### **DISCLAIMER**

The details like name of project, name of fabricator, etc. are indicative only. These should never be referred for any WPSS related matters. Only the technical details should be referred and followed for the WPSS purpose.

# Model WPSS for Railway OPEN WEB GIRDER (25t Loading)

Railway Open Web Girder (25t loading)
30.5m clear span
MODEL WPSS No- RDSO/ Infra-II/ B&S/ RG/
OWG./ WPSS / 30.5 series (22 nos)

Appendix-V (Ref.Cl.26 of BI-2001) WELDING PROCEDURE SPECIFICATION SHEET PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE, PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Welding Procedure specification No. Toopran Mandal, Medak Dist. : GSC/22/SRC-30.5M/WPSS/SAW/01 Drawing No. RDSO/B-17165/R, Section A-A & RDSO/B-17161(Section LO-L1-L2) Weld Joint description 2 Fillet 6mm (Bottom Chord) 3 **Base Metal** IS:2062:2011, Gr E250B0 (20MM X 16MM) 4 **Welding Process** : SAW 5 Welding Position 1F 6 Welding Consumable 6.1 Electrode/Wire Class W1 of IRS M.39/2001. Type Copper coated Mild Steel Wire. **Drying Method** N.A. 6.2 Flux Class : F1 of IRS M.39-2001 Type : Agglomerated 250 C for one hour before uses OR Recommendation as per Drying Method manufacturer. 6.3 **Shielding Gas** : N.A Fusion faces and adjacent surfaces are cleaned and made free from cracks, notches, mill scale, grease, paint, rust etc., which may affect 7 Base metal preparation weld quality. Joint design details 7.1 (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence 2 SIDE PLs. 300x20 4 FL, PLs. 90x16 etc.,) Engg. Worksho S.C. Rly, Lallagu : As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3 & WBC - 2001 Joint preparation 7.2 Welding Current 8 DC Type Polarity Reverse\_ Welder Qualification As per IS:7310 (Part-I) - 817

जे. श्रीनिवास राव/J. Srinivas Rao

Welding parameters and wich No

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL -SHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2X45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters :
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Weld Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/Min)	Electrical Stick out (mm)	Gas Flow (I/min)	
0 1 D	4	450-550	28-32	0.45.0.55	25 - 30	N.A.	

10.2	Welding Sequence and technique	:	1,2,3,4
			6
11	Provision of run-on/run-off tabs	:	Yes
12	Cleaning of weld bead before laying of next weld bead	:	N.A.
13	Root preparation before welding other side of groove weld	:	N.A.  100°C to 150°C
14	Preheating and inter pass temperature	:	100°C to 150°C
15	Peening	:	N.A. Dy. Chief Englisher Engg. Workshop
16	Post weld treatment	:	N.A. S.C. Riy, Lallage
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test & Macro Etching.
19	Any other relevant detail	:	None

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

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	N) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
eldin	g Procedure specification No.	+.	GSC/22/SRC-30.5M/WPSS/SAW/02
1	Drawing No.	H	RDSO/B-17166/R, Section A-A
2	Weld Joint description	<del>l :</del>	Fillet 6mm (Top Chord)
3	Base Metal	H:	IS:2062:2011, Gr E250B0 (10MMX10MM)
4		₽÷	SAW
5	Welding Process	1:	1F
_	Welding Position	H:	IF .
6	Welding Consumable	$\vdash$	
6.1	Electrode/Wire	1	
	Class		W1 of IRS M.39/2001.
<b>)</b>	Туре		Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2	Flux		The Beneficial
	Class		F1 of IRS M.39-2001 Agglomerated
)	Туре	:	F1 of IRS M.39-2001 Agglomerated 250 C for one hour before uses OR Recommendation as per manufacturer.
	Drying Method		250 C for one hour before uses OR Recommendation as per
)	Di ying wethou		manufacturer.
6.3	Shielding Gas	:	N.A Fusion faces and adjacent surfaces are cleaned and made free from
			cracks, notches, mill scale, grease, paint, rust etc., which may affect
7	Base metal preparation	:	A CONTROL OF THE CONT
			weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld		4 MAR ST. FAATTA
	groove details, weld passes & their sequence		1 TOP PL. 500X10
V.	etc.,)		
,			
,			
			0 GIDE DI - 200VIO
			2 SIDE . PLs. 300X10
			6 72 FL. PLs. 90X10
		- 1	
	1		
			Tocase
			Dy. Chief Engineer
			Endd. Workshop
			S.C. Rly, Lallaguda
		-	
7.2	Joint preparation	: /	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
_	Welding Current	+	
8	Туре	-	oc \
	Polarity		deverse 3.55
	welder Qualification	RIV	Siper 15: 73:10/(Part-I) ni 8:17 Rao

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL - VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding	parameters:						
Weld Pass No.	Electrodes wire dia.	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/Min)	Electrical Stick out (mm)	Gas Flow (I/min)	
	(mm) ( ,, -,						
			20.22	0.45.0.55	25 - 30	N.A.	

28-32

1, 2, 3, 4

450-550

Welding Sequence and technique

0

3

9

1

10.2

0.45.0.55

Provision of run-on/run-off tabs Yes 11 Cleaning of weld bead before laying of N.A. 12 next weld bead 1910112000 (111 Root preparation before welding other N.A. Stateh Ortiosi (M. 13 side of groove weld . प्रत्याव्यं के हेल सन्याव्यं व्यव्य**व** Preheating and inter pass temperature 100°C to 150°C 14 N.A. Peening 15 N.A. Post weld treatment 16 By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-Rectification of weld defect 17 2020. Inspection of weld Visual, D.P. Test & Macro Etching. 18 Any other relevant detail None 19 Engg. Workshop

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

S CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m

(CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF

AN (1X30.5m + 2 X 45.7m)	TITED GINDEN.	Т	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopra
ame and address of Fabri		:	Mandal, Medak Dist.
elding Procedure specific	ation No.		GSC/22/SRC-30.5M/WPSS/SAW/03
1 Drawing No.		·	RDSO/B-17167/R, Section B-B
2 Weld Joint descrip	ntion	:	Fillet 6 mm (End Raker)
3 Base Metal	, tion		IS:2062:2011, Gr E250B0 (20MM X 10 MM), (20MM X 16MM)
4 Welding Process		:	SAW
5 Welding Position		:	1F
6 Welding Consuma	ble	Ť	
6.1 Electrode/Wire		$\vdash$	
	Class	:	W1 of IRS M.39/2001.
	Туре	1	Copper coated Mild Steel Wire.
	Drying Method		N.A.
6.2 Flux			
	Class	:	F1 of IRS M.39-2001
	Туре	1	Agglomerated 250 C for one hour before uses OR Recommendation as per manufacturer.
	Drying Method	:	250 C for one hour before uses OK Recommendation as per management
6.3 Shielding Gas		:	NA .
0.5 Silielding das			
7 Base metal prepa	ration	;	Fusion faces and adjacent surfaces are cleaned and made free from crack
, Date metal proper			notches, mill scale, grease, paint, rust etc., which may affect weld quality.
7.1 Joint design detail	s	:	
(Sketch showing a	rrangements of parts,		
weld groove detail			1 TOP PL, 500X16
their sequence et	c.,)		40420
			The state of the s
			Calut admini of an analog in
)			1 30 27310
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			2 SIDE . PLs. 300X20
			6 72 FL. PLs. 90X10
			/ X
			Dy. Chief Englide
			Engg. Workshop
1			S,C. Rly, Lallaguda
7.2 Joint preparation		:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
8 Welding Current	-		DC = S=
(TE	Туре	:	DC 3.S
1/41:01	CIT.	-1/15	REVERSE COLUMN TO THE PROPERTY OF THE PROPERTY

S.C. Rly, Lallaguda

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING FYG. TO A SUBMINION OF GUNTUR DIVISION) OF (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. 10.1 Welding parameters : Weld Pass No. Electrodes wire Electrical Stick out Travel Speed Gas Flow (I/min) Current (Amps) Arc Voltage (Volt) dia. (mm) (mm) (mm/Min) 1 N.A. 4 25 - 30 0.45.0.55 450-550 28-32 10.2 Welding Sequence and technique : 1, 2, 3, 4 Yes Provision of run-on/run-off tabs : 11 Cleaning of weld bead before laying of next N.A. 12 weld bead Root preparation before welding other side of N.A. 13 groove weld कारी (बाबु 100°C to 150°C Preheating and inter pass temperature 14 भारतासम् चलवन N.A. Peening 15 N.A. Post weld treatment 16 By re-welding after complete removal of defective weld & rectifying the weld as per Rectification of weld defect CI.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020. 17 Visual, D.P. Test & Macro Etching. Dy. Chief Enginee. Inspection of weld 18 None Any other relevant detail CO. Engg. Workshop

WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER
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"25T LOADING-2008" 30.50M TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE, PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30,5m + 2 X 45.7m) OPEN WEB GIRDER. M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Name and address of Fabricator Toopran Mandal, Medak Dist. Velding Procedure specification No. GSC/22/SRC-30.5M/WPSS/SAW/04 : RDSO/B-11768, Section & RDSO/B-17161(Section of Verticals) 1 Drawing No. 2 Weld Joint description Fillet 6mm (Verticals) : IS:2062:2011, Gr E250B0 (10MM X 12MM) 3 **Base Metal** 4 **Welding Process** SAW : 5 **Welding Position** 2F : 6 **Welding Consumable** 6.1 Electrode/Wire Class W1 of IRS M.39/2001. Copper coated Mild Steel Wire. Type **Drying Method** 6.2 Flux Agglomerated
250 C for one hour before uses OR Recommendation as per manufacturer. Class Type Drying Method NA : 6.3 **Shielding Gas** Material to be cut straight & square by controlled gas cutting. Fusion faces Base metal preparation 7.0 and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. : Joint design details 7.1 (Sketch showing arrangements of parts, weld groove details, weld passes & their INNER FL. PL. 220x10 sequence etc.,) WEB PL. 460x12 Dy. Chief Enginee Engg. Workshop S.C. Rly, Lallaguda **OUTER FL. PL. 220x10** As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3 & WBC - 2001 Joint preparation 7.2 Welding Current 8 DC Type : Polarity : Reverse

As per IS 7310 (Part-I) - 817

Welder Gualification

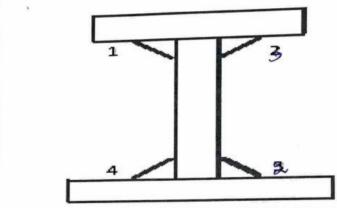
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Walding parameters and technique FA

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE O. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding parameters

	wire dia.		Current (Amps)		ge (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)
	(mm)	AC/	DC	AC /	DC		,	
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
7 10.2 Weldi	ng Sequence ar	nd technique	:	1&2, 3&4				



711	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	N.A. 120°C to 250°C
15	Peening	;	100°C to 250°C
, 16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.  Dy. Chief Eliginee
19	Any other relevant detail	:	None. Engg. Workshop' S.C. Rly, Lallaguda

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

AKEN AS CHARACTER PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

AKEN AS CHARACTER PROPOSED BRIDGE NO. 4 (ROR) A AKEN AS CH: 00.00m) FOR (5x800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:

by. Chief Englisher Engg. Workshop	ame a	N) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GII and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No 12, No.
Drawing No. : RDSO/B-17169/R & RDSO/B-17161 (Section DI-L2)  Welding Process : Fillet femm (Diagonals)  Welding Process : SAW  Welding Position : IF  Welding Consumable  6.1 Electrode/Wire	/eldin	g Procedure specification N		Toopran Mandal, Medak Dist.
2 Weld Joint description 3 Base Metal 4 Welding Process 5 Welding Position 5 Welding Position 6.1 Electrode/Wire Class Type Drying Method 7.1 Joint design details Cseed and adjacent surfaces are deaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details Cseed and passes & their sequence etc.,)  7.2 Joint preparation  7.3 Joint preparation  7.4 Welding Current  1 Filts Filts M.39/2001. 1 Filts M.39/2001. 2 Filts M.39/2001. 3 Welding Gas 5 Filts M.39/2001. 5 Filts M.39/200	1	Drawing N	:	GSC/22/SRC-30.5M/WP33/SAW/03
3 Base Metal :		Wold I i i i	:	RDSO/B-17169/R & RDSO/B-17161 (Section of 22)
4 Welding Process 5 Welding Position 6 Welding Consumable 6.1 Electrode/Wire  Class Type Drying Method  Class Type Drying		Weld Joint description	:	Fillet 6mm (Diagonals)
5 Welding Position : 1F 6 Welding Consumable 6.1 Electrode/Wire Class Type Drying Method : N.A. 6.2 Flux Class Type Drying Method : N.A. 6.3 Shielding Gas 7.0 Base metal preparation Base metal preparation Class Type Drying Method : NA  7.1 Joint design details Class Type Drying Method : NA  Class Type Drying Method : NA  7.1 Joint design details Class Type Drying Method : NA  7.2 Joint preparation  Class Type Drying Method : NA  As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current  Class Type Drying Method : NA  As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current			:	
6.1 Electrode/Wire  Class Type Drying Method  Class: Type Drying Method:  NA Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  Part stretch shown.  2 SIDB. PLa 300X12 4 FL. PLA. 90X16  Dy. Chief Engling Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation  S Welding Current	_	Welding Process	:	
Class Type Drying Method  Class Type Drying		Welding Position	:	1F
Class Type Drying Method : Copper coated Mild Steel Wire. N.A.  Class Type: Drying Method : Part Stretch shown.  Class Type: Drying Method : NA.  Class Type: Drying Method : Agglomerated 250 C for one hour before uses OR Recommendation as per manufacturer.  Amaterial to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDB . PLa 300X12  4 FL PLA, 90X16  7.2 Joint preparation : As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current		Welding Consumable		
Class : Flux  Class : Flor IRS M.39-2001 Type : Drying Method : 250 C for one hour before uses OR Recommendation as per manufacturer.  6.3 Shielding Gas 7.0 Base metal preparation  Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDB . PLa 300X12 4 FL. PLA 90X16  7.2 Joint preparation : As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current	6.1	Electrode/Wire		
Copper coated Mild Steel Wire. N.A.  Class : Flor IRS M.39-2001 Type: Drying Method : 250 C for one hour before uses OR Recommendation as per manufacturer.  6.3 Shielding Gas : NA  7.0 Base metal preparation : Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details : Part stretch shown.  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  40 Dy. Chief English Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation : As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current		Class		W1 of IRS M.39/2001.
Drying Method : N.A.  Class Type Drying Method : Plux Class Type Drying Method : 250 C for one hour before uses OR Recommendation as per manufacturer.  Agglomerated 250 C for one hour before uses OR Recommendation as per manufacturer.  NA Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  Dioint design details : Part stretch shown.  Suppose Side of the stretch shown.  As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current : As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3		Type	:	Copper coated Mild Steel Wire.
Class Type Drying Method Compared Compa	4	Drying Method		
Class : Type : Agglomerated : 250 C for one hour before uses OR Recommendation as per manufacturer.  6.3 Shielding Gas : NA	6.2	Flore	_	12/04/2018 (1916)
Drying Method  5.0 C for one hour before uses OR Recommendation as per manufacturer.  5.0 Shielding Gas  7.0 Base metal preparation  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  7.1 Joint design details  7.2 SIDB . PLA 300X12  FL. PLA 90X16  7.3 Joint preparation  7.4 FL. PLA 90X16  7.5 As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3  7.6 Welding Current	0.2			E1 of IRS M 39-2001
Drying Method  5.3 Shielding Gas  7.0 Base metal preparation  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  7.1 Joint design details  7.2 Joint preparation  7.3 Joint preparation  8 Welding Current  2 Side of or one hour before uses OR Recommendation as per manufacturer.  2 Side of or one hour before uses OR Recommendation as per manufacturer.  2 Side of or one hour before uses OR Recommendation as per manufacturer.  3 Shielding Gas  4 Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7 Side of or one hour before uses OR Recommendation as per manufacturer.  4 Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7 Side of or one hour before uses OR Recommendation as per manufacturer.  5 Of or one hour before uses OR Recommendation as per manufacturer.  6 Joint design details  5 Of or one hour before uses OR Recommendation as per manufacturer.	9			Agglomerated
6.3 Shielding Gas 7.0 Base metal preparation  Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDB . PLa 300X12  4 FL. PLa 90X16  7.2 Joint preparation  : As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current	à			250 C for one hour before uses OR Recommendation as per manufacturer.
6.3 Shielding Gas 7.0 Base metal preparation  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  7.1 Joint preparation  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  7.2 Joint preparation  2 SIDB . Pla 300X12  4 Fl. Pla 90X16  As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current		Drying Method	٠	230 C for one note before association
Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDE . Pl.a. 300X12  4 FL. Pl.a. 90X16  Dy. Chief English Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation  : As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3				
in and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDB. Pla 300X12  4 FL. Pla 90X16  7.2 Joint preparation  i. As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3  Welding Current	6.3	Shielding Gas	:	NA
Scale, Grease Paint, Rust etc., which may affected Weld.  7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDB. PLa 300X12  4 FL. Pla 90X16  Dy. Chief Engine Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation  1 As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3	7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. I dolor tuces
7.1 Joint design details  (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDB . PLa 300X12  4 FL . PLa 90X16  Dy. Chief Engine Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation  3 Welding Current  Welding Current	0		:	and adjacent surfaces are cleaned and made free from crack, Notches, Will
(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDE .PLA 300X12  4 FL. PLA 90X16  Dy. Chief Engine Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation  3 Welding Current  Engg. Workshop S.C. Rly, Lallagud		×6		Scale, Grease Paint, Rust etc., which may affected weld.
(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)  2 SIDE . PLA 300X12  4 FL PLA 90X16  Dy. Chief Engline Engg. Workshop S.C. Rly, Lallagud  7.2 Joint preparation  3 Welding Current  Engg. Workshop S.C. Rly, Lallagud	7.1	Joint design details	:	Part stretch shown.
8 Welding Current		weld groove details, weld passes & their		Dy. Chief English
8 Welding Current	7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3

Polarity

Welder Qualification Co

9

Reverse

As per IS 7310 (Part-I) - 817

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT LAMB 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE.

ROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

parameters :

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	4	450-550	28-32	0.45.0.55	25 - 28	N.A.

The same	1	4	450-550		28-32	0.45.0.55	25 - 20	742.0
<b>P</b>								
10.	2 Wel	ding Sequence and te	chnique	:	- 1			
07							L	7
3								
				- 1		61		- 11
						$\rightarrow$	<	- 11
I Wall								- 11
7								11
								\ II
					IK-			-41
<b>a</b>					U			
11	Provision	on of run-on/run-off t	abs	: N.A.				
.00								

		U
Provision of run-on/run-off tabs	:	N.A.
next weld bead	;	Yes
Root preparation before welding other side of groove weld	:	N.A.
Preheating and inter pass temperature	:	100°C to 250°C  N.A.  Assistance of the contract of the contra
Peening	:	N.A.
Post weld treatment	:	N.A.
Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
Inspection of weld	:	Visual, D.P. Test.  Dy. Chief Enginee.
Any other relevant detail	:	None. Engg. Workshop' S.C. Rly, Lallaguda
	Root preparation before welding other side of groove weld Preheating and inter pass temperature Peening Post weld treatment  Rectification of weld defect  Inspection of weld	Cleaning of weld bead before laying of next weld bead  Root preparation before welding other side of groove weld  Preheating and inter pass temperature  Peening  Post weld treatment  Rectification of weld defect  Inspection of weld  Any other relevant detail  :

WELDING PROCEDURE SPECIFICATION SHEET PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (Taken and Taken and Take AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING FYG. TRACK). (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 × 5 m + SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Name and address of Fabricator Toopran Mandal, Medak Dist. : GSC/22/SRC-30.5M/WPSS/SAW/06 Welding Procedure specification No. : RDSO/B-17172 & RDSO/B-17161(Cross Girder) Drawing No. Fillet 10mm (Cross Girder) 2 Weld Joint description : : IS:2062:2011, Gr E250B0 (10MM X 32MM) 3 Base Metal 4 **Welding Process** SAW : 5 : 2F **Welding Position** 6 **Welding Consumable** 6.1 Electrode/Wire W1 of IRS M.39/2001. Class Copper coated Mild Steel Wire. Type **Drying Method** वस्यक वसुनवान आवनारो (बार् : N.A. Research Officer (M 6.2 Flux F1 of IRS M.39-2001 Class : 250 C for one hour before uses OR Recommendation as per manufacturer. Type Drying Method G S E S E S NA : **Shielding Gas** Material to be cut straight & square by controlled gas cutting. Fusion faces 6.3 and adjacent surfaces are cleaned and made free from Crack, Notches, Mill 7.0 Base metal preparation Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. 7.1 Joint design details TOP FL. (Sketch showing arrangements of parts, PL. 410x32 weld groove details, weld passes & their sequence etc.,) WEB PL. 836x10 Dy. Chief Enginee. Engg. Workshop 10 S.C. Rly, Lallaguda BOTT: FL. PL. 410x32 : As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3& W&C - 2001 Joint preparation 7.2 Welding Current 8 : DC Type Polarity : Reverse

FRA

Apper 37310 (Part-I) + 817 J. Srinivas Rab MW, YTPS, Veerlap

Welder Qualification LCO

10

Welding parameters and rechnique

S.C. Rly, Lallaguda

OJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM
137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE
0. 4 (ROR) AT CH: 1138.00m (CROSSING EYG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-

10.	1 Welding	parameters :			1: 133/8-9, BETW 2 X 45.7m) OPEN				
Weld	Weld Pass No wire dia. Current (		Amps)	Arc Volta	ge (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)	
_		(mm)	AC /	DC	AC /	DC			
	1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
10.:	2 Weldir	ng Sequence and	l technique	:	1&2, 3&4				
) )		*	T		N.A.	4		3.	]
111		of run-on/run-of		:	1988				
12	nevt weld	f weld bead befo bead		:	Yes			37011315	. ervill
13	Root prepa	aration before w	elding other	:	N.A.			1.6.00	100
14		and inter pass t	emperature	:	100°C to 250°C		1197	A CONSTRUCTION OFFICE	4449
15	Peening			:	N.A.		Againin	Logo for States	
16	Post weld t	reatment		:	N.A.		29.4		
		n of weld defect		:	By re-welding a weld as per Cl.3 2020.	fter comple 2.2 of IS 95	te removal of de 95-96, using A2	efective weld & reclass electrode a	ectifying the sectifying the section of the section
	Inspection	of weld		·	Visual, D.P. Test	•		Dy. Chief E	nylthe
18	Inspection								

None.

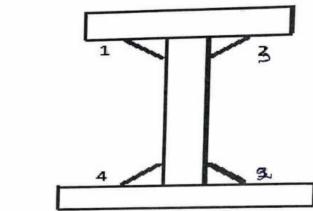
Any other relevant detail

			дррепил	
	WEIDING	pp	OCEDURE SPECIFICATION SHEET	
				ION AT KM 137/970
OJECT				RIDGE NO. 4 (ROR) AT CH
AKEN A	AS CHI. OO OO TOO (SYCOOD WITH A PRINTING	MAAI	POWER PLANT AT VEERLA PALEM VILLAGE, PROPUSED BY	SECTION OF GUNTUR
138.00r	TI (CROSSING EVE TRACK AT KAA 132/9 0 BET!	VEE	POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BY N KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD S	Control
	I) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB G			
	A STATE OF THE STA	I	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuch	avaram village)
ame a	nd address of Fabricator	:	Toopran Mandal, Medak Dist.	
		-	T	
	Procedure specification No.	:	RDSO/B-17173 (Section B-B) & RDSO/B-17161(Strin	ger)
1	Drawing No.	:	RDSO/B-1/1/3 (Section 5 57	
2	Weld Joint description	:	Fillet 10mm (Stringer) IS:2062:2011, Gr E250B0 (10MM X 16MM)	
3	Base Metal	:		
4	Welding Process	:	SAW	
5	Welding Position	:	2F	
6	Welding Consumable			
6.1	Electrode/Wire			
	Class	:	W1 of IRS M.39/2001.	_
	Туре	:	Copper coated Mild Steel Wire.	
	Drying Method	:	N.A.	13 C 17 100 ( 12)
6.2	Flux			at Butal
0.2	Class	:	F1 of IRS M.39-2001	argain atam
	Туре			
	Drying Method		Agglomerated 250 C for one hour before use OR Recommendation	as per manadetaren
	5.7		LP CONTRACTOR OF THE CONTRACTO	C1 - 0
6.3	Shiolding Gas	:	NA	
6.3	Shielding Gas Base metal preparation	:	the beaut straight & square by controlled ga	s cutting. Fusion races
7.0	Dase Illetal preparation		and adjacent surfaces are cleaned and made free fro	m Crack, Notches, Will
			Scale, Grease Paint, Rust etc., which may affected W	eid.
	to the deside	,	Part stretch shown.	
7.1	Joint design details	Ė		OP FL.
	(Sketch showing arrangements of parts, weld groove details, weld passes & their			L. 450x16
			<b>T</b>	
	sequence etc.,).			
			WER.	PL. 718x10
			, Lab	
				c
			750	Dy. Chief English
				Engg. Workshop
			10	S.C. Rly, Lallaguda
				OTT: FL.
			P	L. 450x16
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3	
8	Welding Current			
	Туре	_	DC	
	Polarity	ï	Reverse	
	Welder Qualification	:	As per IS 7310 (Part-I) – 817	
9	WCide: C	$\overline{}$		SIA LILLE

\*\*OJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE 0. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters :
		Parallicters.

Weld Pass No	Electrodes wire dia.	Current	(Amps)	Arc Volta	ge (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)
A7	(mm)	AC/	DC	AC/	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
10.2 Weldi	ng Sequence an	d technique	:	1&2, 3&4				



0				
11	Provision of run-on/run-off tabs	:	N.A.	
12	Cleaning of weld bead before laying of next weld bead	:	Yes	134-112022 (218
13	Root preparation before welding other side of groove weld	:	N.A.	William Stand (M
14		:	100°C to 250°C	Canal Residence
15	Peening	:	N.A.	4.00
16	Post weld treatment	:	N.A.	
) 17	Rectification of weld defect	:		emoval of defective weld & rectifying the 06, using A2 class electrode as per IRS M28-
18	Inspection of weld	:	Visual, D.P. Test.	Dy. Chief Englader
19	Any other relevant detailEEL Con-	:	None.	Engg. Workshop' S.C. Rly, Lallaguda

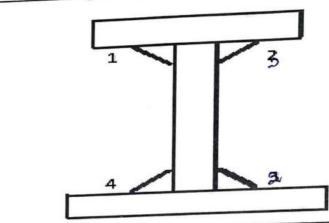
	WELDING	i PF	ROCEDURE SPECIFICATION SHEET
1138.00	I AS CH: 00.00m) FOR (5X800MW) YADADRI THER	M C	1008" 30.50M SPAN OPEN WEB GIRDER  H:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970  L POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH  N KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR
DIVISIO	ON) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB G	IRD	FR .
Name	and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Weldir	ng Procedure specification No.	١.	GSC/22/SRC-30.5M/WPSS/SAW/08
1	Drawing No.	Η.	RDSO/B-17167/R & RDSO/B-17161(Portal Girder U <sub>1</sub> -U <sup>1</sup> <sub>1</sub> )
2	Weld Joint description	H:	Fillet 6mm (Portal Girder)
3	Base Metal	+	IS:2062:2011, Gr E250B0 (10MM X 10MM)
4	Welding Process	H	SAW
5	Welding Process  Welding Position	+	2F
6	Welding Consumable	H.	
6.1		-	
0.1	Class		W1 of IRS M.39/2001.
	Type	:	W1 of IRS M.39/2001. Copper coated Mild Steel Wire.
	Drying Method	:	
	Drying Wethou	:	N.A.
6.2	Flux	L	35 77
	Class	:	F1 of IRS M.39-2001 Agglomerated
	Туре		Agglomerated OR Recommendation as per manufacturer
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer
6.3	Shielding Gas	:	NA
7.0		:	Material to be cut straight & square by controlled gas cutting. Fusion face:
7.0	base metal preparation		and adjacent surfaces are cleaned and made free from Crack, Notches, Mi
			Scale, Grease Paint, Rust etc., which may affected Weld.
			Part stretch shown.
7.1	Joint design details	·	
	(Sketch showing arrangements of parts,		TOP FL. PL. 230x10
	weld groove details, weld passes & their		
	sequence etc.,).		Trus Sans 1
			Dy. Chief Eng
			Engg. Worksh
			S.C. Rly, Lallag
			WEB PL. 350x10
			WED IL. JOAN
			DOTTE TT DE 220-10
			BOTT: FL. PL. 230x10
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
8	Type	:	DC
of the	Polarity	:	Reverse
_	Welder Qualification	:	As per IS 7310 (Part-I) – 817
9			25
10	Welding parameters and technique	:	3.50

137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE

3. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BNNDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters :
		parameters.

Weld Pass No	Electrodes wire dia.	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)
	(mm)	AC /	DC	AC /	DC			N/A
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
10.2 Weldi	ng Sequence ar	nd technique	:	1&2, 3&4				



Provision of run-on/run-off tabs	:	N.A.
Cleaning of weld bead before laying of	:	Yes Jennon Comment
Root preparation before welding other	ı	N.A.
	:	100°C to 250°C
Peening	:	N.A. Dy. Chief Englisher  Engg. Workshop
Post weld treatment	:	N.A. S.C. Rly, Lallaguda
Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
Inspection of weld	:	Visual, D.P. Test.
Any other relevant detail	:	None.
	Cleaning of weld bead before laying of next weld bead Root preparation before welding other side of groove weld Preheating and inter pass temperature Peening Post weld treatment Rectification of weld defect	Cleaning of weld bead before laying of next weld bead Root preparation before welding other side of groove weld Preheating and inter pass temperature  Peening  Post weld treatment  Rectification of weld defect  Inspection of weld  :

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

(TAKEN AS CHARGE OF A SILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM- 133/8-9 RETWEEN KONDRAPOL - VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR

arne and a	SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GI address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Velding Pro	ocedure specification No.		GSC/22/SRC-30.5M/WPSS/SAW/09
1 Dra	awing No.	<u> </u>	RDSO/B-17174 & RDSO/B-17161(Sway Girder (U <sub>2</sub> -U <sup>1</sup> <sub>2</sub> , U <sub>3</sub> -U <sup>1</sup> <sub>3</sub> ))
	eld Joint description		Fillet 6mm (Sway Girder)
3 Ba	se Metal	÷	IS:2062:2011, Gr E250B0 (10MM X 10MM)
4 W	elding Process	:	SAW
	elding Position	:	2F
	elding Consumable		
6.1 Ele	ectrode/Wire		
	Class	١,	W1 of IRS M.39/2001.
	Туре	;	Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2 Flu	IIV.	Ė	Tank (N
0.2	Class		F1 of IRS M.39-2001 Agglomerated
	Type		Agglomerated
	Drying Method		250 C for one hour before uses OR Recommendation as per manufacturer
C 2 Ch			NA .
	nielding Gas	+	Material to be cut straight & square by controlled gas cutting. Fusion face
7.0 Ba	ase metal preparation		and adjacent surfaces are cleaned and made free from Crack, Notches, Mi
			Scale, Grease Paint, Rust etc., which may affected Weld.
		-	Part stretch shown.
	int design details	-	
	ketch showing arrangements of parts,		<b>├──TOP FL. PL. 160x10</b>
	eld groove details, weld passes & their		/
se	quence etc.,).		
			T
			<b>── WEB PL. 290x10</b>
			WED IL. 290A10
			F 6 N POWER WY 160 10
7.2 Jo	int preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
A STATE OF THE STA	elding Current		Dy. Chief Eng
- 1	Туре	:	DC Engg. Works S.C. Rly, Lalla
	Polarity	:	Reverse 5.0. Nly, Lana
9 W	elder Qualification	:	As per IS 7310 (Part-I) – 817
10 W	relding parameters and technique	:	

OJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE 0.4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

NDKD S	SECTION O	F GUNTUR DIVI	SION) OF SPAN	(1X30.5m +	- 2 X 45.7m) OP	EN WEB GIRDE	к.		
7	10.1 Welding parameters :  Electrodes Weld Pass No wire dia.  Current		(Amps)	Arc Vol	tage (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)	
0	(mm)	AC	DC	AC/	DC		20-25	N.A.	
	1	4	A50-500	450-550	25-28	25-30	0.45.0.55	20-23	
0 10.2	Weldir	ng Sequence an	d technique	:	1&2, 3&4	1		2	1
711	Provision	of run-on/run-o	off tabs	i	N.A.				•
112	+ wold	of weld bead bet		:	Yes			0	)
13	Root prep	aration before v	welding other	:	N.A.			13/01/202	
14		g and inter pass	temperature	:	100°C to 250°C		1. 1.	A CHEST OF THE STATE OF THE STA	HOUL CHES
15	Peening			:	N.A.		1-1	THE STATE OF	
16	Post weld	treatment		:	N.A.				
17		on of weld defec	et	·	By re-welding a weld as per Cl.3 2020.	after complete 32.2 of IS 9595	removal of defe -96, using A2 cla	ctive weld & rect	er IRS M28-
18	Inspection	of weld		;	Visual, D.P. Tes	t.		Dy. Chief Er Engg. Work	shop
19	Any other	relevant detail	EELCO	:	None.			S.C. Rly, Lall	aguda

WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Name and address of Fabricator Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-30.5M/WPSS/SAW/10 RDSO/B-17176(Section) & RDSO /B-17161 (Top Laterla Bracing) Drawing No. 2 Weld Joint description Fillet 6mm (Top Lateral Bracings) 3 IS:2062:2011, Gr E250B0 (10MM X 10MM) Base Metal 4 **Welding Process** SAW : 5 **Welding Position** 2F : 6 Welding Consumable 6.1 Electrode/Wire Class W1 of IRS M.39/2001. Type Copper coated Mild Steel Wire. **Drying Method** N.A. Flux 6.2 F1 of IRS M.39-2001 Class Agglomerated Type 250 C for one hour before uses OR Recommendation as per manufacturer. Drying Method NA : Shielding Gas 6.3 Material to be cut straight & square by controlled gas cutting. Fusion faces Base metal preparation 7.0 and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. Joint design details 7.1 (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,). FL. PL. 200x10 **WEB PL. 90X10** As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current DC Type Riv. Lallaquda Polarity : Reverse

As per IS 7310 (Part-I) - 817

Welder Qualification

10

Welding parameters and technique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE.

PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL — VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters :
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Welding Sequence and technique

0

0

10.2

,	Welding Sequence No.	Electrodes wire dia.	Current	Arc Voltage (Volt)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
	Sequence No.	ence No. (mm) (Amps)			25 - 30	N.A.	
	1	4	450-550	28-32	0.45.0.55	25 30	

11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead		Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A. N.A. A STATE OF
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.  Dy. Chief Englished
19	Any other relevant detail	:	None. Engg. Workshop S.C. Rly, Lallaguda
	CLEER CO.		o.o. My, canagoda

VISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GI Ime and address of Fabricator elding Procedure specification No.		:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
1	Procedure specification No.	:	GSC/22/SRC-30.5M/WPSS/GMAW/11
1	Drawing No.	1:	RDSO/B-17172 (Detail at "H")
2	Weld Joint description	:	Fillet 6mm (Rib Plate)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
4	Welding Process	:	GMAW
5	Welding Position	:	2F
6	Welding Consumable		
6.1	Electrode/Wire Class Type Drying Method	: : :	1 of IRS M.46 1.2mm MIG Wire N.A.
6.2	Flux	_	0
	Class Type Drying Method	:	N.A  N.A  INCOME OF ICE (M.)
6.3	Shielding Gas	:	CO2
7.0	Base metal preparation	:	Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mi Scale, Grease Paint, Rust etc., which may affected Weld.
_	Joint design details	:	Part stretch shown.
- 1	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		RIB PL. 190x10x190  Dy. Chie Engg. Worksh S.G. Rly, Lallage
		$\forall$	
SA SA	Velding Current		As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
	Welding Current		

Welding parameters and temporque

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 7/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM ATTIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters	
		Parallictel3	۰

Welding V Sequence No.	Electrodes wire dia. (mm)  Current (Amps)		Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
<u>1</u>	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	

10	.2 Welding Sequence and technique		
			6
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A. Properties design
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.  Dy. Chief Enginee.
19	Any other relevant detail	:	None. Engg. Workshop: S.C. Rly, Lallaguda

### WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER "25T LOADING-2008" 30.50M SPAN TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 238.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Name and address of Fabricator Toopran Mandal, Medak Dist. GSC/22/SRC-30.5M/WPSS/GMAW/12 Welding Procedure specification No. : RDSO/B-17167/R (Details of Lacing) 1 Drawing No. Fillet 6mm (Lacing flat welding on End Raker) Weld Joint description IS:2062:2011, Gr E250B0 (10MM X 10MM) 3 Base Metal **GMAW** : 4 **Welding Process** 2F : 5 **Welding Position** Welding Consumable 6.1 Electrode/Wire 1 of IRS M.46 Class 1.2mm MIG Wire Type N.A. **Drying Method** 6.2 Flux Class द्यान कंधिकारी (बाष् N.A Type : Drying Method : CO2 Shielding Gas 6.3 Material to be cut straight & square by controlled gas cutting. Fusion faces Base metal preparation 7.0 and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. Joint design details 7.1 (Sketch showing arrangements of parts, 3.16 weld groove details, weld passes & their Flat 90x10mm sequence etc.,) Dy. Chief Ellyen Engg. Workshop S.C. Rly, Lallaguda 1 10 NG 22 37 65 10 434 : As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current 8 : DC Type Polarity Reverse \_\_\_\_\_\_\_\_ A Adalification As pen IS 7310 (Part-I) - 817. Welding parameters and technique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM
37/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED
BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM
ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

# 10.1 Welding parameters :

Welding Sequence No.	Electrodes wire dia. (mm)  Current (Amps)		Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	

10.2	Welding Sequence and technique	:	
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None. Dy. Chief Example Engg. Worksho

WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

(TAKEN AS CIL OS EN ANDERS SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Name and address of Fabricator Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-30.5M/WPSS/GMAW/13 Drawing No. RDSO/B-17166/R (Details of Lacing) Fillet 6mm (Lacing Angle welding on Top Chord) 2 Weld Joint description 3 IS:2062:2011, Gr E250B0 (10MM X 10MM) Base Metal 4 Welding Process **GMAW** : 5 Welding Position 2F : 6 Welding Consumable 6.1 Electrode/Wire Class 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. 6.2 Flux Research Officer (M Class : ज्ञात्वाच्य ब्रुवंदर्श Type N.A : Drying Method : CO2 6.3 Shielding Gas Material to be cut straight & square by controlled gas cutting. Fusion faces 7.0 Base metal preparation and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. 7.1 Joint design details (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,) Flat 90X10mm 480 LACING Ls. 75x75x8- ! : 585 Dy. Chiekkan Enga Workshop As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3& WBC - 2001. Rly, Lallague Joint preparation 7.2 Welding Current 8 Type DC : Polarity Reverse EEL CO Welder Qualification As per IS 7310 (Part-I) - 817 Welding parameters and technique (VeV

Appendix-V (Ref.Cl.26 of BI-2001)

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 37/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM TATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters ·
	vveiding	parameters .

Welding Sequence and technique

10.2

Welding Sequence No.	Electrodes wire dia. (Amps)		Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	
2					N.A.	15-20	16-18	
2	1.2	200-220	24-28	2.0-4.0	IV.A.	13 20		

11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	3,55	N.A.
0 17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None.  Dy. Chief Engline  Engg. Workshop

	WELDING	G P	ROCEDURE SPECIFICATION SHEET
PROJECT	T: PROPOSED RAILWAY SIDNA TO THE	G-2	ROCEDURE SPECIFICATION SHEET  008" 30.50M SPAN OPEN WEB GIRDER  CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970  NI POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:
AKEN	AS CH: 00.00m) FOR (EVECONAL) VAR A DELETION	M (	CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT NOT ELECTION OF GUNTUR  AL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:
17798.00	m (CROSSING EVO TO		TONIS ON BN-NDKD SECTION OF GUNTUR
VISIO	N) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB G	WE	EN KONDRAPOL - VISHNOPORAWI STATIONS ON SIX VI
Name	(2.7.50.5) TH 2 X 45.7m) OPEN WEB G	T	EK.
ivame a	and address of Fabricator	1	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village,
		$\perp$	Toopran Mandal, Medak Dist.
A d	g Procedure specification No.		GSC/22/SRC-30.5M/WPSS/GMAW/14
7 1	Drawing No.		RDSO/B-17165/R (section A-A)
2	Weld Joint description		Fillet 6mm (Diaphragm Plate welding on Bottom Chord)
( 3	Base Metal	1	IS:2062:2011, Gr E250B0 (8MM X 20MM)
4	Welding Process	1	GMAW
<b>O</b> 5	Welding Position	1	2F
6	Welding Consumable		
6.1	Electrode/Wire	T	
	Class	١.	1 of IRS M.46
	Туре	Ι:	1.2mm MIG Wire
	Drying Method	:	N.A.
TO .		Γ.	N.A.
6.2	Flux	L	13/01/2013
P	Class	100	N.A and
6	Туре		N.A and a state of Officer (M
0	Drying Method	:	N.A Ashlata Research Officer (M. Ashlata Research Officer (M.
		-	CO2
6.3	Shielding Gas		Material to be cut straight & square by controlled gas cutting. Fusion faces
7.0	Base metal preparation		and adjacent surfaces are cleaned and made free from Crack, Notches, Mill
P		:	Scale, Grease Paint, Rust etc., which may affected Weld.
6			Scale, Grease Failt, Rust etc., Which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
7.1	(Sketch showing arrangements of parts,		DIAPHRAGM )
TO .	weld groove details, weld passes & their		4 FL PLs 90x16
No.	sequence etc.,)		1 PL. 220x8x440 J
	Sequence etc.//		/ \
No.			
20			
-	ta.		
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103			I И , N I
10			
ļ			
, O			Teagener III
			Dy. Onef Engline
0			Engg Workshop
			S.C. Ry, Lallaguda
0			
9	2 (1) (1)		
7.72	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
7.2			1
8	Welding Current		DC Market
9	Type Polarity		Payarra
	Polarity Polarity		Reverse C

: As per IS 7310 (Part-I) - 817

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 37/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL — VISHNUPURAM ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding parameters :

Welding Sequence and technique

10.2

Welding Sequence No.	Electrodes wire dia.	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
1	(mm)			(m/min)	N.A.	15-20	16-18	
C 1	1.2	200-220	24-28	2.0-4.0			16-18	
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	10 10	

	Toolsing Sequence and technique		46
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C  N.A.
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
<b>18</b>	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None. Engg. Workshop S.C. Rly, Lallaguda

WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"ACTION OF THE PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

LAKEN AS CHAOS OF THE PROPOSED BRIDGE NO. 4 (ROR) A "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 38.00m (CROSSING TWO 38.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator Toopran Mandal, Medak Dist. GSC/22/SRC-30.5M/WPSS/GMAW/15 Welding Procedure specification No. RDSO/B-17166/R (Section A-A) Fillet 6mm (Diaphragm Plate welding on Top Chord) Drawing No. IS:2062:2011, Gr E250B0 (10MM X 10MM) 2 Weld Joint description 3 **Base Metal** : **GMAW** 4 **Welding Process** 2F : 5 Welding Position 6 Welding Consumable Electrode/Wire 6.1 Class 1 of IRS M.46 1.2mm MIG Wire Type **Drying Method** N.A. Flux 6.2 Class N.A Type Drying Method CO2 Material to be cut straight & square by controlled gas cutting. Fusion faces Shielding Gas 6.3 and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Base metal preparation 7.0 Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. Joint design details 7.1 (Sketch showing arrangements of parts, DIAPHRAGM 1 PL. 240x10x460 भारतीय हेटी संस्थालन स्थापर weld groove details, weld passes & their sequence etc.,) 64 -2 SIDE PL. 300x10 Dy. Chief End Engg. Workshop S.C. Rly, Lallagud As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current : DC Type Polarity Reverse Weder Busification TEEL CO As per IS 7310 (Part-I) - 817 ngineer

10 Welding parameters and technique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM

87/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED

BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL — VISHNUPURAM

ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10 1	Mald		
-0.1	vveiding	parameters	

Welding Sequence and technique

10.2

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Voltage (Volt) Speed (m/min)		Electrical Stick out (mm)	Gas Flow (I/min)	
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18	

- C- C- C- C			
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A. (all algors (all
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	( a )	N.A.
7 17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	: 1	None.  Dy. Chief Enginee.

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

(TAKEN AS CH. 20.20

(TA (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR

-	N) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB	GIRL	EN KONDRAPOL - VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GONTON
	and address of the	JIKE	
Weldin	g Procedure specification No.  Drawing No.		M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
reidin	s rocedure specification No	+	
		+	GSC/22/SRC-30.5M/WPSS/GMAW/16
2	Weld Joint description	+	RDSO/B-17165/R, Section A-A & B-B
3	Base Metal	-	Fillet 6mm (Batten Plate welding on Bottom Chord)
4	Welding Process	1	IS:2062:2011, Gr E250B0 (10mm X 16mm & 10mm X 12mm)
5	Welding Position	_ :	GMAW
6	Welding Consumable	:	2F
6.1	Electrode/Wire	_	
	II.		
	Class	:	1 of IRS M.46
	Туре	:	1.2mm MIG Wire
0	Drying Method	1:	N.A.
6.2	Flux	+	
7	Cl.	-	
	Clas		N. A.
0	Тур		N.A
	Drying Method	d :	
6.3	Shielding Gas	١.	CO2
7.0	Base metal preparation	Ť	
7			Material to be cut straight & square by controlled gas cutting. Fusion faces
2		;	and adjacent surfaces are cleaned and made free from Crack, Notches, Mill
7.1			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
)	(Sketch showing arrangements of parts,		
-	weld groove details, weld passes & their		1360190033
9	sequence etc.,)		M) The state of th
<del></del>			e de la company
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7			
0			І ИІ ІЛ
			Toolsoon
/			Dy. Chief Elitabee
)			Engg. Workshop
,			S.C. Rly, Lallaguda
1			BATTEN PL. 10 TH.
			400 BATTEN PL. 10 TH.
}			
		$\forall$	
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3& WBC - 2001
8	Welding Current	+	-552, G. 17.5& WBC - 2001
0	Туре	: 1	DC
-	Polarity	_	Reverse - S - Levices
	11/1/1/1/1/1/1/1/1/1/1/1/1/1/1/1/1/1/1/1	2011	
9	Wester Qualification	12	s per IS 7310 (Part-I) – 817
10 //	Velding parameters and technique No.V	14	Haller Via/J. Srinivas Rao Construcija Dicina Maga

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM BRIDGE NO. 4 (2000) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

# 10.1 Welding parameters:

Welding Sequence No.	(mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
0	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

10.2 Welding Sequence and technique : 11 Provision of run-on/run-off tabs N.A. Cleaning of weld bead before laying of 12 Yes next weld bead Root preparation before welding other 13 N.A. side of groove weld Preheating and inter pass temperature 100°C to 250°C 14 N.A. Peening 15 N.A. Post weld treatment 16 By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-Rectification of weld defect 17 2020. Inspection of weld Visual, D.P. Test. 18 Dv. Chief Engile 141 Engg. Workshop Any other relevant detail None. 19 S.C. Rly, Lallaguda

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

TAKEN AS CHI-00 CO. ALLIEN AS CHI-00 CO. ALLI TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 38.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5)

vame ar	OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GI and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
Velding	Procedure specification No.		Toopran Mandal, Medak Dist.
1	Drawing No.	:	GSC/22/SRC-30.5M/WPSS/GMAW/17
2	Weld Joint description	:	RDSO/B-17166/R, Section A-A
3	Base Metal	:	Fillet 6mm (Batten Plate welding on Top Chord)
4		:	IS:2062:2011, Gr E250B0 (10MM X 10MM )
5	Welding Process	:	GMAW
6	Welding Position	:	2F
	Welding Consumable		
6.1	Electrode/Wire		
	Class	١,	1 of IRS M.46
	Type		1.2mm MIG Wire
	Drying Method	i .	N.A.
6.2	Flux		
0.2			
	Class		N.A
	Туре		
9	Drying Method	:	अतामक जानुसाम विश्वता (A
6.3	Shielding Gas		CO2
7.0	Base metal preparation	•	Material to be cut straight & square by controlled gas cutting. Fusion face
r.0	base metal preparation		
0		:	and adjacent surfaces are cleaned and made free from Crack, Notches, M Scale, Grease Paint, Rust etc., which may affected Weld.
			Scale, Grease Failt, Rust etc., which may affected weld.
7.1	Joint design details	:	Part stretch shown.
	(Sketch showing arrangements of parts,		
0	weld groove details, weld passes & their		
_	sequence etc.,)		
<b>&gt;</b>			
			A OTDE DY ASS AS
			2 SIDE PL. 300x10
٥			
			A 777 77 44 44
و			
•			
	-		
			<u> </u>
			BATTEN PL. 10 THICK
			- C TIMEN
			Dy. Chief Ellyn
•			
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC ≥ 2001, Lallagud
	Welding Current		1
8	Welding current Type	:	DC Jan Jan
	Polarity	_	Reverse -s.S
	Wedger Qualification		As per IS 7310 (Part II) 1817 Rag
9	/NEW Mor () I BUILLY OUT !	211	THE PARTY OF THE P

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM BRIDGE NO. 4 (ROR) AT CH: 1138 OO. (XX800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL - VISHNUPURAM ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

# 10.1 Welding parameters:

Welding	Electrodes						
Sequence No.	wire dia. (mm) 1.2	(/ III ps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
1	-12	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

10.2 Welding S		24-20	2.0-4.0	N.A.	15-20	16-
10.2 Welding Sequence and technique	] :					
g:						
9						
				N. S. C. S.	N	
					7 [	^
		\				DN
					_	4
						V
Provision of run-on/run-off tabs	:	N.A.				
Cleaning of weld bead before laying of next weld bead	1:	Yes			0	
Root preparation before welding other						
side of groove weld	:	N.A.			CHITTE HISTORY	Officer
Preheating and inter pass temperature	:	100°C to 250°C			ाता प्रतिकार (Ant Research	न्द्राध्य ह
15 Peening	:	N.A.			To Though	
16 Post weld treatment	:	N.A.				
		By re-welding a	fter complete rea	moval of defective		
Rectification of weld defect	:	weld as per Cl.3	2.2 of IS 9595-96	, using A2 class ele	weld & rectifying ectrode as per IR	g the
8 Inspection of weld		2020. Visual, D.P. Test				14120-
			•		Dy. Chief	Entry
9 Any other relevant detail	:	None.			Engg. Wo	rkshop
					S.C. Rly, L	allagud

WELDING PROCEDURE SPECIFICATION SHEET ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

TAKEN AS CH: 20.00 "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-30.5M/WPSS/GMAW/18 1 Drawing No. RDSO/B-17172 (Section Plan) Weld Joint description 2 : |Fillet 8mm (Pad Plate Welding to End Cross Girder) 3 **Base Metal** IS:2062:2011, Gr E250B0 (10MM X 32MM) 4 **Welding Process** : GMAW 5 **Welding Position** : 2F 6 Welding Consumable 6.1 Electrode/Wire Class : 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. 6.2 Flux ग्रामक मण्डलं के श्री देश Class Research Officer (M. N.A Type Drying Method CO2 **Shielding Gas** : 6.3 Material to be cut straight & square by controlled gas cutting. Fusion faces 7.0 Base metal preparation and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. 7.1 Joint design details (Sketch showing arrangements of parts, PAD PL. 350X10X350 weld groove details, weld passes & their sequence etc.,) Dy. Chief High S.C. Rly, Lallagud As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current DC Type Polarity Reverse : Welder Qualification As per IS 7310 (Partyl) -817 ivas Rao

Welding parameters and technique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM BRIDGE NO. 4 (BOR) -- 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding	parameters ·
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Welding Sequence and technique

10.2

Welding Sequence No.	(mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
0	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

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0			
0			
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0			
0 11	Provision of run-on/run-off tabs	:	N.A.
0 12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	N.A.  100°C to 250°C  N.A.
15	Peening	:	N.A. Wilston Roseron Training
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	;	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None. Engg. Workshop S.C. Rly, Lallaguda
	TEEL CO.		my, canaguda

#### WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER "ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 JAKEN AS CH: 00 00 1 THE PROPOSED BRIDGE NO. 4 (ROR) A TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Name and address of Fabricator Toopran Mandal, Medak Dist. GSC/22/SRC-30.5M/WPSS/GMAW/19 Welding Procedure specification No. : Drawing No. 1 : RDSO/B-17172 Fillet 10mm (End Plate welding to Cross Girders) 2 Weld Joint description IS:2062:2011, Gr E250B0 (16mm X 10mm) 3 Base Metal : GMAW 4 **Welding Process** 2F 5 **Welding Position Welding Consumable** 6 6.1 Electrode/Wire Class 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. Flux 6.2 Class N.A Type Drying Method CO2 **Shielding Gas** 6.3 Material to be cut straight & square by controlled gas cutting. Fusion faces Base metal preparation 7.0 and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. : Part stretch shown. Joint design details 7.1 (Sketch showing arrangements of parts, 410 weld groove details, weld passes & their sequence etc.,) web 10 mm twul END PLATE 16X310X900 TYP. Dy. Chief Election 32 Engg. Workshop 410 S.C. Rly, Lallaguda As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current 8 Type DC Survey Polarity Reverse 5. S-As per IS 7310 (Part-I) - 817

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PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM
7/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED
BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL — VISHNUPURAM
ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters :
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Welding Sequence No.	(Amns)		Arc Voltage (Volt)	Wire Feed Speed	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
1	(mm)		24.20	(m/min)	N.A.	15-20	16-18	
	1.2	200-220	24-28	2.0-4.0			16-18	
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	10 10	

10.2	Welding Sequence and technique	:	
			10 TYP.
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C  Dy. Chief English
15	Peening	:	N.A. Engg. Workshop S.C. Rly, Lallaguda
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None.
	(ACF) CO		

WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"ACTION OF THE STATE O TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE, PROPOSED BRIDGE NO. 4 (ROR) AT CH: 38.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-30.5M/WPSS/GMAW/20 0 1 Drawing No. : RDSO/B-17172 (Detail at "Z") 2 Weld Joint description Single Bewel Welding of End Plate with Cross Girder & Fillet 10mm : 3 **Base Metal** IS:2062:2011, Gr E250B0 (16MM X 32MM) 4 **Welding Process GMAW** : 5 Welding Position : 2F 6 Welding Consumable 6.1 Electrode/Wire Class 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. 6.2 Flux Class : Type : N.A Drying Method : CO2 6.3 **Shielding Gas** Material to be cut straight & square by controlled gas cutting. Fusion faces 7.0 Base metal preparation and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. 7.1 Joint design details (Sketch showing arrangements of parts, weld groove details, weld passes & their PL. OF CROSS GIRDER sequence etc.,) 5---FILLED UP BY WELD MATERIAL Dy. Chief F Engg. Workshop S.C. Rly, Lallaguda END PL. OF CROSS **GIRDER 16 THICK** As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current : DC Polarity Reverse Survey As per IS 7310 (Part-I) - 817

वास राव/J. Srinivas Rao

Welding parameter and lecknique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 7/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM ATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding	parameters:
		parameters:

Welding Sequence No.	Electrodes Wire dia. (Amps		Arc Voltage (Volt)	Wire Feed Speed	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
A .	(mm)	(Allips)		(m/min)	N A	15-20	16-18	
1	1.2	200-220	24-28	2.0-4.0	N.A.		16-18	
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	10 10	

0	1.2 200-220	_	24-20 2.0 4.0
10.2	Welding Sequence and technique	:	1, 2
C	- 1		1
Ci.			
<b>&gt;</b>			2
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0			A PRITE
			— Officer of the second of the
			M 14 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A. Dy. Chief Englines Engg Workshop
16	Post weld treatment	:	N.A. S.C. Rly, Lallaguda
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020.
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None.
17	TEEL CO.	W - T	

0 WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER "25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

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"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 30.50M SPAN TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 38.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-30.5M/WPSS/GMAW/21 1 Drawing No. RDSO/B-17172, Detail at "X" : 2 Weld Joint description Single Bewel Welding & Fillet 6mm of Bracket 3 **Base Metal** IS:2062:2011, Gr E250B0 (10MM X 10MM) : 4 **Welding Process GMAW** : 5 Welding Position 2F : 6 Welding Consumable 6.1 Electrode/Wire Class 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. 6.2 Flux Class : N.A Type Parca Officer . Drying Method CO<sub>2</sub> 6.3 Shielding Gas Material to be cut straight & square by controlled gas cutting. Fusion faces 7.0 Base metal preparation and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Part stretch shown. Joint design details : (Sketch showing arrangements of parts, weld groove details, weld passes & their LAPPERED PL. 200x10x27: sequence etc.,) TO 230 AT TOP Dy. Chief Elyne Engg. Workshop S.C. Rly, Lallaguda 3 25 PL. 190X10X275 FILLED UP BY WELD MATERIAL As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current 8 Type DC Polarity 1.5 Reverse TEEL C

As per IS 7310 (Part-I) - 817

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Westing parameters and technique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM BRIDGE NO. 4 (200) HAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNOF CHILD OF BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM TATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

TO.I Welding	parameters:						Gas Flow
Welding Sequence No.	Electrodes wire dia.	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	(I/min)
	(mm)	(rumps)			N A	15-20	16-18
$C_{1}$	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	

Q						
	10.2	Welding Sequence and technique	:			
0-0-0-0-0				2		
)-0-0-0-0-				Aguar of the Aguard Research Officer (M.		
Ø	11	Provision of run-on/run-off tabs	:	N.A.		
	12	Cleaning of weld bead before laying of next weld bead	:	Yes		
0	13	Root preparation before welding other side of groove weld	:	N.A.		
0	14	Preheating and inter pass temperature	:	100°C to 250°C		
	15	Peening	:	N.A. Dy. Chief Enginee  Engg. Workshop'		
	16	Post weld treatment	:	N.A. S.C. Rly, Lallaguda		
		Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28 2020.		
	18	Inspection of weld	:	Visual, D.P. Test.		
	Day of the last	Any other relevant detail	:	None.		
	10	The state of the s	M			

# WELDING PROCEDURE SPECIFICATION SHEET

"25T LOADING-2008" 30.50M SPAN OPEN WEB GIRDER

(TAKEN AS CH. 20.20 NOTION TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF

Weldi	and address of Fabricator  ng Procedure specification No.	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
1		;	GSC/22/SRC-30.5M/WPSS/MMAW/22
2	Drawing No.	;	RDSO/B-11761
	Weld Joint description	1	Tack Weld (5mm)
3	Base Metal	1	IS:2062:2011, Gr E250B0 (10MM X 10MM)
4	Welding Process	1:	MMAW
5	Welding Position	1	1F/2F
6	Welding Consumable	+	21/21
6.1	Electrode/Wire  Class Type Drying Method	:::::::::::::::::::::::::::::::::::::::	A2 of IRS M28-2012 Medium Coated. As recommended by the Electrode Manufacturer.
	Class Type Drying Method	:::::::::::::::::::::::::::::::::::::::	N.A THE STATE OFFICER Research Officer
6.3	Shielding Gas	:	N.A
7.0	Base metal preparation	:	Fusion faces and adjacent surfaces are cleaned and made free from cracks, notches, mill scale, grease, paint, rust etc., which may affect we quality.
7.1	Joint design details	:	
	(weld beads details, weld passes & their sequence etc.,)		Length of tack Weld 50mm Gap between two tack Weld appr.300mm
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8.0	Welding Current		
	Туре	:	DC
	Polarity	:	Reverse Dy. Chief English
9.0	Welder Qualification	:	Engg. Workshop As per IS 7310 (Part-I) – 1974 S.C. Rly, Lallaguda
10.0	Welding parameters and technique EL COL	:	,,

## Appendix-V (Ref.Cl.26 of BI-2001)

	Appendix-V (Ref.Cl.26 of Bi-200										
B	PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.  10.1 Welding parameters:										
0	Welding Sequence No.		Electrodes wire dia. (mm)	Current (Amps)	Arc	Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
0		1	4	180-210		24-27	N.A.	N.A.	N.A.	N.A.	
0	10.2 Welding Sequence and technique  11.0 Provision of run-on/run-off tabs				:						
0					:	N.A.					
0	12.0	Cleaning of weld bead before laying of next weld bead			:	N.A.			Ve	12077	
0	13.0		paration before v roove weld	velding other	:	N.A.			THE RESERVE	Officer (M	
0	14.0	Preheati	ng and inter pass	temperature	:	N.A.			The of the same	ा <u>जाबम्</u> स्वाब	
C	15.0	Peening			:	N.A.					
C	16.0	Post weld treatment			:	N.A.					
C	17.0	Rectifica	tion of weld defe	ct	:	By re-weldin	g after complete	removal of defe	ective weld.		
2	18.0	18.0 Inspection of weld		:	Visual, D.P. T	est.		Dy. Chief Engg. Wo	Engilyze		
C	19.0	Any other relevant detail			:	None.			S.C. Rly, L	allaguda	

Railway Open Web Girder (25t loading)
45.7m clear span
MODEL WPSS No- RDSO/ Infra-II/ B&S/ RG/
OWG./ WPSS / 45.7 series (22 nos)

#### WELDING PROCEDURE SPECIFICATION SHEET

### "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

(TAKEN AS CU. 1970) TAKEN AS CU. 1970 TAKEN AS CU. 197 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:

ivaine a	N) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
Weldin	g Procedure specification No.		Toopran Mandal, Medak Dist.
1	Drawing No.	:	GSC/22/SRC-45.7M/WPSS/SAW/01
2	Weld leist de la constant de la cons	:	RDSO/B-17181/4/R, Section A-A
3	Weld Joint description Base Metal	:	Fillet 6mm (Bottom Chord, L0-L1 & L1-L2)
4		:	IS:2062:2011, Gr E250B0 (12MM X 16MM)
5	Welding Process	:	SAW
6	Welding Position	:	1F
	Welding Consumable		
6.1	Electrode/Wire		
	Class	١.	W1 of IRS M.39/2001.
	Type		Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2	Flux		
0.2			उद्यापक चतुन्तवान अविकास (A
	Class		F1 of IRS M.39-2001 Assistant Research Officer (
	Туре		Agglomerated
	Drying Method	:	250 C for one hour before uses OR Recommendation as per
			manufacturer.
6.3	Shielding Gas	:	N.A
			Fusion faces and adjacent surfaces are cleaned and made free from
7	Base metal preparation		cracks notches mill scale grosse point much and made free from
	A SUPERIOR STATE OF THE SUPERIOR AND SUPERIOR STATE OF THE SUPERIO		cracks, notches, mill scale, grease, paint, rust etc., which may affect weld quality.
7.1	Joint design details	_	weld quality.
7.1	(Sketch showing arrangements of parts, weld	:	
	groove details, weld passes & their sequence		
			/─ 2 PLs. 542x12
	etc.,)		1
			/ FL. PLs. 150x10
			/ TIL, FLS. IDUXII
	*		/.
			4 1
			1 10 1 10 1
			Dy. Chief English
			Food Wester
			Engg. Workshop
			S.C. Rly, Lallaguda
7.25			1
72	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
7.2		-	2001, Cl. 17.3
8	Welding Current		
	Туре	:	DC
	Polarity	:	Reverse
	Welder Qualification Mo		As per IS:7310 (Part-I) – 817
9	IMAINE ULQUINGUING		IMS DEL 15. (4.10 (Dort I) 045

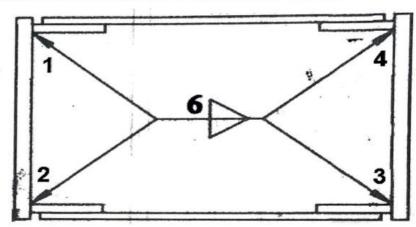
Welding parameters and technique

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT H: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF JUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding parameters:

Weld Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)	
1	4	450-550	28-32	0.45.0.55	25 - 30	N.A.	

10.2 Welding Sequence and technique : 1,2,3,4



7			
11	Provision of run-on/run-off tabs	:	Yes  N.A.  N.A.  Rescarch Officer (M)
12	Cleaning of weld bead before laying of next weld bead	:	N.A. ASSISSE Research Officer (NA)  N.A. ASSISSE Research Officer (NA)
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 150°C
15	Peening	:	N.A. Dy. Chief Engiriee
16	Post weld treatment	:	N.A. Engg. Workshop S.C. Rly, Lallaguda
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020
18	Inspection of weld	:	Visual, D.P. Test & Macro Etching.
19	Any other relevant detail	:	None

#### WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

	.,,,,	_	Reverse 1.5
3	Type	: 1	DC
.2	Joint preparation  Welding Current	: /	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		2 PLs. 542x20  4 FL. PLs. 150x2  Dy. Chief English Engg. Workshöß S.C. Rly, Lallagudå
7.1		:	weld quality.
7	Base metal preparation	:	Fusion faces and adjacent surfaces are cleaned and made free from cracks, notches, mill scale, grease, paint, rust etc., which may affect
6.3	Shielding Gas	:	N.A
	Type Drying Method		F1 of IRS M.39-2001 Agglomerated 250 C for one hour before uses OR Recommendation as per manufacturer.
6.2	2 Flux Class		F1 of IRS M.39-2001 Agglomerated  Agglomerated
	Type Drying Method	:	Copper coated Mild Steel Wire. N.A.
0	1 Electrode/Wire Class		W1 of IRS M.39/2001.
6.3	8		
5	8	:	1F
4	Troiling Frocess	:	SAW
3		:	IS:2062:2011, Gr E250B0 (20MM X 25MM)
2		:	Fillet 6mm (Bottom Chord, L2-L3 & L3-L4)
1		<u> </u>	RDSO/B-17181/4/R, Section B-B
AACIC	ding Procedure specification No.		Toopran Mandal, Medak Dist. GSC/22/SRC-45.7M/WPSS/SAW/02
	e and address of Fabricator	1 :	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,

As per IS:7310 (Part-I) - 817

Welder Qualification

Welding parameters and technique

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Appendix-V (Ref.Cl.26 of BI-2001

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1	Welding parameters:
	TO CHANGE DATA MILETELS .

Weld Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/Min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	4	450-550	28-32	0.45.0.55	25 - 30	N.A.

10.2	Welding Sequence and technique	:	1, 2, 3, 4
10.2	weiding sequence and technique	•	1, 2, 3, 4
			6 4
11	Provision of run-on/run-off tabs	:	Yes
12	Cleaning of weld bead before laying of next weld bead	:	N.A.
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 150°C  Aplatant Research Officer (M
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020
18	Inspection of weld	:	Visual, D.P. Test & Macro Etching.  Dy. Chief Engineer
19	Any other relevant detail	:	None Engg. Workshop S.C. Rly, Lallaguda

#### WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN S CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE, PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m

	1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
/oldi	ng Procedure	+	GSC/22/SRC-45.7M/WPSS/SAW/03
1	ng Procedure specification No.	<del>  i</del>	RDSO/B-17181/R, Section of U1-U2 & U2-U3
2	Drawing No.	+:	Fillet 6mm (Top Chord, U1 - U2 &U2 - U3 )
3	Weld Joint description	+:	IS:2062:2011, Gr E250B0 (10MM X 12MM & 12MM X 12MM)
4	Base Metal	+:	SAW
5	Welding Process	+:	
	Welding Position	+:	1F
6	Welding Consumable	$\vdash$	
6.1	Electrode/Wire	-	
	Class		W1 of IRS M.39/2001.
	Туре	:	Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2	Flux		13/64/2021
J.2	(1) (Sec.)		F1 of IRS M.39-2001
	Class		3 (a. a. Miller)
	Туре	1	Agglomerated 250 C for one hour before uses OR Recommendation as per
	Drying Method	1	250 C for one nour before uses OK Recommendation as per
			manufacturer.
6.3	Shielding Gas	:	N.A
			Fusion faces and adjacent surfaces are cleaned and made free from
7	Base metal preparation	:	cracks, notches, mill scale, grease, paint, rust etc., which may affect
			weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld		
	groove details, weld passes & their sequence		
	etc.,)		∕—TOP PL.642x12
	etc.,)		/ TOP PL.042X12
			0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0
			2PLs.542x12
			10 5 0 450 4
			/
			Tanasas
			Dy. Chief En
2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 Engg. Work
3	Welding Current		S.C. Rly, Lall
	Туре	;	DC
	Polarity	:	Reverse 1.5
	Welder Qualification		As per IS:7310 (Part-I) – 817
	A Complete Aller		AS DEL 13: / 310 (Part-1) - X1 /

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL - VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN 10.1 Welding parameters: Electrodes wire Weld Pass No. Travel Speed Electrical Stick out Current (Amps) Arc Voltage (Volt) Gas Flow (I/min) dia. (mm) (mm/Min) (mm) 1 450-550 28-32 0.45.0.55 25 - 30 N.A. 10.2 Welding Sequence and technique 1, 2, 3, 4 Provision of run-on/run-off tabs 11 Yes Cleaning of weld bead before laying of next 12 : N.A. weld bead Root preparation before welding other side of N.A. : 13 groove weld Preheating and inter pass temperature 100°C to 150°C 14 ऐस्र प्रत्याच्य समार N.A. 15 Peening N.A. Post weld treatment 16 By re-welding after complete removal of defective weld & rectifying the weld as per Rectification of weld defect 17 Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020 Inspection of weld Visual, D.P. Test & Macro Etching. : 18 Any other relevant detail None 19

# WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN S CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF PAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

1	CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF PAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.						
Т				NA/a CLORAL STEEL COMPANY Survey No.12 Kuchayaram Village			
-	vaine an	nd address of Fabricator		M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.			
V	Welding	Procedure specification No.	$\overline{}$	GSC/22/SRC-45.7M/WPSS/SAW/04			
0	1	Drawing No.	$\rightarrow$	RDSO/B-17181/R, Section of U3-U4			
1	2	Weld Joint description	$\rightarrow$	Fillet 6mm (Top Chord, U3 - U4 )			
Q	3	Base Metal	$\overline{}$	IS:2062:2011, Gr E250B0 (16MM X 16MM & 16MM X 20MM)			
	4	Welding Process	$\overline{}$	SAW			
U	5	Welding Position	_	1F			
1	6	Welding Consumable					
9	6.1	Electrode/Wire					
1		Class	:	W1 of IRS M.39/2001.			
1	,	Туре		Copper coated Mild Steel Wire.			
n	h	Drying Method		N.A.			
T	6.2	Flux		Land Service Control of the Control			
0		57 (1980)		The state of the s			
1		Class	(8)	F1 of IRS M.39-2001			
0	0			Aggiornerated			
1		Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.			
J	6.3	Shielding Gas		0.0000000000000000000000000000000000000			
1	0.5	Sillerding Gas	_:_	N.A			
TO S	7	Base metal preparation		Fusion faces and adjacent surfaces are cleaned and made free from			
1	Α,	base metal preparation	:	cracks, notches, mill scale, grease, paint, rust etc., which may affect			
1	7.1	Joint design details		weld quality.			
d	· · · -	(Sketch showing arrangements of parts, weld	-				
1	,	groove details, weld passes & their sequence		TOD DI OLO LO			
9		etc.,)		TOP_PL.642x16			
		etc.,,		= 0 12X10			
				The state of the s			
1							
1				\ \ \ \ \			
	a			2PLs.542x16			
(3)	,						
1							
1				2 FL.PLs,150x20			
				,			
2				Dy. Chief Enthitele			
				Engg. Workshop			
3	7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3			
1	8	Welding Current		5, 5007 NO B1 = 2001, Cl. 17.3			
1		Туре	:	DC			
L		Polarity	:	Reverse 1.5			
1		Welder Qualification Mo	:	As per IS:7310 (Part-I) – 817			
L	-	Welding parameters and technique	जे.	श्रीनिवास राव/J. Srinivas Rao Evecutivo Engine			
3	10	Welding 190 12 x	5	Executive Engineer			

1 4 450-550 28-32 0.45.0.55 25-30 N.  10.2 Welding Sequence and technique : 1, 2, 3, 4  11 Provision of run-on/run-off tabs : Yes  12 Cleaning of weld bead before laying of next weld bead Root preparation before welding other side of growe weld : N.A.  13 Root preparation before welding other side of growe weld Preheating and inter pass temperature : 100°C to 150°C  15 Peening : N.A.  16 Post weld treatment : N.A.  17 Rectification of weld defect : By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020	10.1	Welding	parameters :					
1 4 450-550 28-32 0.45.0.55 25-30 N.  10.2 Welding Sequence and technique : 1, 2, 3, 4  11 Provision of run-on/run-off tabs : Yes  12 Cleaning of weld bead before laying of next weld bead sed of groove weld sed of groove weld : N.A.  13 Root preparation before welding other side of groove weld interpretation in the pass temperature : 100°C to 150°C  15 Peening : N.A.  16 Post weld treatment : N.A.  17 Rectification of weld defect : By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020			Electrodes wire	Current (Amps)	Arc Voltage (Volt)			Gas Flow (I/mi
11 Provision of run-on/run-off tabs  12 Cleaning of weld bead before laying of next weld bead Root preparation before welding other side of groove weld  13 Root preparation before welding other side of groove weld  14 Preheating and inter pass temperature  15 Peening  1 N.A.  16 Post weld treatment  1 N.A.  18 Pre-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020		1	4	450-550	28-32	35°000 (000000000000000000000000000000000	N. N	N.A.
11 Provision of run-on/run-off tabs : Yes  12 Cleaning of weld bead before laying of next weld bead sed service weld bead : N.A.  13 Root preparation before welding other side of groove weld : N.A.  14 Preheating and inter pass temperature : 100°C to 150°C  15 Peening : N.A.  16 Post weld treatment : N.A.  17 Rectification of weld defect : By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020	10.2	W	elding Sequence ar	nd technique	: 1, 2, 3, 4			<b>A</b>
Cleaning of weld bead before laying of next weld bead  Root preparation before welding other side of groove weld  13 Root preparation before welding other side of groove weld  14 Preheating and inter pass temperature  15 Peening  16 Post weld treatment  17 Rectification of weld defect  18 Pre-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020					2	6		
weld bead  Root preparation before welding other side of groove weld  Preheating and inter pass temperature  100°C to 150°C  Peening  N.A.  N.A.  Post weld treatment  N.A.  Rectification of weld defect  By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020								4
Peening : N.A.  16 Post weld treatment : N.A.  17 Rectification of weld defect : By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020	11				: Yes	=======================================		4
Peening : N.A.  16 Post weld treatment : N.A.  17 Rectification of weld defect : By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020		Cleaning weld bea	of weld bead befor d	e laying of next				
Peening : N.A.  16 Post weld treatment : N.A.  17 Rectification of weld defect : By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020	12	Cleaning weld bea Root pre	of weld bead befor d paration before we	e laying of next	: N.A.			A CONTRACT (III
By re-welding after complete removal of defective weld & rectifying the weld Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020	12	Cleaning weld bea Root pre groove w	of weld bead befor d paration before wel	e laying of next	: N.A. : N.A.		egyaw agas	CALCH Officer (
Ci.32.2 of 13 9393-96, using A2 class electrode as per IRS M28-2020	12 13 14	Cleaning weld bea Root pregroove w	of weld bead befor d paration before wel	e laying of next	: N.A. : N.A. : 100°C to 150°C		agram ugas malatant Res	CALCH Officer (CALCH CALCH CAL
	12 13 14 15	Cleaning weld bea Root pregroove w Preheatin	of weld bead befor d paration before wel eld ng and inter pass te	e laying of next	: N.A. : N.A. : 100°C to 150°C : N.A.		agran agas acelatant Res	earch Officer (earch water was
18 Inspection of weld : Visual, D.P. Test & Macro Etching.  Dy. Chief Engineer	12 13 14 15 16	Cleaning weld bea Root pregroove w Preheatin Peening	of weld bead befor d paration before wel eld ng and inter pass te	e laying of next	: N.A. : N.A. : 100°C to 150°C : N.A. : N.A. : N.A.	iter complete removal of	defective wold & roctifui	তে অব্যাত্ত <b>্ত</b>

#### WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN NT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m

Procedure specification No.  Procedure specif	: : : : : : : : : : : : : : : : : : : :	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.  GSC/22/SRC-45.7M/WPSS/SAW/05  RDSO/B-17181/R, Section L0-U1  Fillet 6 mm (End Raker)  IS:2062:2011, Gr E250B0 (16MM X 20MM)  SAW  1F  W1 of IRS M.39/2001.  Copper coated Mild Steel Wire.  N.A.  F1 of IRS M.39-2001  Agglomerated
Drawing No.  Weld Joint description Base Metal  Welding Process  Welding Position  Welding Consumable  Electrode/Wire  Class Type Drying Method  Flux  Class Type Drying Method	: : : : : : : : : : : : : : : : : : : :	GSC/22/SRC-45.7M/WPSS/SAW/05  RDSO/B-17181/R, Section L0-U1  Fillet 6 mm (End Raker) IS:2062:2011, Gr E250B0 (16MM X 20MM)  SAW  1F  W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.  F1 of IRS M.39-2001
Drawing No.  Weld Joint description Base Metal  Welding Process  Welding Position  Welding Consumable  Electrode/Wire  Class Type Drying Method  Flux  Class Type Drying Method	: : : : : : : : : : : : : : : : : : : :	RDSO/B-17181/R, Section LO-U1 Fillet 6 mm (End Raker) IS:2062:2011, Gr E250B0 (16MM X 20MM) SAW  1F  W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.  F1 of IRS M.39-2001
Weld Joint description Base Metal Welding Process Welding Position Welding Consumable Electrode/Wire Class Type Drying Method Flux Class Type Drying Method	: : : : : : : : : : : : : : : : : : : :	Fillet 6 mm (End Raker) IS:2062:2011, Gr E250B0 (16MM X 20MM) SAW  1F  W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.  F1 of IRS M.39-2001
Base Metal Welding Process Welding Position Welding Consumable Electrode/Wire Class Type Drying Method Flux Class Type Drying Method	: : : : : : : : : : : : : : : : : : : :	IS:2062:2011, Gr E250B0 (16MM X 20MM)  SAW  IF  W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.  F1 of IRS M.39-2001
Welding Process Welding Position Welding Consumable Electrode/Wire Class Type Drying Method Flux Class Type Drying Method	: : : : : : : : : : : : : : : : : : : :	SAW  1F  W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.  F1 of IRS M.39-2001
Welding Position Welding Consumable Electrode/Wire Class Type Drying Method Flux Class Type Drying Method	:	W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.  F1 of IRS M.39-2001
Welding Consumable Electrode/Wire Class Type Drying Method Flux Class Type Drying Method	:	Copper coated Mild Steel Wire.  N.A.  F1 of IRS M.39-2001  Steel Wire.  Steel Wire.
Electrode/Wire Class Type Drying Method Flux Class Type Drying Method	:	Copper coated Mild Steel Wire.  N.A.  F1 of IRS M.39-2001  Steel Wire.  Steel Wire.
Class Type Drying Method Flux Class Type Drying Method	:	Copper coated Mild Steel Wire.  N.A.  F1 of IRS M.39-2001  Steel Wire.  Steel Wire.
Drying Method  Flux  Class Type Drying Method	:	N.A.  F1 of IRS M.39-2001  Page 1 of IRS M.39-2001  Page 1 of IRS M.39-2001
Drying Method  Flux  Class Type Drying Method	:	F1 of IRS M.39-2001
Flux Class Type Drying Method	:	F1 of IRS M.39-2001
Class Type Drying Method	:	F1 of IRS M.39-2001
Type Drying Method	:	latest Research Officer (
Drying Method		Aggiomerated
1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000 - 1000		250 C fee and have before one OR Recorded Attack and the feet and the
Shielding Gas		250 C for one hour before uses OR Recommendation as per manufacturer.
Shielding Gas		
	:	NA .
Base metal preparation	:	Fusion faces and adjacent surfaces are cleaned and made free from crack
		notches, mill scale, grease, paint, rust etc., which may affect weld quality.
Joint design details	:	
(Sketch showing arrangements of parts,		
weld groove details, weld passes & their	1	_TOP_PL.642x20
sequence etc.,)		/ 101 FL.042XZU
		<b>1</b>
		The state of the s
	1	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\
		2PLs.542x16
		21 L3.57ZX10
	1	
		- 2 EL DI-1E0 00
		2 FL.PLs.150x20
		Dy. Chief Enthag
		Engg. Workshop
		S.C. Rly, Lallagud
N		
Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
Welding Current		
	:	DC C
	1/2	Welding Current

As per IS 7310 (Part I) - 1974

Welder Qualification 12

	ER.	3-9, BETWEEN KOND	MAL POWER PLANT AT RAPOL – VISHNUPURAI	VEERLA PALEM M STATIONS ON	N VILLAGE. I N BN-NDKD	PROPOSED BRIDGE N SECTION OF GUNTUR	Y STATION AT KM 137/970 ( O. 4 (ROR) AT CH: 1138.00m R DIVISION) OF SPAN (1X30.	n (CROSSING EXG. 5m + 2 X 45.7m) OPER
10.1 V	Velding	parameters :			TO THE	医线/图 高级	GROSS AND AND AND A	
Weld Pa	Weld Pass No. Electrodes wire		Arc Voltage (	(Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (I/min)	
1		4	450-550	28-32		0.45.0.55	25 - 30	N.A.
10.2	W	elding Sequence a	nd technique	: 1, 2, 3, 4				
					2/			
11		on of run-on/run-of		: Yes	2/	na 6 kg ga		4
12	Cleanin weld be	ng of weld bead bef	ore laying of next	: N.A.				
12	Cleanin weld be	ng of weld bead bef ead reparation before v		: N.A.				4
12	Cleanin weld be Root pr groove	ng of weld bead bef ead reparation before v	ore laying of next welding other side of	: N.A.	to 150°C		्राक स्टूर	वान अधिकारा (बा
12	Cleanin weld be Root pr groove	ng of weld bead bef ead reparation before v weld ating and inter pass	ore laying of next welding other side of	: N.A.	to 150°C		Ambient Re	वान अधिकारा (बा
12 13 14	Cleanin weld be Root pr groove Prehea	ng of weld bead bef ead reparation before v weld ating and inter pass	ore laying of next welding other side of	: N.A. : N.A. : 100°C to	to 150°C		Assistant Re	वान अधिकारी (बा खान अधिकारी (बा खान अधिकारी (बा क्षेत्रकारी क्षांकर
12 13 14 15 16	Cleanin weld be Root pr groove Prehea Peenin Post w	ng of weld bead before weld arting and inter pass	velding other side of temperature	: N.A. : N.A. : 100°C t : N.A. : N.A.	welding aff	ter complete remov 5-96, using A2 class	ral of defective weld & recelectrode as per IRS M28	चान अधिकारे (बा mearch Officer () देख धन्धावय वर्षाः ctifying the weld as
12 13 14 15 16	Cleanin weld be Root prigroove Prehea Peenin Post w	ng of weld bead before we weld and inter pass and inter pass weld treatment	velding other side of temperature	: N.A. : N.A. : 100°C to : N.A. : N.A. : By re-w	welding aff 2 of IS 959:	ter complete remov 5-96, using A2 class & Macro Etching.	ral of defective weld & recelectrode as per IRS M28	चान अधिकारे (बा mearch Officer () देख धन्धावय वयन ctifying the weld as

### WELDING PROCEDURE SPECIFICATION SHEET

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

(TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER

ame a	N) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GII and address of Fabricator		M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
		:	Toopran Mandal, Medak Dist.
/eldin	g Procedure specification No.	:	GSC/22/SRC-45.7M/WPSS/SAW/06
1	Drawing No.	:	RDSO/B-17181/R, Section U1-L2
2	Weld Joint description	:	Fillet 6mm (Diagonals)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (12MM X 16MM)
4	Welding Process	:	SAW
5	Welding Position	:	1F
6	Welding Consumable		
6.1	Electrode/Wire		
	Class		W1 of IRS M.39/2001.
)	Туре	:	Copper coated Mild Steel Wire.
	Drying Method		
-	man a di nomina di managante i nomi	•	191617
6.2	Flux		
1	Class	11.5	F1 of IRS M.39-2001 Agglomerated  Agglomerated  Agglomerated
	Туре		Agglomerated GodoNio रेज अस्थायन
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacture
6.3	Shielding Gas	:	NA
7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion fac
Ò		:	and adjacent surfaces are cleaned and made free from Crack, Notches, N
			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
3	(Sketch showing arrangements of parts,		
	weld groove details, weld passes & their		2 Dl = 400.40
	sequence etc.,)		2 PLs. 400x16
<b>y</b>			
			_ 1 El Dia 10010
			/ 4 FL. PLs. 100x12
C			
			16
			Dy. Chief Engineet
			Engg. Workshop
	in the second se		S.C. Rly, Lallaguda
	- Ara-		*
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current		
	Туре	:	DC
	Polarity	:	Reverse

WEB G	n) FOR (5X80 AT KM: 133/ IRDER.	100MW) YADADRI THE 1/8-9, BETWEEN KOND	TAKING OFF FROM CH RMAL POWER PLANT DRAPOL – VISHNUPUR	:2027m OF JNPD END ( AT VEERLA PALEM VILL IAM STATIONS ON BN-I	OF VISHNUPURAM RAILWA AGE. PROPOSED BRIDGE N NDKD SECTION OF GUNTUI	NY STATION AT KM 137/970 IO. 4 (ROR) AT CH: 1138.00 R DIVISION) OF SPAN (1X30	(TAKEN AS CH: m (CROSSING EXG. J.5m + 2 X 45.7m) OPE
10.:	1 Welding	parameters :					
	Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (I/min
	1	4	450-550	28-32	0.45.0.55	25 - 30	N.A.
10.2	W	elding Sequence ar	ad tachairus	: 1, 2, 3, 4	•		
				6			
11	Provision	of run-on/run-off t	tabs	: Yes			
12	Cleaning weld bea	of weld bead befor d	e laying of next	: N.A.			
13	Root prep groove w	paration before we	lding other side of	: N.A.		ুবেদ বাট্ট	ह्यान के ये तारी (
14	Preheatin	ng and inter pass te	mperature	: 100°C to 150°C		Great Re	esearch Officer देण जन्माच्य चर्
15	Peening			: N.A.		SOUDHIAG.	
16	Post weld	d treatment		: N.A.			
	Rectificat	ion of weld defect		By re-welding a Cl.32.2 of IS 95	fter complete removal o 95-96, using A2 class elec	of defective weld & rectifectrode as per IRS M28-20	ying the weld as po 020
17							
17	Inspection	n of weld		: Visual, D.P. Tes	t & Macro Etching.	Tassa	1/11/

# WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

DIVISION) OF SPAN (	1X30.5m + 2 X 45.7m) OPEN WEB GI	RDE	RONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR R.
Name and address		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure	specification No.	:	GSC/22/SRC-45.7M/WPSS/SAW/07
1 Drawing N		•	RDSO/B-17181/R, Section of Verticals
	t description	÷	Fillet 6mm (Verticals)
3 Base Met		÷	IS:2062:2011, Gr E250B0 (10MM X 12MM)
4 Welding F		÷	SAW
5 Welding F		÷	2F
В.	Consumable	•	ZF
6.1 Electrode		-	
Licettode	1.000 E.000		
	Class	:	W1 of IRS M.39/2001.
	Type	:	Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2 Flux			ज्यान गाँउनारी (बार्
	Class	:	F1 of IRS M.39-2001
	Туре		Agglomerated
	Drying Method		250 C for one hour before uses OR Recommendation as per manufacturer
	Drying Method	•	230 C for one flour before uses OK Recommendation as per manufacturer
6.3 Shielding	Gas	:	NA
7.0 Base met	al preparation		Material to be cut straight & square by controlled gas cutting. Fusion face
	3.00 (100 (100 (100 (100 (100 (100 (100 (		and adjacent surfaces are cleaned and made free from Crack, Notches, Mi
		:	Scale, Grease Paint, Rust etc., which may affected Weld.
			, , , , , , , , , , , , , , , , , , , ,
7.1 Joint desi	gn details	:	Part stretch shown.
(Sketch s	howing arrangements of parts,		
weld groo	e etc.,)		6 FL. PL. 200x12
			FL. PL. 200x12 Chief English Engg. Worksho
7.2 Joint prep		:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8 Welding (	Current		DC
	Type	<u>:</u>	7) 25 (27)
7	Polarity	•	Reverse
9 Welder Q	ualification	:	As per IS 7310 (Part-I) – 817
10 Welding	parameters and technique	:	Company and

Enga Workshop

#### WELDING PROCEDURE SPECIFICATION SHEET

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5x800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1x30.5m + 2 x 45.7m) OPEN WEB GIRDER.

Name a	and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Weldin	g Procedure specification No.	-	GSC/22/SRC-45.7M/WPSS/SAW/08
1	Drawing No.	÷	RDSO/B-17181/R (L <sub>0</sub> -L' <sub>0</sub> , L <sub>1</sub> -L' <sub>1</sub> , L <sub>2</sub> -L' <sub>2</sub> , L <sub>3</sub> -L' <sub>3</sub> , L <sub>4</sub> -L' <sub>4</sub> )
2	Control Contro	•	The control of the co
3	Weld Joint description	:	Fillet 12mm (Cross Girder)
4	Base Metal	:	IS:2062:2011, Gr E250B0 (20MM X 25MM)
10.70	Welding Process	:	SAW
5	Welding Position	:	2F
6	Welding Consumable	_	
6.1	Electrode/Wire Class Type Drying Method	: ::	W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.
6.2	Flux		वद्यापक विद्यापान गा
	Class		F1 of IRS M.39-2001
	Туре		Agglomerated
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacture
6.3	Shielding Gas	:	NA
7.0	Base metal preparation	:	Material to be cut straight & square by controlled gas cutting. Fusion factorial and adjacent surfaces are cleaned and made free from Crack, Notches, Notches, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		TOP FL. PL.450X25  WEB PL.925X20  Dy. Chief Eng Engg. Works S.C. Rly, Lalla BOTT.FL. PL.450X25
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
0	Туре	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817

Welding parameters and technique

Appendix-V (Ref.CI.26 of BI-2001)

ec Ply Lallaguda

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS 2H: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE'NO. 4 (ROR) AT CH: 1138.00m CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN 2x30.5m + 2 X 45.7m) OPEN WEB GIRDER.

# 10.1 Welding parameters:

Weld F	Pass No	and and	Current (	Current (Amps)		Arc Voltage (Volt)		Electrical Stick out (mm)	Gas Flow (I/min)
N		(mm)	AC	DC	AC	DC	(M/Min)	July ()	(4)
9	1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
•	2	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
10.2	Weldi	ng Sequence ar	nd technique		102 204				

1	3
4	3.

11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C Applicant Research Officer (Mo
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020
18	Inspection of weld	:	Visual, D.P. Test.
19		:	None. Dy. Chief Enginee Engg. Workshop

# WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

(TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 3.7.45.7m) OPEN WER CIRDER

D	IVISION	) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIR	DER	
12		nd address of Fabricator		M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
1				Toopran Mandal, Medak Dist.
1	Velding	Procedure specification No.	:	GSC/22/SRC-45.7M/WPSS/SAW/09
1	_1	Drawing No.	:	RDSO/B-17181/R (L <sub>0</sub> -L <sub>1</sub> , L <sub>1</sub> -L <sub>2</sub> , L <sub>2</sub> -L <sub>3</sub> , L <sub>3</sub> -L <sub>4</sub> )
Ľ	2	Weld Joint description	:	Fillet 10mm (Stringer)
1	3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 20MM)
Ĺ	4	Welding Process	:	SAW
	_ 5	Welding Position	:	2F
Ľ	6	Welding Consumable		
	6.1	Electrode/Wire Class Type Drying Method	: :	W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.
4	6.2	Flux		(SEE )   SEE
4	h	Class	:	F1 of IRS M.39-2001
ì		Туре	:	Aggiornerated
0	A .	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
S	6.3	Shielding Gas	:	NA
0	7.0	Base metal preparation	:	Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mil Scale, Grease Paint, Rust etc., which may affected Weld.
1	7.1	Joint design details	:	Part stretch shown.
		(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,).		TOP FL. PL.450X20  WEB PL.750X10  BOTT.FL. PL.450X20
1	1 72	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
j	7.2	Welding Current		Dy. Chief Engineer
1	8	Туре	:	Enga Workshop
	0	Polarity	:	S.C. Rly, Lallaguda
	9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
	10	Welding parameters and technique	:	

pendix-V (Ref.Cl.26 of BI-2001)

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE, PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m ROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

→ 10.1 V	Velding	parameters:							
Weld Pa	ass No	Electrodes wire dia. (mm)	Current (	Amps)	Arc Volt	age (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (I/min)
.,,		(mm)	AC/	DC	AC/	DC	SE 58 ES		
7 1		4	A50-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
10.2	Weldi	ng Sequence an	d technique	:	1&2, 3&4				
						4		3 3u	]
		of run-on/run-	OCCUPATION OF STREET	:	N.A.			5	
12	next wel			:	N.A.				)
		paration before roove weld	welding other	:	N.A.			व अब्रह्मान अवर	TET (MI)
14	Preheati	ng and inter pa	ss temperature	:	100°C to 250°	c		that Research O	de ages
15	Peening			:	N.A.		Colle	41	
16	Post wel	d treatment		:	N.A.				
17	17 Rectification of weld defect		fect	·				fective weld & re class electrode as	
18	Inspectio	on of weld		:	Visual, D.P. Te	est.		Feerman	Antre
19	Any othe	er relevant deta	il	:	None.			Engg. Work	shop

### WELDING PROCEDURE SPECIFICATION SHEET

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970
TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:
1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR
DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Name	and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Weldi	ng Procedure specification No.	+.	GSC/22/SRC-45.7M/WPSS/SAW/10
7 1	Drawing No.	H	RDSO/B-17181/R Portal Girders (U <sub>1</sub> -U' <sub>1</sub> )
2	Weld Joint description	H	Fillet 6mm (Portal Girder)
3	Base Metal	+:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
4	Welding Process	+:	SAW
5	Welding Position	+	2F
6	Welding Consumable	Ť.	
6.1	Electrode/Wire	T	
	Class	١,	W1 of IRS M.39/2001.
	Туре	:	Copper coated Mild Steel Wire.
	Drying Method	1	
	1 100 200 3 200 200 200 200 200 200 200 200	Ι.	N.A.
6.2	Flux	-	
	Class	-	F1 of IRS M.39-2001 Agglomerated
	Туре	1	Set William
·	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer
6.3	Shielding Gas	:	NA
7.0	Base metal preparation	:	Material to be cut straight & square by controlled gas cutting. Fusion faces
			and adjacent surfaces are cleaned and made free from Crack, Notches, Mi
			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
	(Sketch showing arrangements of parts,		✓ TOP FL.
	weld groove details, weld passes & their		PL.200X10
)	sequence etc.,).		
	1		
	1		WEB PL.522X10
	1		242
			v
			6
			•
			BOTT.FL.
			PL. 200X10
	Joint preparation		As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
		•	
8	Welding Current Type		DC Dy Chief Foundation
	Polarity	÷	Dy. Office 2.19
	. Marie	·	Lings
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817 S.C. Rly, Lallaguda
10	Welding parameters and technique	:	

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN A H: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Weld Pass No  Electrodes wire dia.  (mm)		(Amps)	Arc Volta	age (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flov (I/min)		
		(mm)	AC /	DC	AC /	DC			
•	1	4	A50-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.
10	0.2 Weldin	g Sequence an	d technique	:	1&2, 3&4				
						4 /		<b>3</b> v	
11	Provision o	f run-on/run-o	ff tabs	:	N.A.				
Signatur	Cleaning of next weld b	weld bead bef	ore laying of	:	N.A.	2	(		
12	luext weig r	)eau							
12	Root prepa	ration before w	elding other	:	N.A.		and the same of th	3/01/2000	W.
10000	Root prepa side of groo	ration before w		:	N.A. 100°C to 250°C		4 1021 4 10 4 40	Research Officer	(M) Sea
13	Root prepa side of groo	ration before w ove weld					्राहरू वर्षाचन स	Research Officer	(M)
13 14	Root prepa side of groo Preheating	ration before wove weld and inter pass		:	100°C to 250°C		वर्षाणक व्या	See at all a g	্মি (Mi
13 14 15	Root prepa side of groot Preheating Peening Post weld tr	ration before wove weld and inter pass	temperature	: :	100°C to 250°C  N.A.  N.A.  By re-welding aft	er complete	removal of defec	ctive weld & recti	fying the
13 14 15 16	Root prepa side of groot Preheating Peening Post weld tr	ration before wove weld and inter pass reatment of weld defect	temperature	: :	100°C to 250°C  N.A.  N.A.  By re-welding aft weld as per Cl.32	er complete 2 of IS 9595	removal of defec-96, using A2 clas	Research Office	fying the er IRS M28

### WELDING PROCEDURE SPECIFICATION SHEET

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURA

Name an	OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIR d address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,					
Welding	Procedure specification No.	_	Toopran Mandal, Medak Dist.					
1	Drawing No.	$\rightarrow$	GSC/22/SRC-45.7M/WPSS/SAW/11					
			RDSO/B-17181/R (Sway Girder U <sub>2</sub> -U' <sub>2</sub> , U <sub>3</sub> -U' <sub>3</sub> , U <sub>4</sub> -U' <sub>4</sub> )					
Weld Joint description     Base Metal		$\overline{}$	Fillet 6mm (Sway Girder)					
4		$\overline{}$	IS:2062:2011, Gr E250B0 (10MM X 16MM)					
5	Welding Process	$\rightarrow$	SAW					
6	Welding Position	:	2F					
6.1	Welding Consumable							
0.1	Electrode/Wire							
	Class	:	W1 of IRS M.39/2001.					
	Туре	:	Copper coated Mild Steel Wire.					
d	Drying Method	:	N.A.					
6.2	Flux		12/01/500					
Ò	Class	:	F1 of IRS M.39-2001 Applomerated					
	Туре	:	Agglomerated  Agglomerated  Agglomerated					
7	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacture					
6.3	Shielding Gas		NA					
7.0	Base metal preparation	·	Material to be cut straight & square by controlled gas cutting. Fusion fac					
7.0	base metal preparation		and adjacent surfaces are cleaned and made free from Crack, Notches, N					
0			Scale, Grease Paint, Rust etc., which may affected Weld.					
	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	-						
7.1	Joint design details	:	Part stretch shown.					
1	(Sketch showing arrangements of parts,		TOP FL.					
0	weld groove details, weld passes & their		PL.160X16					
200	sequence etc.,).							
7								
2								
C			WEB PL. 526X10					
Ž			828					
1			K					
2								
1.			6					
7			BOTT.FL.					
1			PL.160X16					
7			TL.100A10					
7.0	Joint preparation	;	As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3					
7.2	Welding Current		Dy Chief Engineer					
8	Type	:	DC Enga, Workshop					
0	Polarity	:	Reverse S.C. Rly, Lallaguda					
1.00	Welder Qualification	:	As per IS 7310 (Part-I) – 817					
9	Welding parameters and technique	:						
10	Melaluk Karaman		7.50 Dan leval					

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS

-0.2	Welding	parameters :								
Weld Pass No		Electrodes wire dia.	Current (A	Amps)	Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flov (I/min)	
	(mm)		AC /	DC	AC /	DC	<b>\</b> \.,,	,	(1) 111111)	
	1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.	
10.2	Weldir	ng Sequence an	d technique	:	1&2, 3&4					
) )——					1	4 2	4	3/	l	
11	Provision	of run-on/run-	off tabs	:	N.A.					
12	next wel			:	Yes			0 -		
13	The second second second	paration before roove weld	welding other	:	N.A.			131-1179	भेट्रे शाबु विकास	
14	Preheati	ng and inter pas	ss temperature	:	N.A.  100°C to 250°C  agree was all of Officer (Market Research Officer					
15	Peening			:	N.A.		. 153	a Research On to		
16	Post wel	d treatment		:	N.A.					
17	Rectifica	tion of weld de	fect	:	By re-welding weld as per Cl. 2020	after comple 32.2 of IS 95	te removal of def 95-96, using A2 c	fective weld & rec lass electrode as p	tifying the per IRS M2	
	Inspection	on of weld	*	:	Visual, D.P. Tes	st.	_	15/4/2		
0 18							10	6/4/2		
,0 18 19		er relevant deta	il	:	None.		Dv.	Chief Englises	1	

5				Page-23 Appendix-V (Ref.Cl.26 of BI-2001)
	1	WEIDING	- Dr	
1				ROCEDURE SPECIFICATION SHEET
5	PROJE	CI: PROPOSED RAILWAY SIDING TAKING OFF FROM	MC	008" 45.7 M SPAN OPEN WEB GIRDER H:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970
-	LIMKE	N AS CH: 00.00m) FOR (5X800MW) YADADRI THER	MAI	POWER PLANT AT VEERLA DALEM VILLAGE PROPOSED PRINCE NO. 4 (POR) AT CH-
0		CROSSING EXG. TRACK AT KM: 133/8-9 RETU	NFF	N KONDRAPOL - VISHNI IDI IRAM STATIONS ON BN NDVD SECTION OF GUNTUR
	DIVISI	ON) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB G	IRDE	ER.
3	Name	and address of Fabricator	١.	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
			Ι.	Toopran Mandal, Medak Dist.
J		ing Procedure specification No.	:	GSC/22/SRC-45.7M/WPSS/SAW/12
	1	Drawing No.	:	RDSO/B-17181/R (U <sub>1</sub> -U' <sub>2</sub> , U <sub>2</sub> -U' <sub>3</sub> , U <sub>3</sub> -U' <sub>4</sub> )
1	2	Weld Joint description	1:	Fillet 6mm (Top Lateral Bracings)
	3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
		Welding Process	:	SAW
_	5	Welding Position	:	2F
7	6	Welding Consumable		
	6.1	Electrode/Wire		
		Class	١.	W1 of IRS M.39/2001.
2		Туре	١.	Copper coated Mild Steel Wire.
1		Drying Method		N.A.
	6.2	Flux	-	200
		Class		
A		Type	1	The state of the s
1		Drying Method		Agglomerated 250 C for one hour before uses OR Recommendation as per manufacturer.
		Drying Method	١.	250 C for one flour before uses or Recommendation as per manufacturer.
0	6.3	Shielding Gas	·	NA
1	7.0	Base metal preparation	<u> </u>	(A)
0	10.15	See Marie Proparetion	١.	Material to be cut straight & square by controlled gas cutting. Fusion faces
				and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld.
1	7.1	Joint design details		
ŀ	7.1	(Sketch showing arrangements of parts,	:	Part stretch shown.
		weld groove details, weld passes & their		000
		sequence etc.,).		1 200 .
		sequence etc.,).		200
				DI DI AAA IA
1				FL. PL. 200x 10
1				
1				WILD DI 100V10
l				WEB PL. 100X10
				6
				V
_		Joint preparation		As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
	7.2	Welding Current	•	Dv. Chief Engine
	8	Type	$\overline{\cdot}$	DC Engg. Workshop
		Polarity	$\rightarrow$	Reverse S.C. Rly, Lallaguda
		, clairej	*	

: As per IS 7310 (Part-I) – 817

Welder Qualification

10

Welding parameters and technique

Appendix-V (Ref.Cl.26 of BI-2001)

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding parameters .

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	4	450-550	28-32	0.45.0.55	25 - 30	N.A.

				450-550		28-32	0.45.0.55	,	25 - 30	N.A.
6	10	0.2 Welding	g Sequence ar	nd technique	T :					
6	0									
9	ì								<b>16</b>	i
5									14	
T	1						,	1 1	/	
9										
T										
T	11	Provision of	run-on/run-o	off tabs	:	N.A.				
C	12	Cleaning of next weld b		fore laying of	:	N.A.				
C	13	Root prepar side of groo		welding other	:	N.A.				DANZEIG
0	14	Preheating a	and inter pass	temperature	:	100°C to 250°C	3	4.5	alstant Research	Officer (M
2	15	Peening			:	N.A.		201	াত্রাতরত ইয়া অ	पाचन चन्य
O	16	Post weld tre	eatment		:	N.A.		8		
3	17	Rectification	of weld defe	ct	:	By re-welding a weld as per Cl. 2020	after complete remo 32.2 of IS 9595-96, u	oval of defe	ctive weld & rec ss electrode as p	tifying the per IRS M28-
3	18	Inspection of	weld		:	Visual, D.P. Tes	t.		y. Chief En	Thom
, U	19	Any other rel	evant detail		:	None.			Engg. Works	hop

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

			GIRI	AL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT EN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DER.
Vam	ne ar	nd address of Fabricator		: M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
-				Toopran Mandal, Medak Dist.
		Procedure specification No.		: GSC/22/SRC-45.7M/WPSS/GMAW/13
_1		Drawing No.	+	: RDSO/B-17181/13, Detail at H
2		Weld Joint description	$\overline{}$	Fillet 6mm (Rib Plate)
3	_	Base Metal	+	: IS:2062:2011, Gr E250B0 (10MM X 10MM)
4		Welding Process	+	: GMAW
_ 5		Welding Position	+	: 2F
_ 6	, i	Welding Consumable	+	2
6.1	1	Electrode/Wire	+	
		Class		- 12 Valle 10 Valle
		Туре	:	1 of IRS M.46
		Drying Method	:	1.2mm MIG Wire
	_		:	N.A.
6.2	2	Flux	Т	
	- 1	Class	:	
		Туре	:	N.A 12401/2495
		Drying Method	:	बहायक बनुसद्यान अधिकारी (बाबू
<i>c</i> 2		Chialdina C	$\vdash$	Analstont Descend Officer (M.
6.3	$\rightarrow$	Shielding Gas	:	CO2
7.0	'	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion fac
			:	and adjacent surfaces are cleaned and made free from Crack, Notches, N
	- 1			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	J	Joint design details		Part stretch shown.
	_	(Sketch showing arrangements of parts,	•	Tare sciencia shown.
		weld groove details, weld passes & their		PIP PT 100-10-100
		sequence etc.,)		RIB PL. 190x10x190
	٦	equence etc.,,		
				8
	Sec.			200 Dy. Chief Electric Engal Work S.C. Rly, Lall
2		int preparation	: /	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
	We	elding Current	٠	
		Type :		OC \
	-	Polarity :	: [1	Reverse

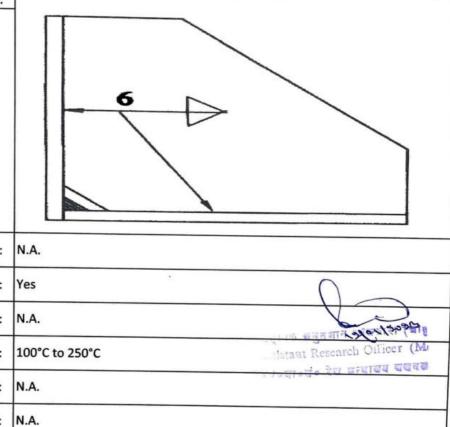
Welding parameters and technique

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 Appendix-V (Ref.Cl.26 of BI-2001)

(AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR UVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

# 10.1 Welding parameters:

	(m/min)	out (mm)	(I/min)
1 1.2 200-220 24-28 2.0-4.0	N.A.	15.20	15.10
2 12 200 220 24 20		15-20	16-18
200-220 24-28 2.0-4.0	N.A.	15-20	16-18



12	Cleaning of weld bead before laying of next weld bead	:	Yes	0
13	Root preparation before welding other side of groove weld	:	N.A.	क्षा वार संदर्शका है
14	Preheating and inter pass temperature	:	100°C to 250°C	ilataut Research Officer (M.
15	Peening	:	N.A.	अंग्रिसिक्यक राम व्यवस्थित व
20				

By re-welding after complete removal of defective weld & rectifying the Rectification of weld defect weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-17 2020

Inspection of weld Visual, D.P. Test. 18 Any other relevant detail

Provision of run-on/run-off tabs

Post weld treatment

11

16

19

Dy. Chief Engines None. Engg. Workshop S.C. Rly, Lallaguda

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 238.00m (CROSSING EXG. TRACK AT KM: 133/8-9. BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR

ame an	nd address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,
elding	Procedure specification No.	_	Toopran Mandal, Medak Dist.
1		:	GSC/22/SRC-45.7M/WPSS/GMAW/14
	Drawing No.	:	RDSO/B-17181/6/R (Details of Lacing)
2	Weld Joint description	:	Fillet 6mm (Lacing flat welding on End Raker)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 20MM)
4	Welding Process	:	GMAW
5	Welding Position	:	2F
6	Welding Consumable		
6.1	Electrode/Wire		
	Class		1 of IRS M.46
į.	Туре	١.	1.2mm MIG Wire
	Drying Method	:	N.A.
2	Drying Method	:	
6.2	Flux		
,	Class	:	000
	Туре	١.	N.A
)	Drying Method		
		ı.	बत्यक बतुसवान अधिकारो <b>(बाह्</b>
6.3	Shielding Gas	:	CO2 Auditin Research Officer (M)
7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion face
)	76 SEC		and adjacent surfaces are cleaned and made free from Crack, Notches, M
			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
1	(Sketch showing arrangements of parts,		
	weld groove details, weld passes & their		<i>p</i> .30
3.	sequence etc.,)		
-			FLAT
2			20X150
7			
7			
0			
2.			
,			
			Todorosa stiller
			Dy. Chief Elily
			Engg. Workshi
			S.C. Rly, Lattern
- 12			LACING FLAT
•			65X10X542
	tion		As per IS 4353 -1905 CL7 IDS D4 - 2655
7.2	Joint preparation	•	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
1.4			
	Wolding Current		1
8	Welding Current Type	:	DC

Welding parameter

OJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

(TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

	1	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
5-	2	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
.*									
10.2	Weldi	ng Sequence an	nd technique	:					
1									. 6
7									$ \sqrt{0}$
1.0								$\varphi$	
7									
-									
								/	
C							∠		
					1			1	
C								7	
2								_	
4	1				_				
11	Provision	of run-on/run-	off tabs	:	N.A.				
- 12	Cleaning	of weld bead be	efore laying of		Vac				
© 12	next weld			:	Yes				
13	The state of the s	paration before	welding other		N.A.			1	).
0	side of gr	roove weld			N.A. 22013095				
14	Preheatir	ng and inter pas	s temperature	:	100°C to 250°	С	7.11	latant Research C	aM) room
15	Peening			:	N.A.		764	व्यावद्यं र रच सन्य	24 4044
15	recining				14.7				
16	Post weld	d treatment		:	N.A.				
					By re-welding	after complete r	emoval of defectiv	e weld & rectifyi	ng the
17	Rectificat	tion of weld def	ect	:			96, using A2 class e		
ľ					2020		98 806	*0:00 E	
18	Inspectio	n of weld		:	Visual, D.P. Te	st.	П	y. Chief Engi	Live
A		- rolovant detai			None.			Engg. Worksh	op
19	Any othe	r relevant detai	CON	•	itolie.			S.C. Rly, Lallar	nid <b>3</b>
0		(CARCE	COM						

### WELDING PROCEDURE SPECIFICATION SHEET "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 238.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR

1	and address of Fabricator		M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
veidin	g Procedure specification No.		: GSC/22/SRC-45.7M/WPSS/GMAW/15
1	Drawing No.	T	: RDSO/B-17181/5/R (Details of Lacing)
2	Weld Joint description	T	: Fillet 6mm (Lacing Angle welding on Top Chord)
) 3	Base Metal		: IS:2062:2011, Gr E250B0 (10MM X 10MM)
4	Welding Process	T	GMAW
5	Welding Position	T	:   2F
6	Welding Consumable	T	
6.1	Electrode/Wire	T	
	Class	L.	1 of IDC NA AC
	Туре	Ľ	1 of IRS M.46
	Drying Method		1.2mm MIG Wire
<u></u>		Ŀ	N.A.
6.2	Flux		
0	Class	:	N.A वर्षक बहुतको ने प्राप्त (बाध
	Туре	:	N.A
7	Drying Method	:	Maditiant Research Officer (M
6.3	Shielding Gas	:	CO2
7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion face
	William Control of the American Art - William Co Control of American Co. )		and adjacent surfaces are cleaned and made free from Crack, Notches, M
	1	:	Scale, Grease Paint, Rust etc., which may affected Weld.
			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
	(Sketch showing arrangements of parts,		
)	weld groove details, weld passes & their		56.5 6 FLAT 10x150
	sequence etc.,)		100.130
1			
.	1		
			5 Z
- 1			75×50×8-10
			//// 75*50× <del>2-10</del> \\\
- 1			
1			272.5 272.5
			Dy China wash
200			Dy. Chief Entitles
			Engg. Workshop
.2 1	oint preparation	٠	As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3& WBC -2001
	Welding Current		
8 V	Velding Current Type	:	DC

Welder Qualification

10

Welding parameters and reconique

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 Appendix-V (Ref.CI.26 of BI-2001) TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR VISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

10.1 Welding	parameters :
--------------	--------------

Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	1.2	200-220	24-28	2.0-4.0	N. A		TO STATE OF THE ST
2	1.2	200-220			N.A.	15-20	16-18
		200-220	24-28	2.0-4.0	N.A.	15-20	16-18

Sequence N	(mm)	(Amps)	Arc \	Voltage (Volt)	Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
2	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
,	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
10.2 W	elding Sequence a	nd technique	:					<u>_</u> 6
Clea	ision of run-on/run ning of weld bead b weld bead		:	N.A. Yes			$\stackrel{'}{\Longrightarrow}$	_
Root	preparation before of groove weld	e welding other	:	N.A.			1stallows	>
14 Preh	eating and inter pa	ss temperature	:	100°C to 250°	,c	4.7(4.4)	At Research Office	) । व्याप
15 Peer	ning		:	N.A.			∍त्र रेज स <del>म्बद्धिय</del>	
16 Post	weld treatment		:	N.A.				
17 Rect	ification of weld de	efect	:	By re-welding weld as per C 2020	g after complet 1.32.2 of IS 959	e removal of defe	ctive weld & recti ss electrode as pe	fying the r IRS M28-
18 Insp	ection of weld		:	Visual, D.P. To	est.		Toppoon	
- 19 Any	other relevant deta	ail	:	None.		1	Dy. Chief Engi	Hee

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: ±138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-45.7M/WPSS/GMAW/16 Drawing No. : RDSO/B-17181/4/R & B-17184/5/R, Section A-A & B-B 2 Weld Joint description : |Fillet 6mm (Batten Plate welding on Bottom Chord & Top Chord) 3 **Base Metal** IS:2062:2011, Gr E250B0 (10MM X 10MM / 10MM X 20MM)) **Welding Process** : GMAW 5 Welding Position : 2F Welding Consumable 6.1 Electrode/Wire Class 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. 6.2 Flux Class : Type N.A : दद्यायक बनुसद्यान आह्यकारा (बाह् **Drying Method** Assistant Research Officer (M. 6.3 **Shielding Gas** : CO2 व व च व मा व है जे देश के मा व य व व व व व 7.0 Material to be cut straight & square by controlled gas cutting. Fusion faces Base metal preparation and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. 7.1 Joint design details : Part stretch shown. (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,) Dy. Chief Enginee Engg. Workshop S.C. Rly, Lallaguda 6/ BATTENS 10 THICK As per IS 4353 -1995, Cl.7, IRS B1 - 2001, Cl. 17.3& WBC - 2001 Joint preparation 7.2 Welding Current 8 Type DC Polarity Reverse per 15-7310 (Part-1) [4817 Srinivas Rao Welder Qualification 9 Welding parameter sand technique

प्र महाप्रवंधक(सि)/Sr Dy General Manager(C)

Appendix-V (Ref.CI.26 of BI-2001)

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR OIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

Sequence No	. (mm)	(Amps)	Arc	voitage (voit)	(m/min)	(m/min)	out (mm)	(I/min
1	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
10.2 We	lding Sequence ar	nd technique	:	_				6
Cleanin	ion of run-on/run- ng of weld bead be reld bead		:	N.A. Yes			0	
Root p	reparation before groove weld	welding other	:	N.A.			hate.	प्राष्ट्र
14 Prehea	ating and inter pas	s temperature	:	100°C to 250°C			stant Research Or	licer (Mi
15 Peenin	g		:	N.A.		व्यव	aliana da deste	
	Post weld treatment			N.A.				
16 Post w	eld treatment		:					
	eld treatment	ect		By re-welding a			ctive weld & rectif is electrode as per	
17 Rectific		ect	:	By re-welding a weld as per Cl.	32.2 of IS 9595-	96, using A2 clas		

### "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

"251 LUADING-2006 45.7 IVI SPAIN OF EN VVLD GINDLING TO STATION AT KM 137/970 PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:

138.000	n (CROSSING EXG. TRACK AT KM: 133/8-9, BETW ) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GII	EEN	POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR R.
lame ar	nd address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Velding	Procedure specification No.	-	GSC/22/SRC-45.7M/WPSS/GMAW/17
1	Drawing No.	:	RDSO/B-17181/4/R & B-17184/5/R, Section A-A & B-B
2	Weld Joint description	÷	Fillet 6mm (Diaphragm Plate welding on Bottom Chord & Top Chord)
3	Base Metal	•	IS:2062:2011, Gr E250B0 (10MM X 20MM / 10MM X 16MM)
4	Welding Process	÷	GMAW
5	Welding Position	÷	2F
6	Welding Consumable	·	
6.1	Electrode/Wire		
	Class		1 of IRC M AC
	Туре	:	1 of IRS M.46
_	Drying Method		1.2mm MIG Wire
		:	N.A.
6.2	Flux		
~	Class	188	N.A वशुसक बबुसवान अधिकारो (बाह
	Туре	100	N.A वशुरक बनुसकान अधिकारा (बाह
	Drying Method	:	Assistant Research Officer (Mo
6.3	Shielding Gas	:	CO2
7.0	Base metal preparation	·	
	proparation		Material to be cut straight & square by controlled gas cutting. Fusion faces
		:	and adjacent surfaces are cleaned and made free from Crack, Notches, Mil
<u> </u>			Scale, Grease Paint, Rust etc., which may affected Weld.
7.1	Joint design details	:	Part stretch shown.
7	(Sketch showing arrangements of parts,		
	weld groove details, weld passes & their		(DIADUDAC)
192	sequence etc.,)		DIAPHRAGM
-			\\\\WEB\\PL.\\450x10x564
D-			
			· VIII
3			
			6 1 8
			l Vg
			И
<b>3</b>			l A
			H B _
55			Teacher Hill
			Dy. Chief English
7			Engg. Workshop
			S.C. Rly, Lallaguda
9			
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3& WBC - 2001
8	Welding Current		
0	Туре	:	DC
	Polarity	:	Reverse > S
	Welder Qualification 2	N	Asper IS 7310 (Part-I) -817 ivas Rao Executive Engineer/Ci
9	Weider and technique	P	Transfer (1) a B a control Rao LACCULAR Engineer/CI

10

Welding parameters and technique

Appendix-V (Ref.CI.26 of BI-2001)

AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR VISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
2 1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

10	.2 Welding Sequence and technique	:	
			46
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A প্ৰবাহণ হৈ মন্যাম্ম ভ্যান্ত
16	Post weld treatment	:	N.A.
) <sup>17</sup>	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020
18	Inspection of weld	:	Visual, D.P. Test.
19	Any other relevant detail	:	None. Dy. Chief Engineer
			Engg. Workshop

### "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:

Name and address of Fabricator			M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village,
Veldin	g Procedure specification No.		Toopran Mandal, Medak Dist.
1	Drawing No.	:	GSC/22/SRC-45.7M/WPSS/GMAW/18
2	Weld Joint description	:	RDSO/B-17181/13 (Sectional Plan)
3	Base Metal	:	Fillet 8mm (Pad Plate Welding to End Cross Girder)
4		:	IS:2062:2011, Gr E250B0 (12MM X 25MM)
5	Welding Process	:	GMAW
6	Welding Position	:	2F
6.1	Welding Consumable		
0.1	Electrode/Wire		
	Class	:	1 of IRS M.46
6	Туре	:	1.2mm MIG Wire
	Drying Method	:	N.A.
6.2	Flux		Speriary
	Class	:	तपुरसम्बद्धाः अप्रतास्य अर्थाहरू । (मा)
	Туре		N.A Amintant Research Officer (M
n	Drying Method		ত এতবাত্যত বৈষ্ণ কৰেছিল অভিনৱ
	arying memor	•	
6.3	Shielding Gas	:	CO2
7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion face
			and adjacent surfaces are cleaned and made free from Crack, Notches, M
		•	Scale, Grease Paint, Rust etc., which may affected Weld.
<u> </u>	Laint design details		
7.1	Joint design details	:	Part stretch shown.
)	(Sketch showing arrangements of parts,		
	local diameters and details could be a second of the could		PAID PI 305V13V430
	weld groove details, weld passes & their		PAD PL. 305X12X430
3	weld groove details, weld passes & their sequence etc.,)		PAD PL. 305X12X430  25mm Thick
9			Support attended
3			Section 2
9			Support attended
9			Section 2
			25mm Thick
			Section 2
			25mm Thick
			Dy. Chief
			Dy. Chief Wa
			Dy. Chief
			Dy. Chief W
	sequence etc.,)		Dy. Chief Works.C. Rly, Lal
7.2	Joint preparation	:	Dy. Chief W
7.2	Joint preparation Welding Current		Dy. Chief W. Errigg. Works.C. Rly, Lal
8	Joint preparation  Welding Current  Type	:	25mm Thick  Dy. Chief W. Erigg. World S.C. Rly, Lal  As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Joint preparation  Welding Current  Type	:	25mm Thick  Dy. Chief Works.C. Rly, Lal  As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001  DC  Reverse
	Joint preparation  Welding Current  Type	:	Dy. Chief W. Erigg. World S.C. Rly, Lal S.C. Rly, Lal DC

Engg. Workshop

S.C. Rly, Lalles

Appendix-V (Ref.Cl.26 of BI-2001) OJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR VISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. 10.1 Welding parameters: Electrodes Wire Feed Welding Gas Flow Travel Speed **Electrical Stick** Current wire dia. Arc Voltage (Volt) Speed Sequence No. (I/min) (m/min) out (mm) (Amps) (mm) (m/min) 1 15-20 16-18 N.A. 24-28 2.0-4.0 1.2 200-220 2 15-20 16-18 N.A. 24-28 2.0-4.0 1.2 200-220 10.2 Welding Sequence and technique Provision of run-on/run-off tabs N.A. 11 Cleaning of weld bead before laying of della Peserch Officer (M Yes 12 next weld bead Root preparation before welding other ्यन्यारवर्षः देख सन्धास्य स्त्यन्त N.A. 13 side of groove weld 100°C to 250°C Preheating and inter pass temperature 14 N.A. Peening 15 N.A. Post weld treatment 16 By re-welding after complete removal of defective weld & rectifying the Rectification of weld defect weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-17 2020 Visual, D.P. Test. Inspection of weld Dy. Chief Engineer 18 Any other relevant detail None.

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970

0	m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWIN) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIR	OEF	A				
Vame a	and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village,				
Velding	g Procedure specification No.		Toopran Mandal, Medak Dist.				
0 1	Drawing No.	<u>:</u>	GSC/22/SRC-45.7M/WPSS/GMAW/19				
2	Weld Joint description	:	RDSO/B-17181/13				
3	Base Metal	:	Fillet 10mm (End Plate welding to Cross Girders)				
4	Welding Process	:	IS:2062:2011, Gr E250B0 (16MM X 20MM)				
5		:	GMAW				
6	Welding Consumable	:	2F				
6.1	Welding Consumable						
0.1	Electrode/Wire	(					
	Class	:	1 of IRS M.46				
	Туре		1.2mm MIG Wire				
	Drying Method	:	N.A.				
6.2	Flux	$\vdash$					
	Class	·	Control of the state of the sta				
	Type	1	N.A अशायक व्यवस्थान विश्वकारी (बाह				
	Drying Method		and the state of t				
0	Drying Wethou		ार्थावार रिकारिय संस्थाति संस्थाति ।				
6.3	Shielding Gas	:	CO2				
7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion faces				
			and adjacent surfaces are cleaned and made free from Crack, Notches, Mil				
	T j	:	Scale, Grease Paint, Rust etc., which may affected Weld.				
<u> </u>			The control and the control an				
7.1	Joint design details	:	Part stretch shown.				
	(Sketch showing arrangements of parts,		450				
	weld groove details, weld passes & their	(					
2	sequence etc.,)		82				
	1	1					
$\cap$	1		20mm Thick				
	1		Web				
$\cap$	1						
9	1 ,						
7	1		END PLATE				
	1 )		16X400X975				
-	1 ,						
)	1 ,						
	1		10 TYP.				
)	I						
			Dy. Chief Engineer				
1			Dy. Chief Engineer Engg. Workshop				
			450 S.C. Rly, Lallaguda				
2	A STATE OF THE STA	$\vdash$					
- 2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3& WBC - 2001				
7.2		-					
	- LU Current						

**Welding Current** 

DC

Type Polarity Reverse

8

per IS 7310 (Part-I) Welder Qualification Curvey 9 Welding parameter and technique

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR CiVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

10.2	Welding Sequence and technique	:	
			10 10 10
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes 131-1/309D (11)
.3	Root preparation before welding other side of groove weld	:	N A
.4	Preheating and inter pass temperature	:	100°C to 250°C
.5	Peening	:	N.A.
6	Post weld treatment	:	N.A.
7	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020
8	Inspection of weld	:	Visual, D.P. Test.
9	Any other relevant detail	:	None.  Dy. Chief Engineer  Engg. Workshop

"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 2x38.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

DIVISION	n (CROSSING EXG. TRACK AT KM: 133/8-9, BETWI ) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIR	FFN	KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR				
Name and address of Fabricator			M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village,				
		•	Toopran Mandal, Medak Dist.				
Welding	Procedure specification No.	:	GSC/22/SRC-45.7M/WPSS/GMAW/20				
01	Drawing No.		RDSO/B-17181/13 (Detail "Y")				
2	Weld Joint description	÷	Single Bewel Welding of End Plate with Cross Girder & Fillet 12mm				
<b>7</b> 3	Base Metal	÷	IS:2062:2011, Gr E250B0 (16MM X 25MM)				
. 4	Welding Process	•	GMAW				
<b>5</b>	Welding Position	÷	2F				
. 6	Welding Consumable	·					
6.1	Electrode/Wire						
	Class						
	Туре	:	1 of IRS M.46				
	Drying Method	•	1.2mm MIG Wire				
0	8	:	N.A.				
6.2	Flux						
0	Class	:	N.A STATE Research Officer (Mi				
	Туре	:	N.A				
0	Drying Method	:	N.A AND THE STATE OF THE STATE				
6.3	Shielding Gas	:					
7.0	Base metal preparation		Material to be cut straight & square by controlled gas cutting. Fusion face				
0		:	and adjacent surfaces are cleaned and made free from Crack, Notches, Mi				
		88	Scale, Grease Paint, Rust etc., which may affected Weld.				
O <sub>7.1</sub>	Joint design details	:	Part stretch shown.				
7.1	(Sketch showing arrangements of parts,		Part Stretch snown.				
0	weld groove details, weld passes & their		r <sub>O</sub>				
			1				
0	sequence etc.,)		1 11-5				
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0-			5N FILLED UP				
0-			WELD MATRIAL				
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100		l					
	r -						
			DV Chief T WW				
			Dy. Chief Engine				
9			Engg. Workshop				
			S.C. Rly, Lallaguda				
01	1000 M						
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3& WBC - 2001				
1.2	The state of the s	1					
8	Welding Current		DC 0				
1	Type Type		Reverse 1.53				
		_	off the contract of the contra				
9		14	Mark 15 7310 (Part-I) - 817 rinivas Rao Executive Enginee				
	Welding parameters and technique	1:	अभिनाप्रविधक (सि)/Sr.Dy.General Manager(C) Construction Division				
10	Weiding		THE CONTRACT OF THE PROPERTY O				

Appendix-V (Ref.Cl.26 of BI-2001)

OJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR VISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

meters:

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
ć 1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
5 2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

7		(mm)	(Amps)			(m/min)	(m/min)	out (mm)	(I/min)
	1	1.2	200-220	$\top$	24-28	2.0-4.0	N.A.	15-20	16-18
-	2	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18
5 10.	.2 Weldir	ng Sequence ar	nd technique	:	1, 2	1		<b>\</b>	
)								$\cap$	
_	Cleaning of	f run-on/run-o weld bead bef		:	N.A.	V	and the second	13 Common Office	CI
12	Cleaning of next weld b Root prepar	weld bead bef ead ration before v	ore laying of	:	N.A. Yes N.A.	V	6.98 <sup>1</sup> .20	Selection of the select	CI
12	Cleaning of next weld b Root prepar side of groo	weld bead bef ead ration before v	ore laying of velding other	: :	Yes	V	A. 201 3.0	113. OHI	CI
12 13 .4	Cleaning of next weld b Root prepai side of groo Preheating a Peening	weld bead bef lead ration before v lye weld and inter pass	ore laying of velding other	:	Yes N.A.		A. 11/10	113. OHI	CI
12	Cleaning of next weld b Root prepar side of groo Preheating a	weld bead bef lead ration before v lye weld and inter pass	ore laying of velding other	: :	Yes  N.A.  100°C to 250°C  N.A.  N.A.			Total and Academical College	Marin
112 113 144 55 66	Cleaning of next weld be Root preparation of groot preheating at Peening  Post weld tree Rectification	weld bead before we weld and inter pass eatment	velding other	: :	Yes  N.A.  100°C to 250°C  N.A.  N.A.  By re-welding a weld as per Cl. 2020	after complete r 32.2 of IS 9595-9	emoval of defect	113. OHI	3 25211 11
14 .5 6 7 F	Cleaning of next weld b Root prepar side of groo Preheating a Peening	weld bead before we weld and inter pass eatment of weld defectively	velding other	: :	Yes  N.A.  100°C to 250°C  N.A.  N.A.  By re-welding a weld as per Cl.	after complete r 32.2 of IS 9595-9	emoval of defect 96, using A2 class	tive weld & rockie	ying the r IRS M28-

## "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 KEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:  $\Omega$ 38.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER. Name and address of Fabricator M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist. Welding Procedure specification No. GSC/22/SRC-45.7M/WPSS/GMAW/21 Drawing No. RDSO/B-17181/13 (Detail "X") 2 Weld Joint description Single Bewel Welding & Fillet 12mm of Bracket **(**)3 **Base Metal** IS:2062:2011, Gr E250B0 (10MM X 10MM) **Welding Process** 4 : GMAW **(**) 5 **Welding Position** 2F 6 Welding Consumable 6.1 Electrode/Wire Class 1 of IRS M.46 Type 1.2mm MIG Wire **Drying Method** N.A. 6.2 Flux Class ्यायम सनुसंसान असिन Andstant Research Officer (M. Type N.A Drying Method यो० रेख जन्दाच्य ब्रह्मक् **Shielding Gas** CO<sub>2</sub> : Base metal preparation Material to be cut straight & square by controlled gas cutting. Fusion faces and adjacent surfaces are cleaned and made free from Crack, Notches, Mill Scale, Grease Paint, Rust etc., which may affected Weld. Joint design details : Part stretch shown. (Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,) TAPPERED PL. 210x10x250 TO 200 AT TOP Dy. Chief End Engg. Workshap S.C. Rly, Lallan 13 FILLED UP WELD MATRIAL PL. 200x10x250 As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3& WBC - 2001 Joint preparation 7.2 **Welding Current** 8 DC Type Polarity

7310 (Part-I) - 817

Welder Qualification

9

Welding parameters and technique

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 Appendix-V (Ref.Cl.26 of BI-2001 AKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR VISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.

Welding Sequence No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)
1	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18
2	1.2	200-220	24-28	2.0-4.0	N.A.	15-20	16-18

		1	(mm)		_		(m/min)	(,)	out (iiiii)	(1/111111)			
1			1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18			
-	1	2	1.2	200-220		24-28	2.0-4.0	N.A.	15-20	16-18			
F	- 10	al .						(00.007/77)					
-	10.2 Welding Sequence and technique :												
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0						of 10							
I	11	Provision o	of run-on/run-of	ff tabs	:	N.A.			Seather 15	(बाह्			
0	79000	Cleaning of weld bead before laying of					1 14th B	Pagano Office	· (M				
	next weld bead			:	Yes Andreat Research Officer (Ma								
10			Root preparation before welding other			Yes							
T	13	side of groo		ouiei	:	N.A.	2						
0													
T	Preheating and inter pass temperature :  Peening :			:	100°C to 250°C								
0-													
				:	N.A.								
-	estile)												
	16	Post weld tr	reatment	1	:	N.A.				7			
-		100000000000000000000000000000000000000					oft or						
-		Rectification of weld defect				By re-welding after complete removal of defective weld & rectifying the weld as per Cl.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-							
. 1	17	Rectification	n of weld defec		.	weid as per Ci	.32.2 of IS 9595-9	6, using A2 class e	electrode as per I	RS M28-			
					_	2020							
	_	Inspection o	of weld		:	Visual, D.P. Te	st.	Tess	2				
1	.8	Inspection o				,		Teses	of Engine				
-	-+		levant detail		:	None.		by. Gni	Markahan				
0 1	9	Any other re	elevant detail Co	100	ಿ			Engg.	Workshop y, Lallaguda	1			
_			12/ WE	N/5/				9:0: KI	y, canaguda				

## "25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (FAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH:

	and the state of t	RDER.	CONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR
Jame :	and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village,
Yeldin	g Procedure specification No.		Toopran Mandal, Medak Dist.
1		+:	GSC/22/SRC-45.7M/WPSS/MMAW/22
2	Drawing No.	+:	RDSO/B-17181/R
	Weld Joint description	:	Tack Weld (5mm)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
4	Welding Process	:	MMAW
5	Welding Position	;	1F/2F
6	Welding Consumable	$\top$	
6.1	Electrode/Wire		
2	Class		A2 of IRS M28-2012
	Туре	:	Medium Coated.
	Drying Method	:	As recommended by the Electrode Manufacturer.
6.2	Flux		
	Class Type Drying Method	:	N.A squas squas control (signal squas control (signal squas control (signal squas control cont
6.3	Shielding Gas	:	N.A
7.0	Base metal preparation	:	Fusion faces and adjacent surfaces are cleaned and made free from cracks, notches, mill scale, grease, paint, rust etc., which may affect wel quality.
7.1	Joint design details	:	
	(weld beads details, weld passes & their sequence etc.,)		Length of tack Weld 50mm Gap between two tack Weld appr.300mm
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8.0	Welding Current		
	Туре	:	DC Passage Engine
	Polarity	:	Reverse Engg. Workshop S.C. Rly, Lallagud:
9.0	Welder Qualification	:	As per IS 7310 (Part-I) – 1974
10.0	Welding parameters and technique	:	

1	,										
0											
0	)							Δ	ppendix-V (Ref.Cl	Page-44 .26 of BI-2001)	
	PROJEC	T: PROPOSE	ED RAILWAY SIDIN	IG TAKING OFF F	ROM	CH:2027m OF J	NPD END OF VISH	NUPURAM RAILW	AY STATION AT KM	1 137/970	
'	(TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR										
0	DIVISION) OF SPAN (1X30.5m + 2 X 45.7m) OPEN WEB GIRDER.										
	10.1 Welding parameters :										
000	Welding Sequence No.		Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)		Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (I/min)	
0		1	4	180-210	24-27		N.A.	N.A.	N.A.	N.A.	
0											
0	10.2 Welding Sequence and technique										
9											
0	11.0	11.0 Provision of run-on/run-off tabs				N.A.					
0	12.0 Cleaning of weld bead before laying of next weld bead			:	N.A.						
0	Root preparation before welding other side of groove weld			:	N.A.						
0	14.0					N.A.					
0	15.0	15.0 Peening				N.A. Applicat Research Officer (No. 2) Applicat Research Officer (No. 2) Applicat Gold Gold Gold Gold Gold Gold Gold Gold					
9	16.0	16.0 Post weld treatment			:	N.A.					
	17.0 Rectification of weld defect				:	By re-welding after complete removal of defective weld.					
9	18.0 Inspection of weld				:	Visual, D.P. Test.					
	19.0 Any other relevant detail				:	None.			Chief Facin	W.	