

केन्द्रीय मुहर विभाग -2

संदर्भ :- केमूवी-2/16:18809

23-07-2026

विषय: आई एस 18809:2024 के संशोधन संख्या 01 का 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।

**रंजीत कुमार
वैज्ञानिक "ई"**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:18809

23-07-2026

Subject: Guidelines for implementation of Amendment No.01 to IS 18809:2024.

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

OurRef:CMD-2/16:18809

Date: 23-07-2026

Subject: Guidelines for implementation of Amendment No. 01 to IS 18809:2024 (Wear and Abrasion Resistant Steel Sheet and Plate).

1. Amendment no. 01 to IS 18809:2024 has been published. The last date for implementation of the amendment is **19th September 2026**.

2. 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	Change
6 Manufacture	A reference to IS 14650 (Unalloyed and Alloyed Steel Ingot and Semi-Finished Products for Re-Rolling Purposes) has been introduced in Clause 6.1. Accordingly, the steel used for the manufacturing the product shall conform to the requirements of IS 14650.
7.1 Ladle Analysis	A reference to IS 8811 has been incorporated in clause 7.1 as a test method, in addition to earlier specified IS 228 or any other established instrumental/chemical method, for carrying out product analysis.
Table 2 Chemical Composition	A Note has been introduced below the table through which the composition of Cr, Ni and Mo are allowed to be increased beyond the specified limits and other unspecified elements are also allowed to be added, if, agreed upon between the manufacturer and the purchaser. In such cases, the hardness requirement shall also be mutually agreed upon, provided it exceeds the minimum specified hardness of the nearest applicable grade.’
8.1 Hardness Test Annexure-B	The hardness test requirements have been modified to specify that, for plates thicker than 20 mm , the minimum core hardness shall

	be 90% of the guaranteed minimum surface hardness, and the same may be determined as per Annex B. Further, it has also been specified that IS 4258 shall be used for conversion of hardness values.
8.1.1 Sampling	The sampling requirement has been modified to specify the sampling frequency (60 MT of part thereof). Also, the requirement of test sample for plates has also been modified.
Page 4 Informal Table	Editorial changes The heading of Col(3) of the table has been modified from ‘Depth of Milling or Grinding (mm)’ to ‘Depth of Milling or Grinding, Min (mm)’.
11 Freedom from Defects	The clause 11.2 has been modified and a new table 9 has been introduced which specifies the requirement of maximum permissible depth of ground areas with a maximum of 2 percent of the inspected area as per Table 9.
12.1 Flatness Tolerances	A new clause 12.1 and a new Table 10 specifying the special flatness tolerances of Q&T plates have been added. The flatness tolerance requirement is applicable if agreed at the time of enquiry and order.

3. Consequent upon the issuance of aforementioned amendment, the existing product manual of IS 18809:2024 has been revised which is being circulated separately.

4. The guidelines for implementation of amendment no 01 to the IS are given below:

A. LICENSEES:

i) All Licensees shall implement the amendment by **19th September 2026**. Any difficulty in implementation shall be brought to the notice of CMD-2 immediately after issuance of these guidelines. BOs shall ensure that no Licences are under operation without this amendment after **19th September 2026**. The status of implementation of the amendment shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of implementation.

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, as applicable.

iv) BOs shall plan an early surveillance visit for verification of the implementation of the amendment preferably within 30 days from confirmation of implementation of the amendment to standard by licensee.

v) If the Licensee fails to complete all actions by **19th September 2026**, it shall be dealt with as per the prevailing guidelines.

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 IS with/without the amendment. However, if the applicant is desirous of considering the application, with the amendment to the IS, 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 IS incorporating the amendment, Licence will not be granted by BIS without considering the amendment.

ii) Applications which are recorded henceforth may be processed with or without considering amendment to the IS. Processing of applications without considering the amendment, shall be permitted only up to **18th September 2026** and for such cases Applicant shall give a declaration that they will implement the amendment by **19th September 2026**.

iii). Beyond **19th September 2026**, no Licence shall be granted without considering the amendment.

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 without considering the amendment shall be permitted only up to the date of implementation of the amendment or up to **19th September 2026** whichever is earlier.

5. BOs are requested to circulate these guidelines to licensees and applicants under their jurisdiction immediately after issuance of this circular.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)