

**Draft Addendum & Correction Slip No. 2 of March 2025**  
**To**  
**IRS Specification for Fusion Welding of Rails by Alumino Thermic Process**

**Serial No. IRST-19-2021**

**1. Para 3.2 has been modified as:**

Every portion shall be packed in a moisture proof bag of polyethylene to IS:9738, "Indian Standard Specification for polyethylene bags for general purposes" Grade HM HDPE of 150-micron thickness which shall be sealed so as to make it airtight. The polyethylene bag shall ~~then~~ be packed in a heavy-duty bag made of new cloth to IS:187 or any other superior packaging approved by RDSO. The open end of this packaging shall be stitched and sealed in such a manner that there is no access to the 'portion' without damaging the bag / packaging or breaking its seal. ~~Then each portion bag shall be packed in PVC bucket conforming to IS:3730 bearing the details as per Para 3.3 of IRST-19. The bucket shall have colour code as per Para 3.4.1(i) of IRST-19 for easy identification. The bucket shall be auto-locked and not openable without damaging the lid.~~

**2. Para 9.0 of Annexure -2 has been modified as:**

**9.0 PACKING:**

9.1 Each pre-fabricated mould shall be individually packed and sealed in ~~polyethylene~~ bags of polyethylene ~~made out of polyethylene~~ conforming to IS: 9738-2003 Grade HM HDPE of 150 micron thickness or as prescribed by IRS-T-19-~~2020~~.

9.2 A pair of such packed moulds shall again be packed in ~~carton paper boxes confirming to IS: 2771 (Second Revision)~~ PVC bucket/box conforming to IS:3730. Proper ~~sealing-seal~~ packing of the bucket/box shall be done ~~on each cartoon~~. The bucket/box shall be auto locked and not openable without damaging the lid.

9.3 Each ~~cartoon~~ bucket/ box shall be clearly marked giving manufacturer's name, date of manufacture and rail section, batch number for easy identification