

**Reasoned documents of Comments submitted by M/s Kalimata Ispat Industries Pvt. Ltd. after meeting with ERC's manufacturers held on 18.07.23 at RDSO.**

SN	Clause No.	Remarks of RDSO in reasoned document	Comments of M/s Kalimata Ispat Industries Pvt. Ltd. received after meeting with ERC's manufacturers held on 18.07.23 at RDSO.	RDSO's comments
2.1	Clause 4.11 A	Tests of the Spring Steel Rounds in steel manufacturers' premises are consider adequate. Process inspection of Steel manufacturing is not practical, hence not incorporated	It is once again reiterated that casting of billet shall be tested by M&C Directorate of RDSO & is most important and shall be made mandatory for proper quality of raw materials. Proper stock register for casted billet and rolled billet shall be maintained. Without testing of billet by M&C Directorate of RDSO, only testing of Spring Steel Round by M&C Directorate of RDSO at Spring Steel Round manufacturers' premises will not serve the purpose to ensure proper quality of Spring Steel Round.	Spring Steel Rounds are rolled from casted billet or rolled billet. The purpose of ensuring the quality of Spring Steel Rounds shall be met testing the finished product Spring Steel Rounds.  It is more convenient to test the finished product Spring Steel Rounds to ensure the desire quality.  Hence not accepted.
2.1.	(b)	Inspection of Spring Steel Round shall be carried out by the agency nominated by Zonal Railways/ Tendering Authority.	Inspection of Spring Steel Round at manufacturers' premises shall be carried out by M&C Directorate of RDSO or officials of Zonal Railways who are trained by M&C Directorate of RDSO.	The suggestion has been examined and it has been incorporated in the corrigendum no. 2 of T-31
	(c)	ERC manufacture will issue the P.O. to Spring Steel Round manufacturer against the P.O. issued by Zonal Railway for ERC supply.  Thereafter Spring Steel manufacturer shall approach the	Casted billet and round bars shall be inspected and tested by M&C of RDSO and to be stored at round manufacturers premises as a continues process. After placing order by the ERC manufacturer, the bar as tested above shall be delivered to them along with the test of and Spring Steel Round done at the Round manufacturers premises.	The suggestion has been examined and it has been incorporated in the corrigendum no. 2 of T-31

2207

SN	Clause No.	Remarks of RDSO in reasoned document	Comments of M/s Kalimata Ispat Industries Pvt. Ltd. received after meeting with ERC's manufacturers held on 18.07.23 at RDSO.	RDSO's comments
		inspecting agency nominated by Zonal Railway for inspection of Spring Steel Round ERC		
2.2	Clause 4.11 A 1	<p>Suggestion of the firm for 100% check of rolled bars for crack detection through online magnetic particle crack detection testing machine is not agreed to, as this test is already been carried out by ERC manufacturer before manufacturing of ERCs.</p> <p>The suggestion regarding each bar should be identified with hologram duly pasted by inspecting is examined and is not found practical</p>	<p>RDSO's remarks are not acceptable since :</p> <p>(i) 100% check of rolled bars for crack detection through online magnetic particle crack detection testing machine for helical coil spring has been implemented by Mechanical Directorate of RDSO.</p> <p>(ii) The pasting of hologram in each round as already been implemented by Mechanical Directorate of RDSO for helical compression coil spring.</p> <p>Therefore, online crack detection and the pasting of hologram is very much feasible and should be Applicable for Spring Steel Round for ERC too.</p>	<p>100% check of rolled bars for crack detection is not agreed to, as this test is already being carried out by ERC manufacturers.</p> <p>However, pasting of hologram in each round after inspection has been examined and incorporated in the documents.</p>
2.8	Clause 4.11 A 7	<p>Suggestion impracticable as the manufacturer of raw material for ERC i.e. 55si7 round bars is not a dedicated manufacturer of 55si7 bars only.</p> <p>Hence, the clause remain unchanged</p>	<p>RDSO's remarks is not acceptable since the rejected heat may be used by the spring Steel bars manufacturer adopting malpractice.</p> <p>20.64mm &amp; 23mm diameter of grade 55si7 is dedicatedly used by Indian Railways for ERCs and hence the rejected heat shall be re-casted to avoid misuse and malpractice.</p>	<p>Remarks of the firm are not clear hence the para is remain unchanged.</p>
3.1	Clause 15.1	<p>The Purchaser/Consignee or its nominated representative shall pick up and seal 03 02 sample sets @ 20 30 nos. ERCs per lot in the presence of firm's representative within 01 month after receipt the material (ERC) at the consignee</p>	<p>The end user of ERC i.e. field PWI should lodge a complaint specifying the lot no and name of supplier to Chief Track Engineer of the consignee Railway regarding the poor quality of ERC specifying the defects. On the basis of above complaint, CTE shall intimate the concern supplier for joint sampling within one month from the date of intimation sent to supplier by CTE.</p>	<p>The suggestion has been examined and it has been suitably incorporated in the corrigendum no. 2 of T-31</p>



SN	Clause No.	Remarks of RDSO in reasoned document	Comments of M/s Kalimata Ispat Industries Pvt. Ltd. received after meeting with ERC's manufacturers held on 18.07.23 at RDSO.	RDSO's comments												
		depot and shall be preserved in the consignee depot or nominated location for a period of one year from the date of receipt of material.														
3.2	Clause 15.2	If the firm's representative does not turn up within one month after receipt of material (ERC) at the consignee end for joint sampling by Purchaser/Consignee, the sampling shall be done by Purchaser /Consignee solely.	If the supplier's representative does not turn - up within one month from the date of intimation of joint sampling, the sampling be done by the end user solely.	The suggestion has been examined and it has been suitably incorporated in the corrigendum no. 2 of T-31												
3.3	Clause 15.3	<p>The sealed sample set can be got tested by the Purchaser /Consignee, from NABL accredited labs within 06 months from the date of receipt material as per the discretion of Purchaser /Consignee. A total number of 14 nos. samples (ERCs) shall be tested for conformity as per following scheme:</p> <table><tr><td>No. of Samples</td><td>Test to be conducted for conformity</td></tr><tr><td>12</td><td>Dimension</td></tr><tr><td>06</td><td>Hardness, depth of decarburization, freedom from surface defects, Micro structure</td></tr></table>	No. of Samples	Test to be conducted for conformity	12	Dimension	06	Hardness, depth of decarburization, freedom from surface defects, Micro structure	<p>Two sets of sealed sample shall be picked up at random from the Consignee jointly in presence of supplier &amp; all the test should be carried out in presence of ERC supplier. Each set shall consist of 12 nos. ERCs, out of which 6 nos. shall be sent to RDSO Laboratory for dimensional check and Toe- load testing and other 6 nos. shall be send to NTH/Govt. NABL Laboratory for chemical and metallurgical test as per specification. The second set of samples shall be kept reserve for re- testing only for the parameter in which the first set of sample fails.</p> <table><tr><td>No. of Samples</td><td>Test to be conducted</td><td>Passing Criteria</td></tr><tr><td>06 nos.</td><td>Dimension</td><td>Out of 6 nos. ERCs taken for dimensional test minimum 4 nos. ERC should pass for dimensional test and two nos. should be allowed as</td></tr></table>	No. of Samples	Test to be conducted	Passing Criteria	06 nos.	Dimension	Out of 6 nos. ERCs taken for dimensional test minimum 4 nos. ERC should pass for dimensional test and two nos. should be allowed as	The suggestion has been examined and new para 15.8 (Acceptance / Rejection of samples) has been incorporated in the corrigendum no. 2 of T-31
No. of Samples	Test to be conducted for conformity															
12	Dimension															
06	Hardness, depth of decarburization, freedom from surface defects, Micro structure															
No. of Samples	Test to be conducted	Passing Criteria														
06 nos.	Dimension	Out of 6 nos. ERCs taken for dimensional test minimum 4 nos. ERC should pass for dimensional test and two nos. should be allowed as														



SN	Clause No.	Remarks of RDSO in reasoned document		Comments of M/s Kalimata Ispat Industries Pvt. Ltd. received after meeting with ERC's manufacturers held on 18.07.23 at RDSO.			RDSO's comments
			and inclusion rating and chemical analysis on 02 samples			Non Confirmatory.	
		06	Toe-load, flat bearing area, application deflection test	06 nos.	Hardness, depth of decarburization, freedom from surface defects, Micro structure and inclusion rating and chemical analysis on 02 samples	Out of 6 nos. ERCs taken for Hardness, depth Of decarburization, freedom from surface defects, Micro structure and inclusion rating test minimum 4 nos. ERC should pass for Hardness, depth of decarburization, freedom from surface defects, Micro structure and inclusion rating in each individual test and two nos. should be allowed as Non Confirmatory in each individual test and in chemical analysis both the samples should pass.	
				06 nos. (Which are dimensionally checked).	Toe-load, flat bearing area, application deflection test	Out of 6 nos. ERCs taken for Toe-load, flat bearing area, application deflection test minimum 4 nos. ERC should pass in each individual test for Toe-load, flat bearing area, application deflection test and two nos. should be allowed as Non Confirmatory in each individual test.	

Reasoned documents of Comments submitted by ERC's manufacturers after meeting with ERC's manufacturers held on 18.07.23 at RDSO.

SN	ERCs manufacturer's suggestion regarding Inspection of raw material and its manufacturing process i.e., Spring Steel rounds 20.64mm/23mm of grade 55Si7 confirming to IS: 3195 for manufacture of ERCs at the premises of RDSO approved manufacturer of these spring steel rounds.	RDSO's Remarks
a)	The inspection shall be carried out by the RDSO/RITES or by the Nearest Zonal Railway officer competent and trained by track and MnC directorate of RDSO	The suggestion has been examined and it has been suitably incorporated in the corrigendum no. 2 of T-31
b)	Raw material Manufacturer has to submit an advance intimation letter at least 15 days prior to their rolling schedule to the Inspecting agency so that Inspecting agency could nominate their Inspecting official accordingly and send him for inspection round bars as per IRS-T-31 amended up to date.	
c)	The Raw material Manufacturer can offer the entire/partial quantity rolled or planned to roll for inspection as per their availability of material in advance or can enhance or decrease the quantity at the time of visit of Inspecting Officer depending upon the availability of the material Rolled.	
d)	The raw material manufacturer has to offer Size wise round bars, heat wise and quantity per heat.	
e)	The inspecting officer will check all the parameters as mentioned in IRS-T-31 of each heat and stamp signed and certify the test certificates of each heat passed and Inspection Certificates shall be issued by him.	
f)	Inspecting officer can issue multiple IC's depending upon the number of heats OR RDSO can Fix number of heats per IC	
g)	g) The raw material manufacture then will sell the certified material to ERC manufacturers against PO as per their demand along with the copy certified true copy of test certificate and Certified true copy of IC through their pan India respective stock yards.	





h)	The Inspecting officer will cross check the material at ERC manufacturer premises when ERC manufacturer offers the raw material for inspection.	
	<b>Suggestion regarding In the Consignee end inspection of ERC</b>	
a)	Testing of any lot shall be done only after any specific nature of complain from the field in performance of ERC.	The suggestion has been examined and it has been suitably incorporated in the corrigendum no. 2 of T-31
b)	The complain 1 <sup>st</sup> should be brought to the knowledge of the supplier and only after joint inspection if the nature of complain is found true then only at the consignee the material can be send for further testing to RDSO with the approval of not below the CTE rank officer of the concern zonal railway.	As per the specific nature of complain from the field regarding performance of ERC, 1 <sup>st</sup> set of samples shall be tested in presence of firm's officials with the approval of concerned Zonal Railway officer not below the level of JAG officer.
c)	The 3 sets of samples should be sealed during joint inspection in the presence of the representative of the supplier.	The suggestion has been examined and it has been suitably incorporated in the corrigendum no. 2 of T-31

