevant product standard under which the ingots and semi-finished products have been ordered.</p> <p>In order to get the desired properties, restricted chemistry may be mutually agreed to between the purchaser and the supplier</p>
10 Dimensions	<p>The size and shapes shall be subject to mutual agreement between the purchaser and the manufacturer</p> <p>The length shall be subject to mutual agreement between the purchaser and the manufacturer</p>
11 Tolerances	<p>Tolerances of billets of Width Across Flat > 75 mm to 125 mm, >125 mm to 150 mm and Over 150 mm have been added</p> <p>For other products, tolerances shall be subject to mutual agreement between the purchaser and the manufacturer.</p> <p>The requirements of Bend and Camber in case of slabs have been added</p>
13 Optional Tests	The requirement of Inclusion content (see IS 4163) has been added in the Optional Tests as per mutual agreement between manufacturer and purchaser

8. The existing Product Manual has also been revised on account of the revision and the same is being circulated separately.

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

A. LICENSEES:

a) Switchover of Existing Licensees of IS 14650:1999, IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001, IS 8952:1995 to IS 14650:2023

i) For switchover to revised standard IS 14650:2023, licensees shall be required to :

a) Classify the steel grades , covered under the existing scope of licence, as per the categories and sub-categories specified in the Grouping Guidelines (Refer Annex A of the Product Manual of IS 14650:2023) and re-designate them as per cl.5. of IS 14650:2023 . Subsequently, licensees shall submit declaration with regards to their equivalent scope of licence as per IS 14650:2023 (Refer Scope of Licence specified in the Product Manual of IS 14650:2023).

b) In cases where no steel grades are specified in existing scope of licence, such licensees shall submit declaration with regards to their intended scope of licence as per Scope of Licence specified in the Product Manual of IS 14650:2023.

c) Submit In-house/Independent Test Reports ,of the re-designated grades or grades covered under intended scope of licence (for cases as per b)) , as per IS 14650:2023, for each sub-category of steel as per Grouping Guidelines.

ii) An example for an existing licensee of IS 14650:1999 is given below for better understanding:

Existing Scope of Licence (3)	Classification and Re-designation of existing Steel Grades (4)			Equivalent Scope of Licence (5)	
Billets of Grade Fe 500 of IS 1786, Fe 500 (Cu) of IS 1786, Fe500D of IS 1786, Fe500 D(Cu) of IS 1786	Category	Sub-Category	Product Designation (Steel Grades)	Product Type	Continuously Cast Billets
	Carbon Steel	Low Carbon	IS 14650 CPS 1786/Fe 500D IS 14650 CPS 1786/Fe 500	Category of Steel (Sub-Category)	As per column 4
	Alloy Steel	Low Alloy	IS 14650 CPS 1786/Fe 500 (Cu) IS 14650 CPS 1786/Fe 500 D(Cu)	Product Designation(Steel Grade)	
				With or without optional requirements	Without optional requirements

iii) On receipt of the above evidences of conformity, BOs shall issue endorsement for switchover of the licence to IS 14650:2023 along with revised scope of licence.

iv) All Licensees shall implement the revised standard by **28th September 2024**. 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 the old versions i.e IS 14650:1999, IS 2830:2012, IS 2831:2012, IS 8052:2006, IS 8951:2001, IS 8952:1995 IS after **28th September 2024**. **The status of implementation of the revised standard shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.**

v) For inclusion of new steel grades in the existing scope of licence, the latest guidelines for change in scope of licence (CSoL) shall be referred.

vi) **However, if a request is received from a licensee, inclusion of new steel grades may also be permitted on factory testing basis through a special inspection. In such**

cases, BOs shall plan to carry out a special inspection preferably within 15 days from the date of receipt of the request.

vii) Verification for implementation of the revised standard may be carried out during the next surveillance visit. 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:

1. 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 from such Applicants also be obtained that in new test requirements, Licence will not be granted by BIS as per the old version.
2. 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 upto **27th September 2024** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **28th September 2024**.
3. Beyond **28th September 2024** no Licence shall be granted as per the old Standard.

C. CHANGE IN SCOPE OF LICENCE:

1. For change in scope of licence, the relevant provisions as given above for Applicants shall apply.
2. 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 **28th September 2024** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja
Sc. C

Head (CMD-2)
DDG (Certification)
ROs/BOs