

केन्द्रीय मुहर विभाग -2

संदर्भ -: के.मू.वि. -2/16:10748

15.04.2026

विषय: संशोधित IS 10748:2025 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-2/16:10748

15.04.2026

Subject: Guidelines for implementation of Revised IS 10748:2025.

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-2/16:10748

Date: 15.04.2026

Subject: Guidelines for implementation of Revised IS 10748:2025 (Hot-Rolled Steel Plates, Sheets and Strips for Welded Tubes and Pipes).

1. IS 10748:2004 has been revised and published as IS 10748:2025. The last date for implementation of the revised Standard is 10th June 2026 after which the old Standard shall stand withdrawn.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 10748:2025	Change
Title	Title has been changed from ‘Hot rolled steel strip for welded tubes and pipes’ to ‘Hot-Rolled Steel Plates, Sheets and Strips for Welded Tubes and Pipes’
1 Scope	The scope has been enhanced to include steel plates and sheets as well along with steel strip in coil form. The end use has also been extended to welded hollow sections for various application as well along with welded steel tubes and pipes.
3 Terminology	The terminology of Weldability (Cl 3.4), Fine-grain Steel (Cl 3.5), As-rolled (Cl 3.6), Normalizing Rolling (Cl 3.7), Normalized (Cl 3.8), Thermo-Mechanical Rolling (TM) (Cl 3.9) have been added. Further, terminology of coil has been modified to remove the requirement of at least 50 laps.
5 Grades	A total of 26 new grades have been introduced, thereby expanding the scope of the standard to 32 grades, as against 6 grades specified in the earlier version. These grades have been classified into three categories, as detailed below:

	<p>(i) Grades defined by chemical composition and mechanical properties: A total of 8 grades are covered under this category, comprising 6 existing grades from the previous version and 2 newly introduced grades (Grade 7 & Grade 8). Accordingly, Table 1 (Chemical Composition) and Table 5 (Mechanical Properties) have been revised to incorporate the new grades. Further, the chemical composition of existing Grade 2, Grade 3 & Grade 5 have been relaxed.</p> <p>(ii) Fine grain steel grades: This is a newly introduced category covering 4 grades. Correspondingly, Table 2 (Chemical Composition) and Table 6 (Mechanical Properties) have been newly incorporated.</p> <p>(iii) Grades defined by chemical composition only: This is also a newly introduced category covering 20 new grades. Correspondingly, Table 3 (Chemical Composition) has been newly added.</p>
4 Supply of Material	The clause 4.2 has been modified to specify that Impact test requirements can be mutually agreed between the purchaser and supplier for fine grain steel.
6 Manufacture	<p>New clauses 6.3 & 6.3.1 have been introduced which specify the supply condition of fine grain steel grades.</p> <p>New Clauses 6.4 and 6.5 have also been introduced to specify the supply conditions of hot-rolled plates, sheets, and strips. These may be supplied in various conditions, including as-rolled, normalized, normalized rolled, controlled rolled, or thermo-mechanically rolled, as well as in descaled and oiled condition, as agreed between the purchaser and the manufacturer.</p>
Table 4 (Permissible Variation for Product Analysis)	Table 2 has been modified to incorporate the additional requirement with respect to permissible variation of elements Cu, Ni, Cr, V, Nb, Ti, Mo, N, B and Al.
7.4	A new clause has been introduced which specify that Max. CEV can be increased for steels with control on Si.

8.1 (Number of Tensile Tests)	Clause 8.1 (Number of Tensile Tests) has been modified. The number of tensile tests is now specified irrespective of cast/heat size, as against the earlier provision where it was based on cast/heat size.
9.1 (Number of Bend Tests)	Clause 9.1 (Number of Bend Tests) has been modified. Earlier it was specified that one bend test shall be tested per cast per thickness. Now in the revised standard it is specified that Number of test samples shall be 2 from each cast/heat of same grade, quality and delivery condition irrespective of cast/heat size.
13 Tolerances	Clause 13.2 has been modified. Earlier, the tolerance for edge camber was specified with reference to IS 1079, however, in the revised standard, the tolerances for edge camber have been explicitly incorporated within the standard itself.
14 Calculation of Mass	A new clause 14 has been introduced which specify that the mass of the steel shall be calculated on the basis that steel weighs 7.85 g/cm^3 .
15 Condition of Delivery	A new clause 15.1 has been introduced which specify that the material shall be in as-rolled, normalized, normalized rolling or thermomechanical rolling condition without any skin passing, pickling, oiling, and blast cleaning, annealing and normalizing unless otherwise specified by the purchaser.

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 10748 has been revised which is being circulated separately.

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

A. LICENSEES:

i) All Licensee of IS 10748:2004 shall switch over to IS 10748:2025 by **10th June 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 10th June 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) Licensees shall be required to submit evidence of conformity to the additional/modified requirements for the grades presently covered under their scope of licence through In-house/Independent Test Reports.

iii) If the licensee fails to complete all actions by 10th June 2026 it shall be dealt with as per the prevailing guidelines.

iv) 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 09th June 2026 and for such cases Applicant shall give a declaration that they will implement the revised Standard by 10th June 2026.

iii). Beyond 10th June 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 10th June 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