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)

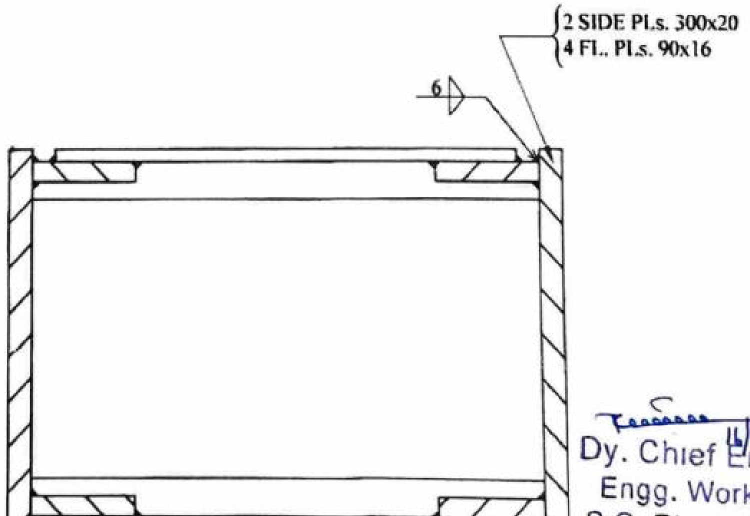
Railway Open Web Girder (25t loading)
30.5m clear span
MODEL WPSS No- RDSO/ Infra-II/ B&S/ RG/ OWG./ WPSS / 30.5 series (22 nos)

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

WELDING PROCEDURE SPECIFICATION SHEET

"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.

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/SAW/01
1	Drawing No.	:	RDSO/B-17165/R, Section A-A & RDSO/B-17161(Section L0-L1-L2)
2	Weld Joint description	:	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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	N.A
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique		

Dy. Chief Engineer, Engg. Workshop, S.C. Rly, Lallaguda

जे. श्रीनिवास राव/J. Srinivas Rao

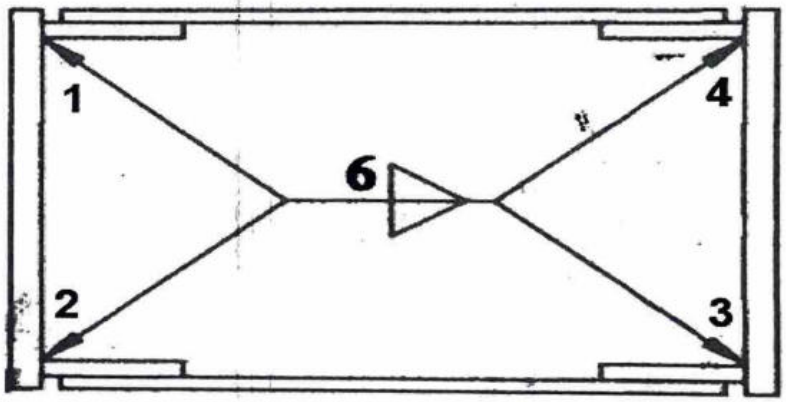
Appendix-V (Ref.Cl.26 of BI-2001

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT M 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 + 2X45.7m) 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 (l/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



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
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.
19	Any other relevant detail	:	None

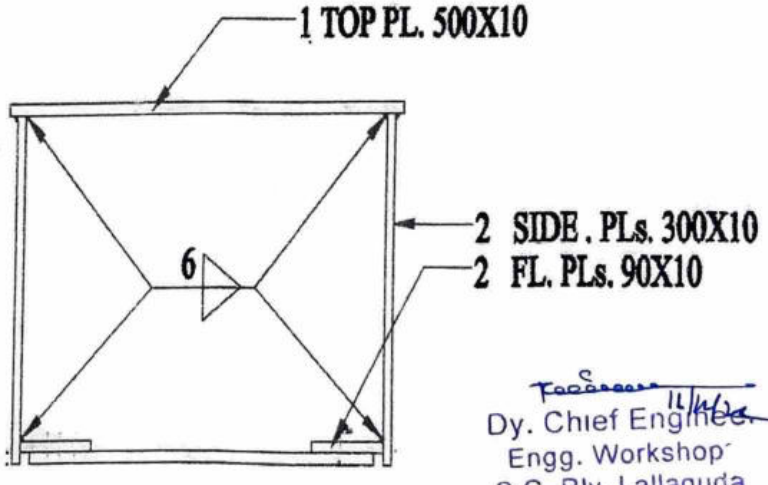
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/SAW/02
1	Drawing No.	:	RDSO/B-17166/R, Section A-A
2	Weld Joint description	:	Fillet 6mm (Top Chord)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MMX10MM)
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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	N.A
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer/Civil

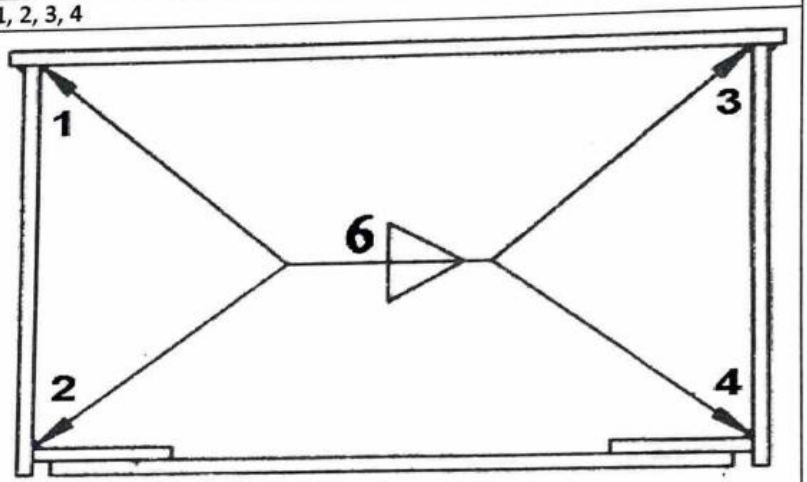
Appendix-V (Ref.Cl.26 of BI-2001

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 :

Weld Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

12/01/2022

Assistant Research Officer (Mt

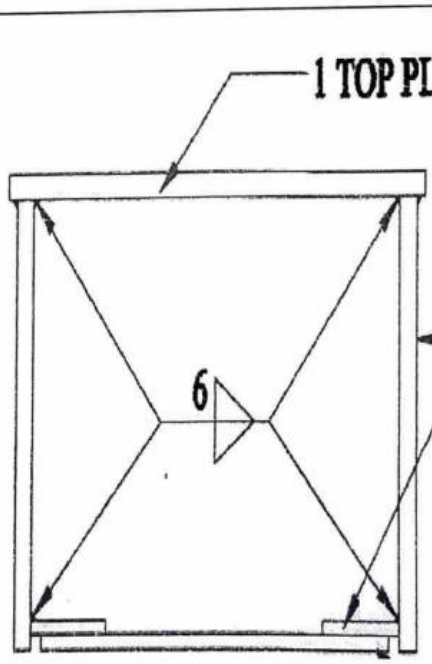
Dy. Chief Engineer
Engg. Workshop

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

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 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 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/SAW/03
1	Drawing No.	:	RDSO/B-17167/R, Section B-B
2	Weld Joint description	:	Fillet 6 mm (End Raker)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (20MM X 10 MM), (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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	NA
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part I) – 1974
10	Welding parameters and technique		

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

J. Srinivas Rao
Sr.Dy.General Manager(C)

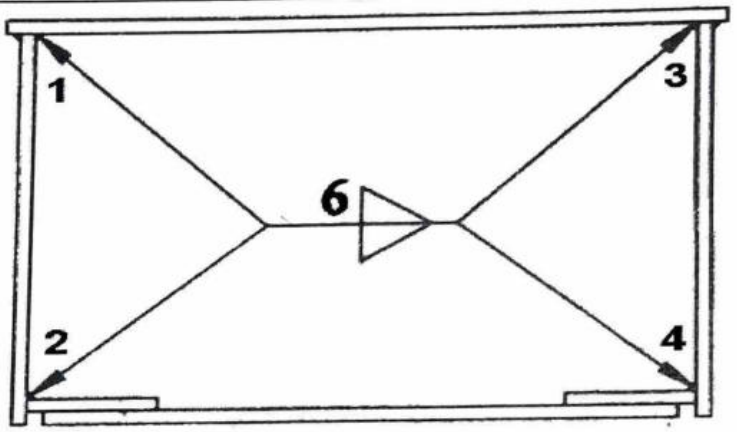
Executive Engineer(C)
Construction Division-II(C)

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. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

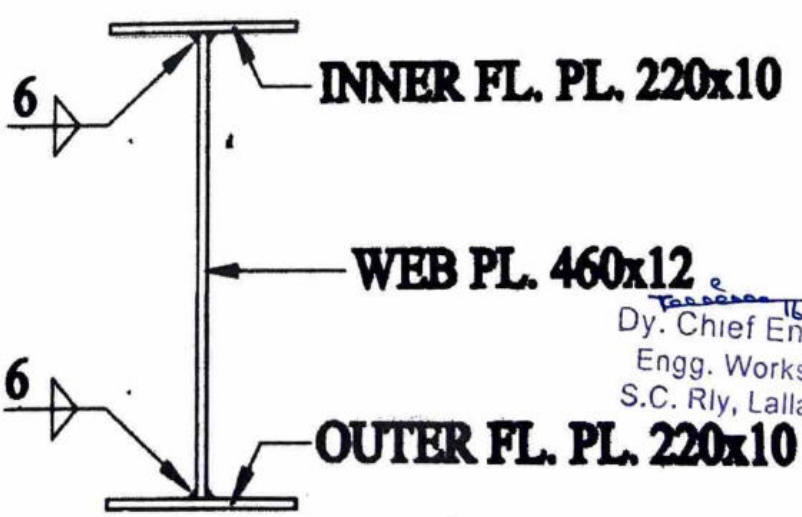
16/4/22
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/SAW/04
1	Drawing No.	:	RDSO/B-11768, Section & RDSO/B-17161(Section of Verticals)
2	Weld Joint description	:	Fillet 6mm (Verticals)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 12MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

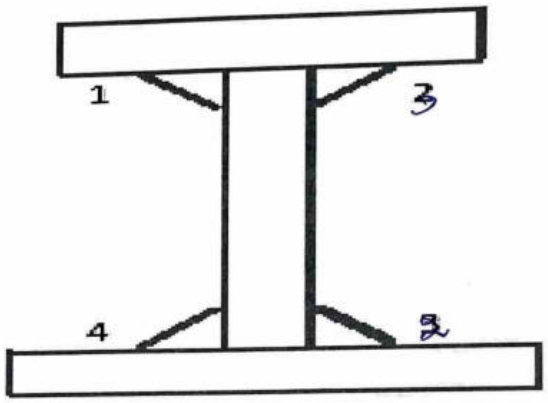
pendix-V (Ref.Cl.26 of BI-2001)

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 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 :

Weld Pass No	Electrodes wire dia. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



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.

12/04/2022

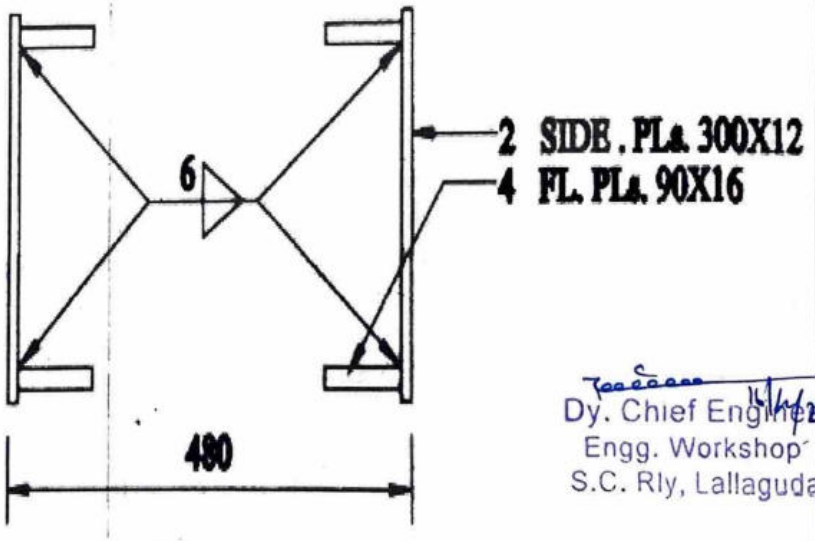
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.

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/SAW/05
1	Drawing No.	:	RDSO/B-17169/R & RDSO/B-17161 (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.
	Type	:	Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

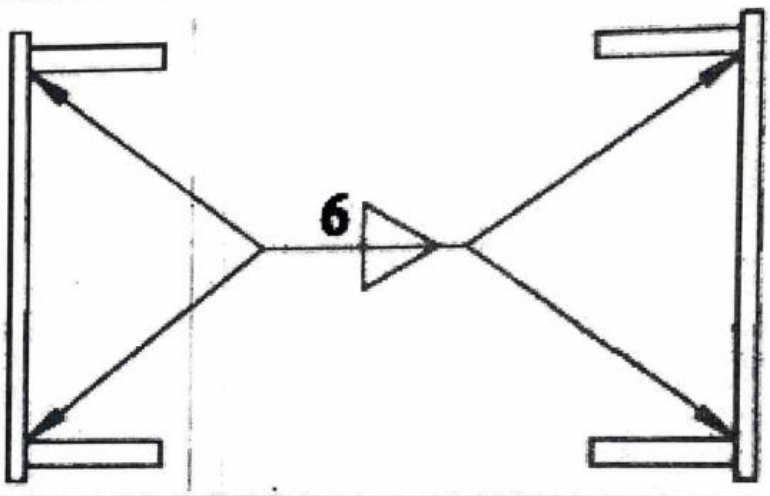
Executive Engineer/Civil
Construction Division-I/CC-II
5x800 MW, YTPS, Veerlapalem (V)

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 (l/min)
1	4	450-550	28-32	0.45.0.55	25 - 28	N.A.

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.

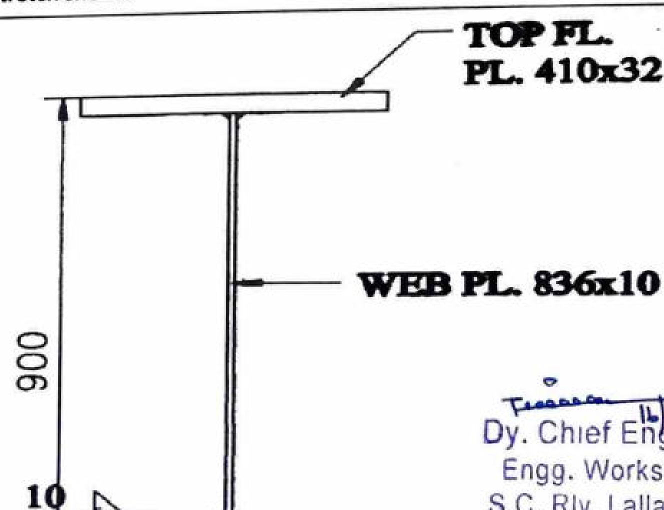
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.

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/SAW/06
1	Drawing No.	:	RDSO/B-17172 & RDSO/B-17161(Cross Girder)
2	Weld Joint description	:	Fillet 10mm (Cross Girder)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 32MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) - 817
10	Welding parameters and technique		

Assistant Research Officer

Dy. Chief Engineer.
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer/Civil
Construction Division I/CC-II
J. Srinivas Rao 5X800 MW, YTPS, Veerlapalem (V)
Dameracherla (M), Nalgonda (D)-508 355

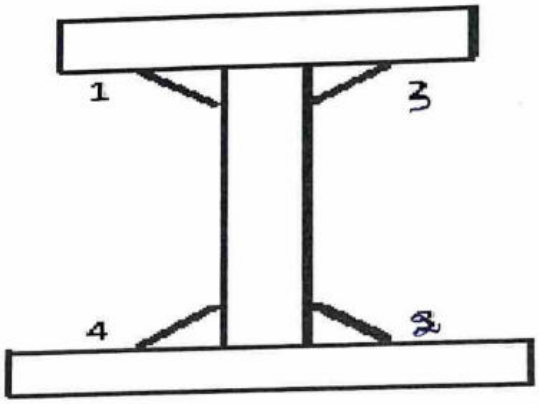
Appendix-V (Ref.Cl.26 of BI-2001)

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 :

Weld Pass No	Electrodes wire dia. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



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.

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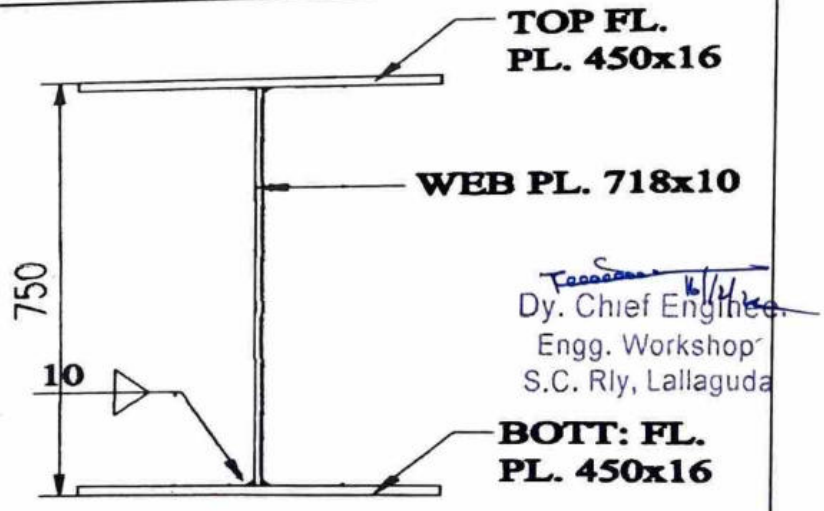
Appendix-V (Ref.Cl.26 of BI-2001)

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.

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/SAW/07
1	Drawing No.	:	RDSO/B-17173 (Section B-B) & RDSO/B-17161(Stringer)
2	Weld Joint description	:	Fillet 10mm (Stringer)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 16MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	Drying Method	:	250 C for one hour before use 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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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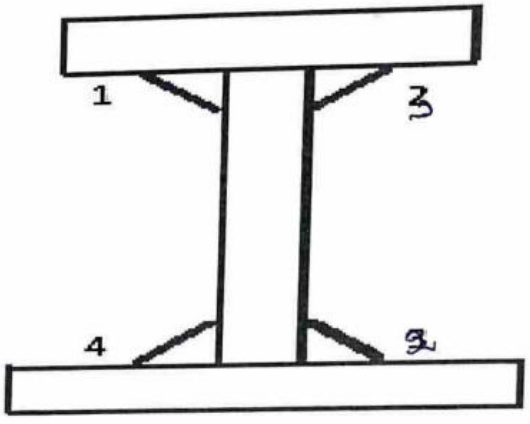
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



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.

13/04/2022

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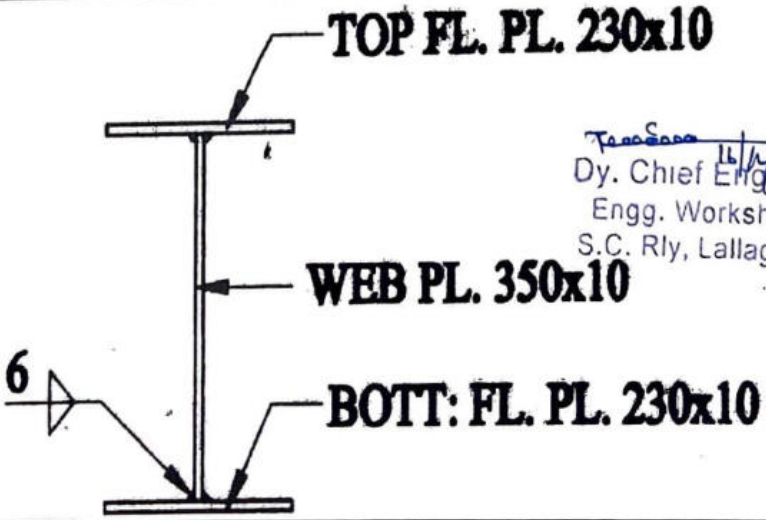
WELDING PROCEDURE SPECIFICATION SHEET

"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.

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/SAW/08
1	Drawing No.	:	RDSO/B-17167/R & RDSO/B-17161(Portal Girder U_1-U^1_1)
2	Weld Joint description	:	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		
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
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

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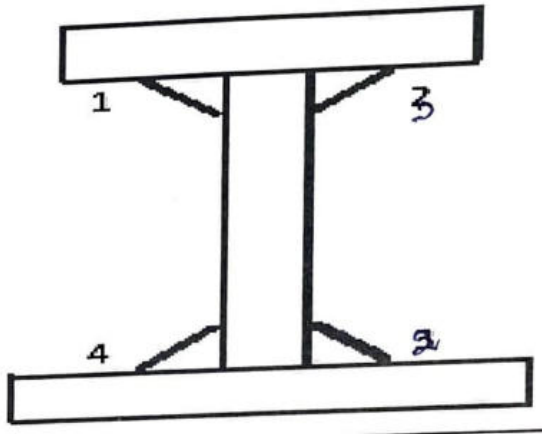
ROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE O. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL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

10.1 Welding parameters :

Weld Pass No	Electrodes wire dia. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



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.

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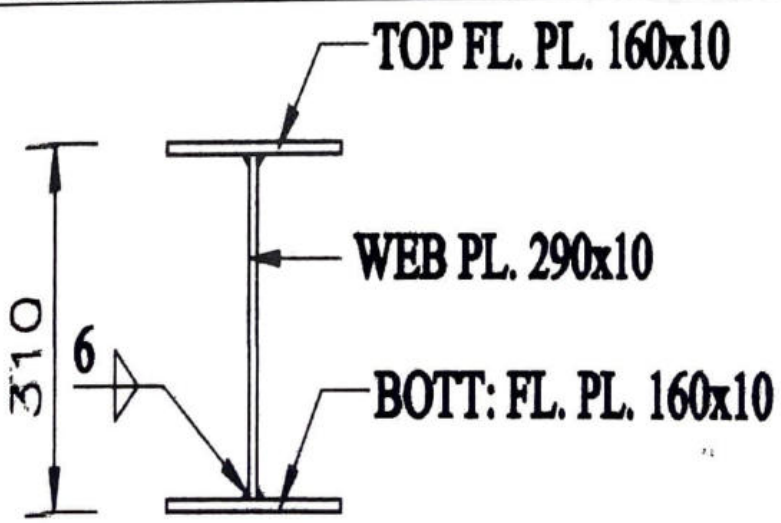
WELDING PROCEDURE SPECIFICATION SHEET

"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.

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/SAW/09
1	Drawing No.	:	RDSO/B-17174 & RDSO/B-17161(Sway Girder (U_2-U^1_2, U_3-U^1_3))
2	Weld Joint description	:	Fillet 6mm (Sway Girder)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
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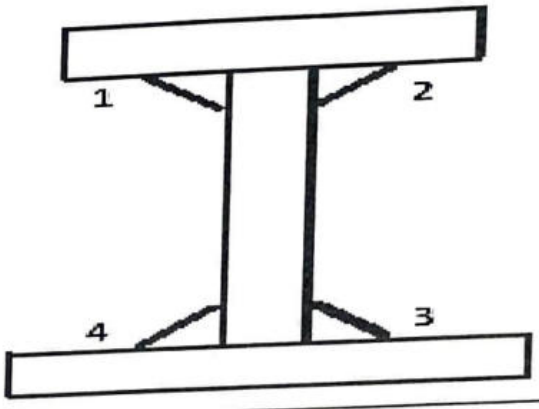
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



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.

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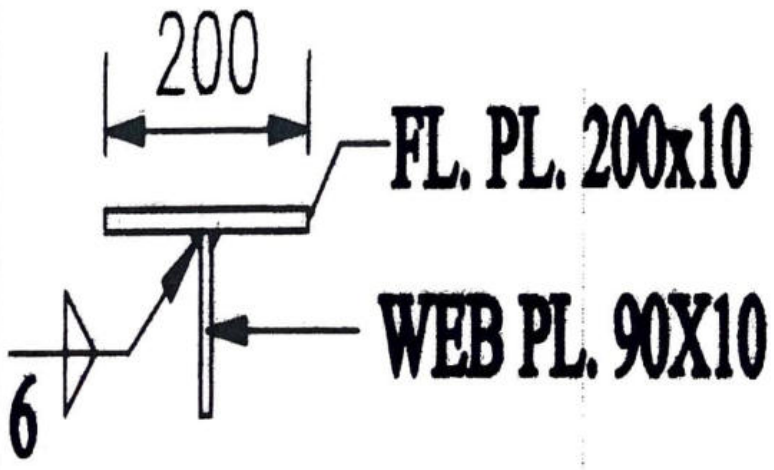
WELDING PROCEDURE SPECIFICATION SHEET

"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.

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/SAW/10
1	Drawing No.	:	RDSO/B-17176(Section) & RDSO /B-17161 (Top Laterla Bracing)
2	Weld Joint description	:	Fillet 6mm (Top Lateral Bracings)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
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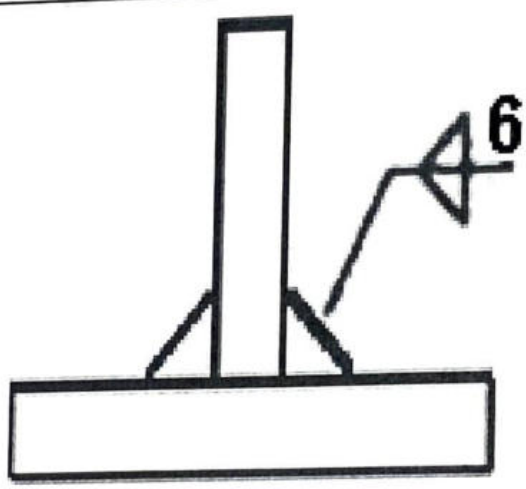
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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 (l/min)
1	4	450-550	28-32	0.45.0.55	25 - 30	N.A.

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.

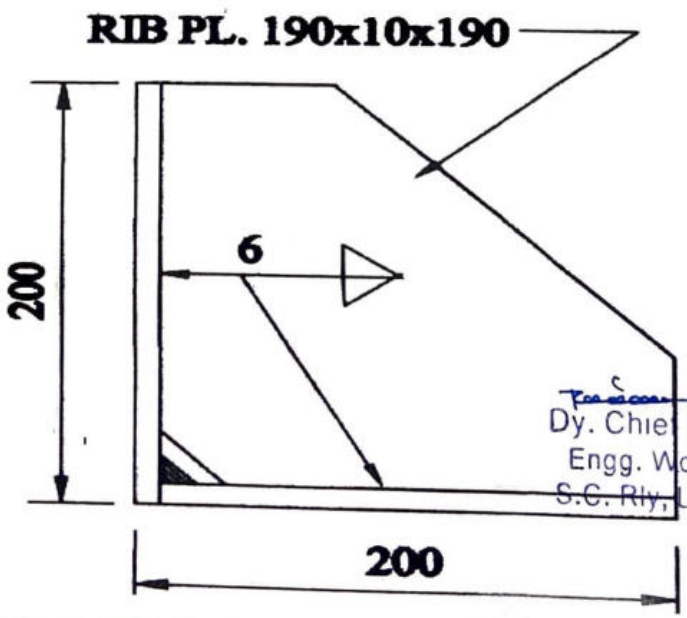
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/11
1	Drawing No.	:	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	:	1 of IRS M.46
	Type	:	1.2mm MIG Wire
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	
	Type	:	N.A
	Drying Method	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

12/01/2015

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

GLOBAL STEEL COMPANY Survey No. 12. KUCHARAM

Executive Engineer Civil
Construction Division I/C

जे. श्रीनिवास राव/J. Srinivas Rao

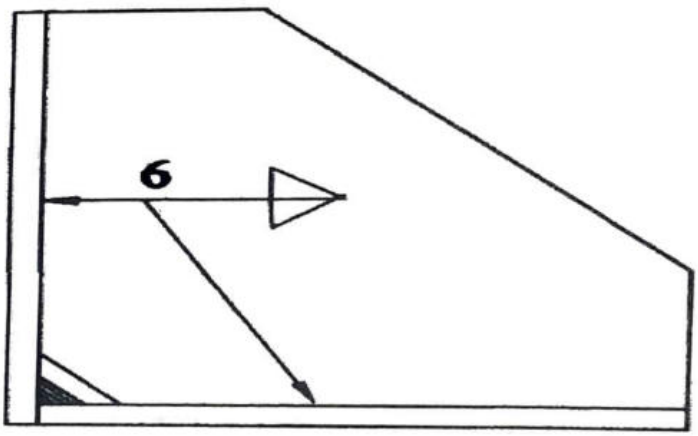
Appendix-V (Ref.Cl.26 of BI-2001)

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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	:	



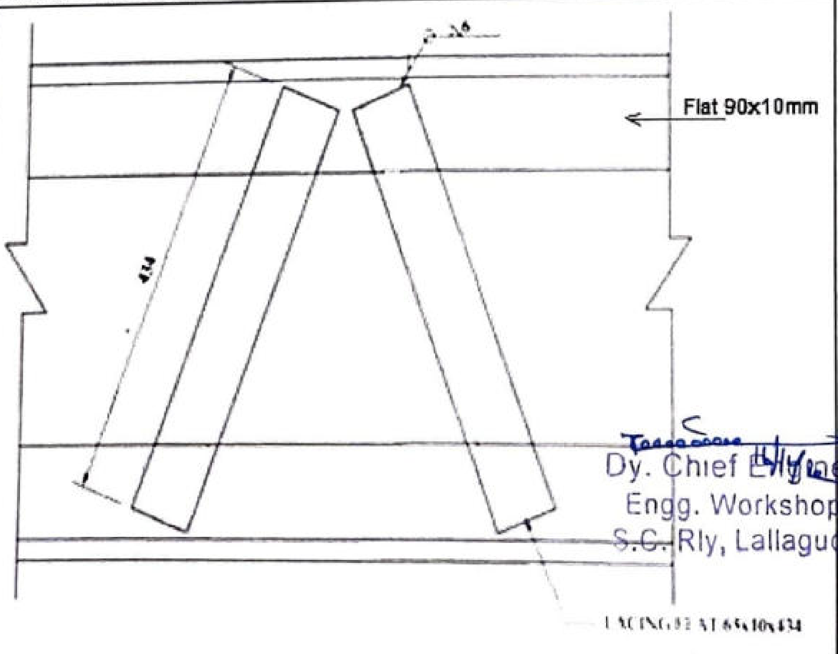
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld 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 Engineer.
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/12
1	Drawing No.	:	RDSO/B-17167/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 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 Class Type Drying Method	: : :	N.A
6.3	Shielding Gas	:	CO_2
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, 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.,)	:	Part stretch shown. 
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current Type Polarity	 : :	 DC Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

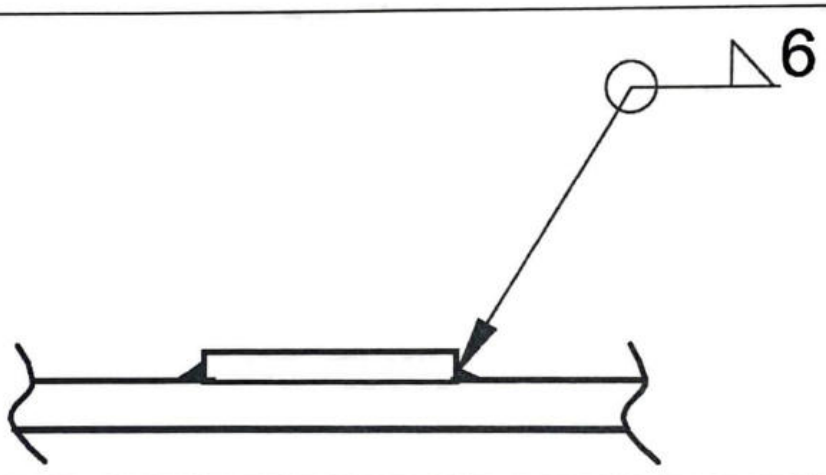
Executive Engineer/Civil
Construction Division-I/CC-II

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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

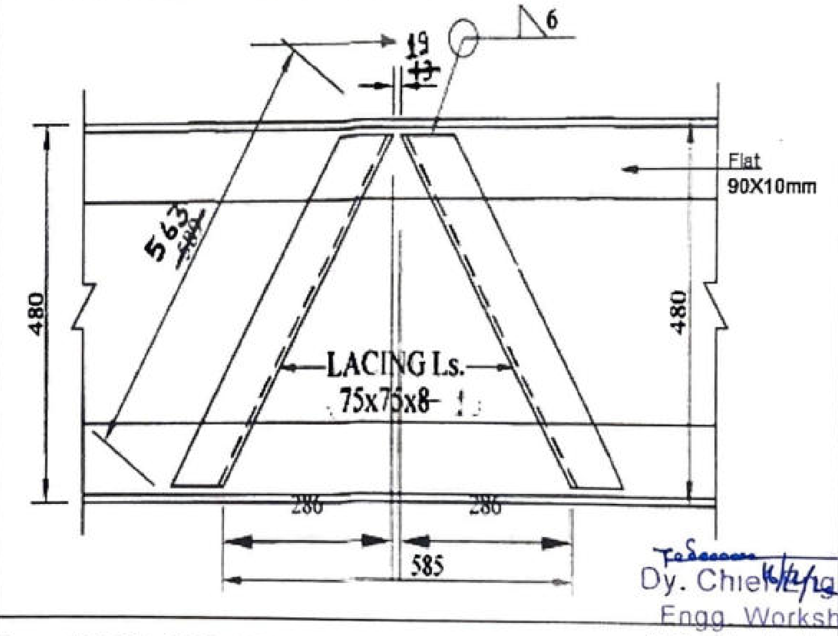
10.2	Welding Sequence and technique	:	
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld 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 Engineer
Engg. Workshop

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

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: 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/13
1	Drawing No.	:	RDSO/B-17166/R (Details of Lacing)
2	Weld Joint description	:	Fillet 6mm (Lacing Angle welding on Top Chord)
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	:	
	Type	:	N.A
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Assistant Research Officer (M)

Dy. Chief Engg. Workshop, S.C. Rly, Lallaguda

Executive Engineer/Civil, Construction Division-I/CC-II, 5x800 MW, YTPS, Veerlapalem (V), Damarcherla (M), Nalgonda (D) 503 355

J. Srinivas Rao

GLOBAL STEEL COMPANY Survey No.12

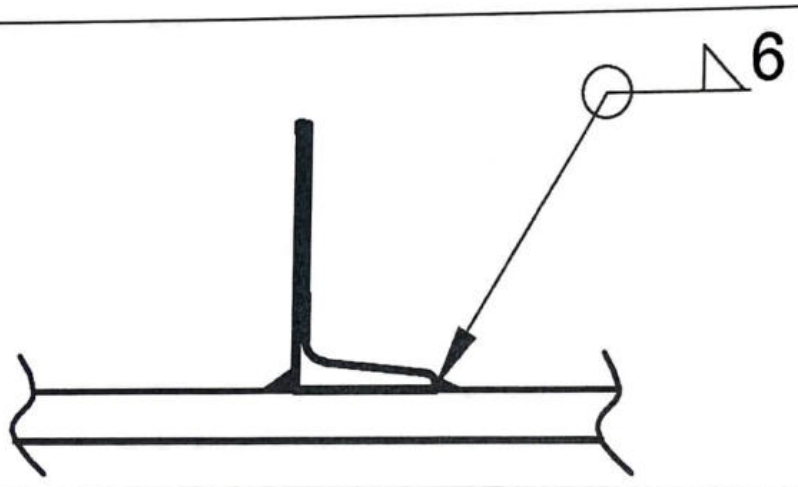
Appendix-V (Ref.Cl.26 of BI-2001)

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

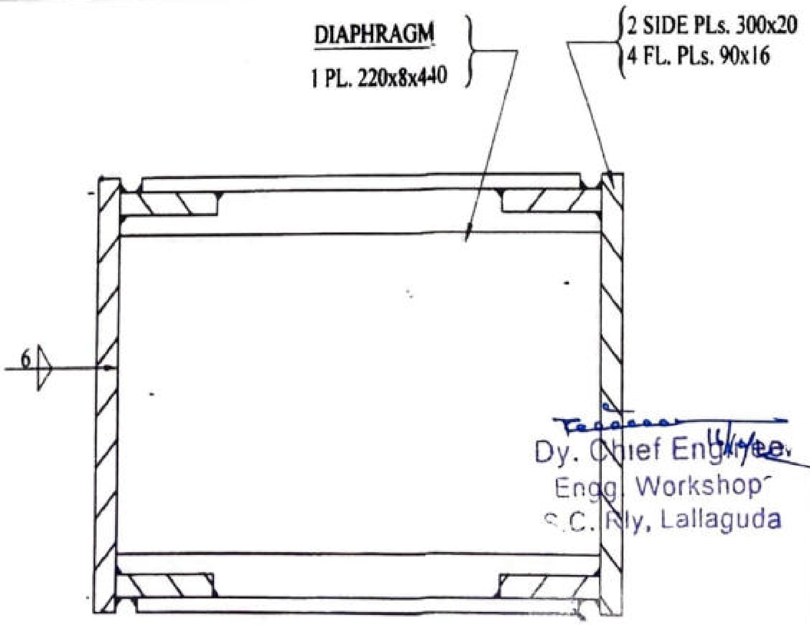
Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

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

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.

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/14
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	:	IS:2062:2011, Gr E250B0 (8MM X 20MM)
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	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Assistant Research Officer

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

J. Srinivas Rao

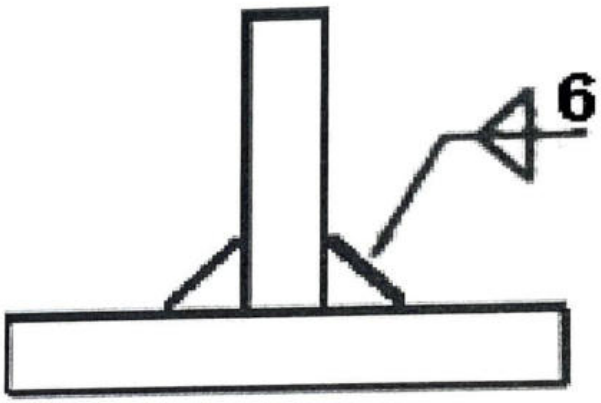
Executive Engineer/Civil
Construction Division I/CC
5x800 MW YTPP

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

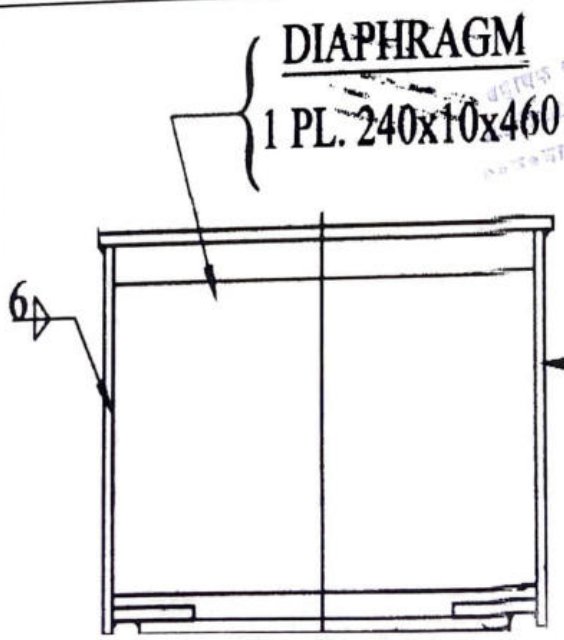
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/15
1	Drawing No.	:	RDSO/B-17166/R (Section A-A)
2	Weld Joint description	:	Fillet 6mm (Diaphragm Plate welding on Top Chord)
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	:	
	Type	:	N.A
	Drying Method	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer/Civil
Construction Division-I/CC-II

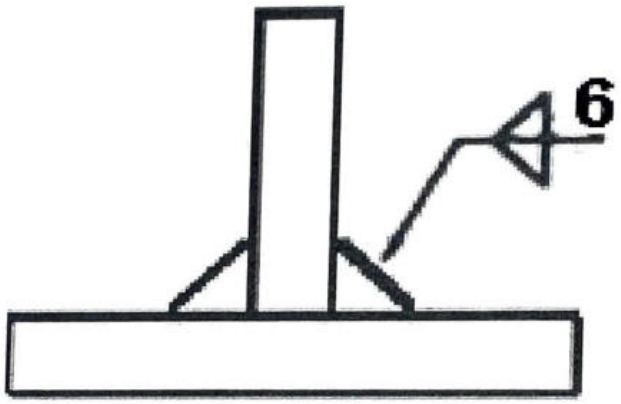
Appendix-V (Ref.Cl.26 of BI-2001)

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

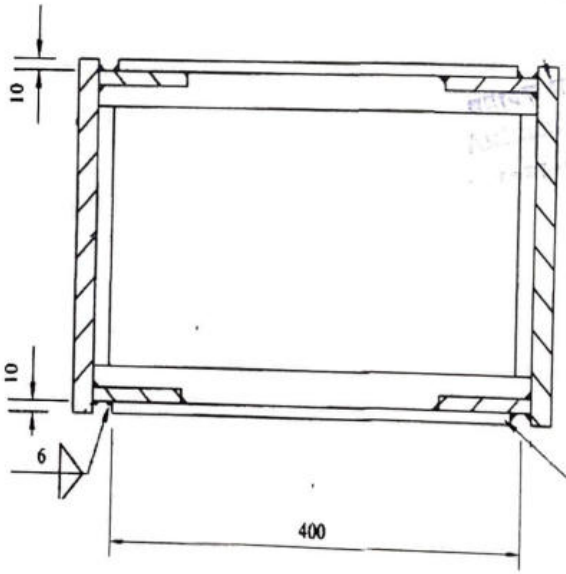
Dy. Chief Engineer

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

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: 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/16
1	Drawing No.	:	RDSO/B-17165/R, Section A-A & B-B
2	Weld Joint description	:	Fillet 6mm (Batten Plate welding on Bottom Chord)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10mm X 16mm & 10mm X 12mm)
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	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity		Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

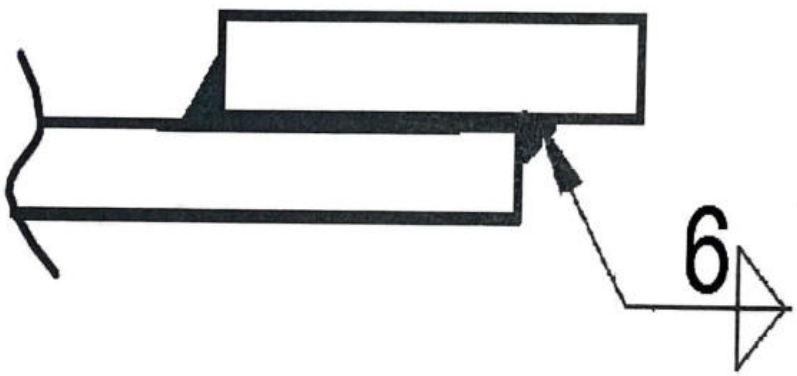
Executive Engineer/Civil
Construction Division-I/CCG-II

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

12/01/2022

सहायक अनुसंधान अधिकारी (वाह
Assistant Research Officer (M

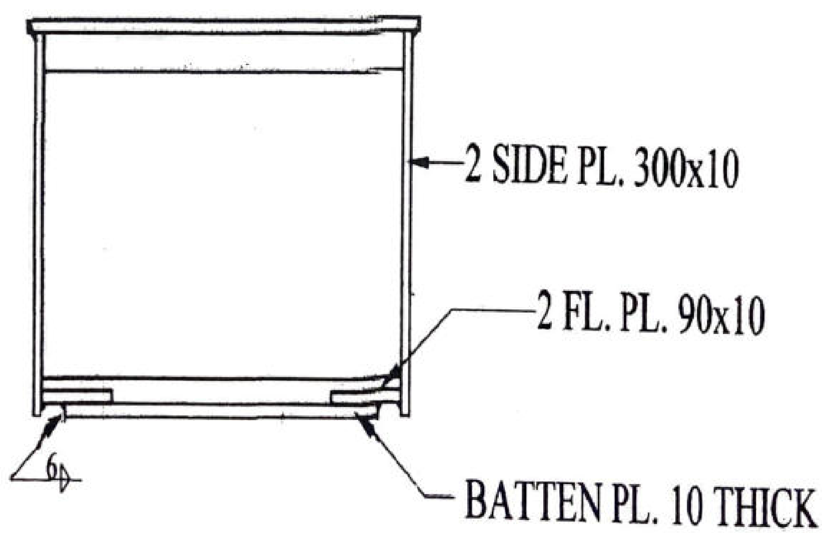
Dy. Chief Engg.
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/17
1	Drawing No.	:	RDSO/B-17166/R, Section A-A
2	Weld Joint description	:	Fillet 6mm (Batten Plate welding on Top Chord)
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	:	
	Type	:	N.A
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC- 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

12/01/2022

Research Officer

Dy. Chief Engineer
Engg. Workshop
SCR, Lallaguda

Executive Engineer/Civil
Construction Division-I/CC

Srinivas Rao
Sr Dy General Manager(C)

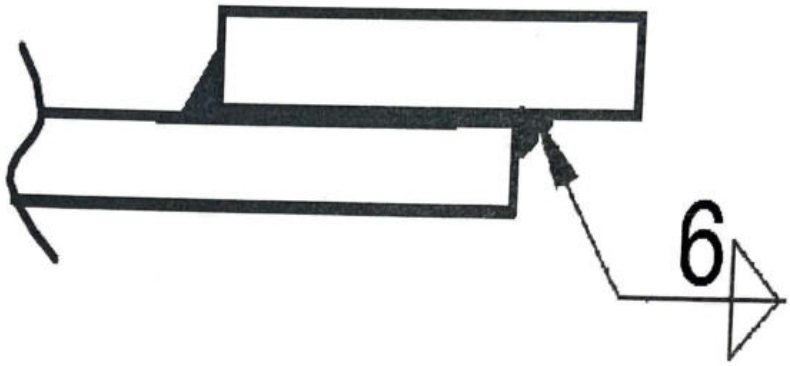
Appendix-V (Ref.Cl.26 of BI-2001)

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 LOCATIONS 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 (l/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 :



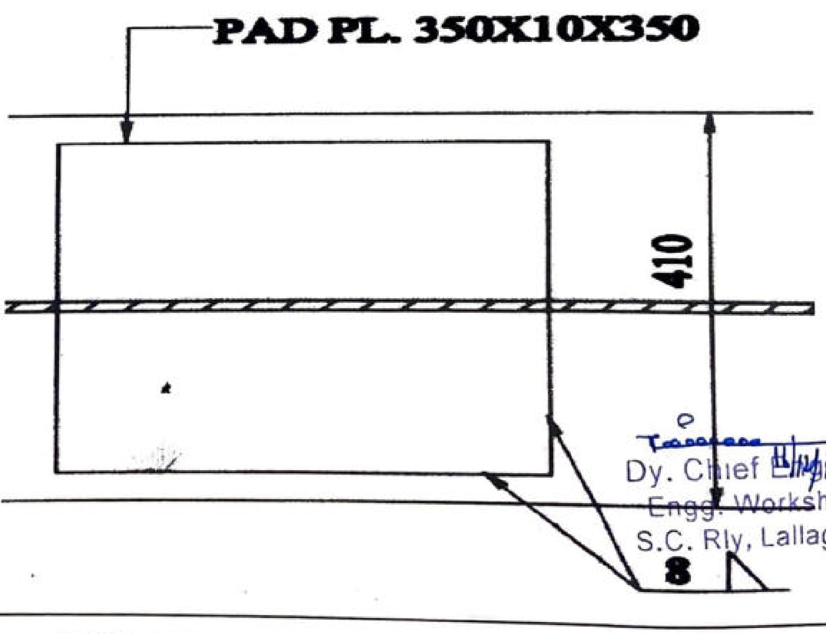
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld 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 Engineer,
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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)
2	Weld Joint description	:	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		
	Class	:	
	Type	:	N.A
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Assistant Research Officer

Dy. Chief Engineer, Engg. Workshop, S.C. Rly, Lallaguda

Executive Engineer/Civil, Construction Division-I/CC-II, 5x800 MW, YTPS, Veerlapalem (V)

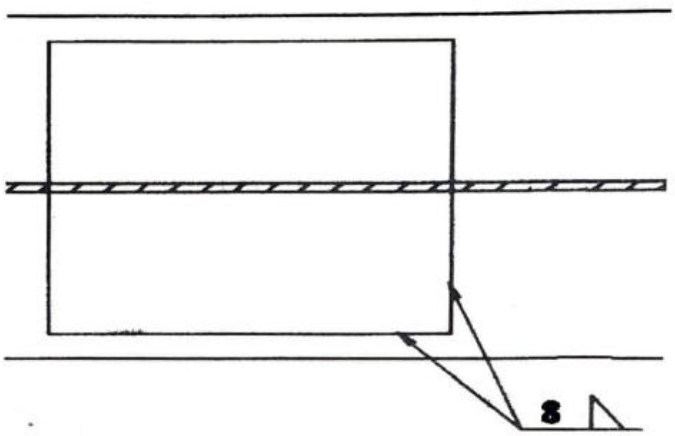
Srinivas Rao, Sr.Dy.General Manager(C)

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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 Engineer
Engg. Workshop
S.C. Rly, Lallaguda

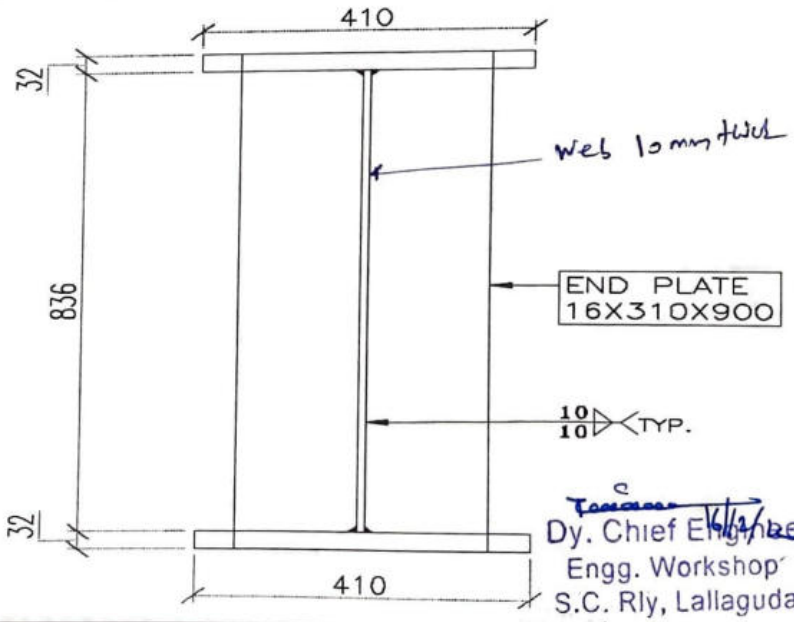
Appendix-V (Ref.Cl.26 of BI-2001)

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: 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/19
1	Drawing No.	:	RDSO/B-17172
2	Weld Joint description	:	Fillet 10mm (End Plate welding to Cross Girders)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (16mm 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 Class Type Drying Method	: : :	 N.A
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, 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.,)	:	Part stretch shown.
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current Type Polarity	: :	 DC Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	



Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

GLOBAL STEEL COMPANY Survey No.12.

Executive Engineer/Civil
Construction Division-I/CC-II
5x800 MW, YTPS, Veerlapalem (V)

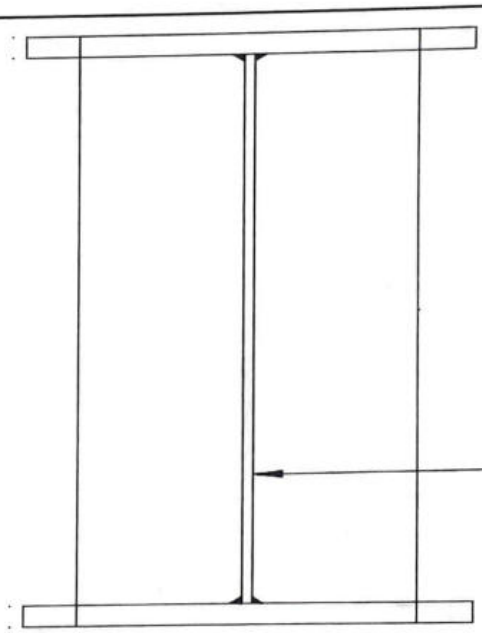
श्रीनिवास राव/J. Srinivas Rao
वरिष्ठ उप महाप्रबंधक(नि)/Sr Dy General Manager(C)

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

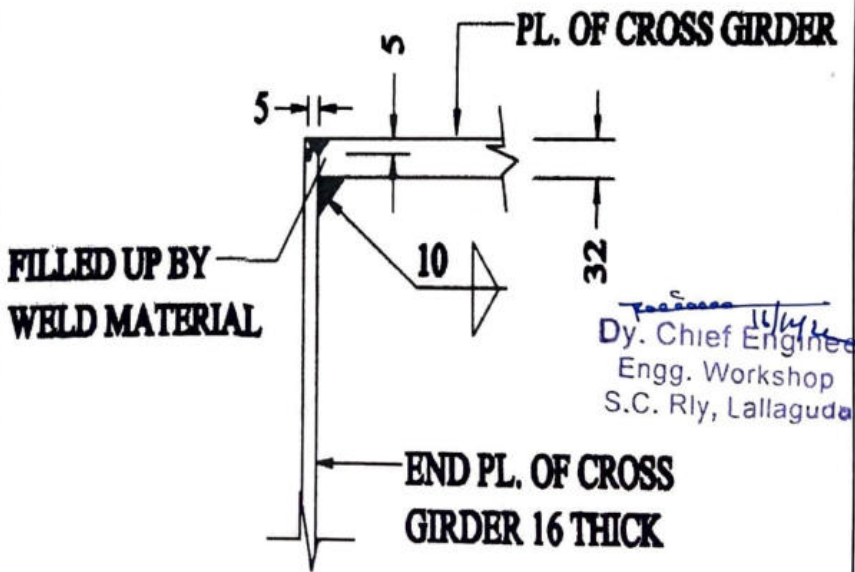
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.

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
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	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

GLOBAL STEEL COMPANY Survey No.12.

श्रीनिवास राव/J. Srinivas Rao

Executive Engineer/Civil
Construction Division-I/CC-I
5x800 MW, YTPS, Veerlapalem (V)

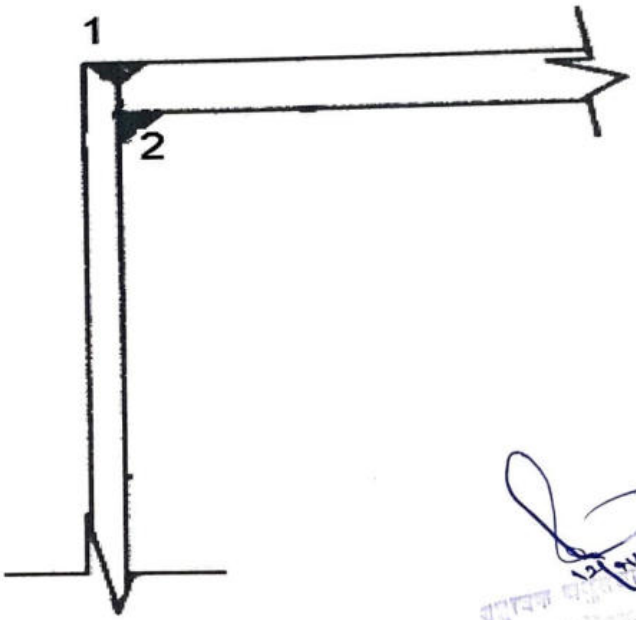
Appendix-V (Ref.Cl.26 of BI-2001)

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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	:	1, 2



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.

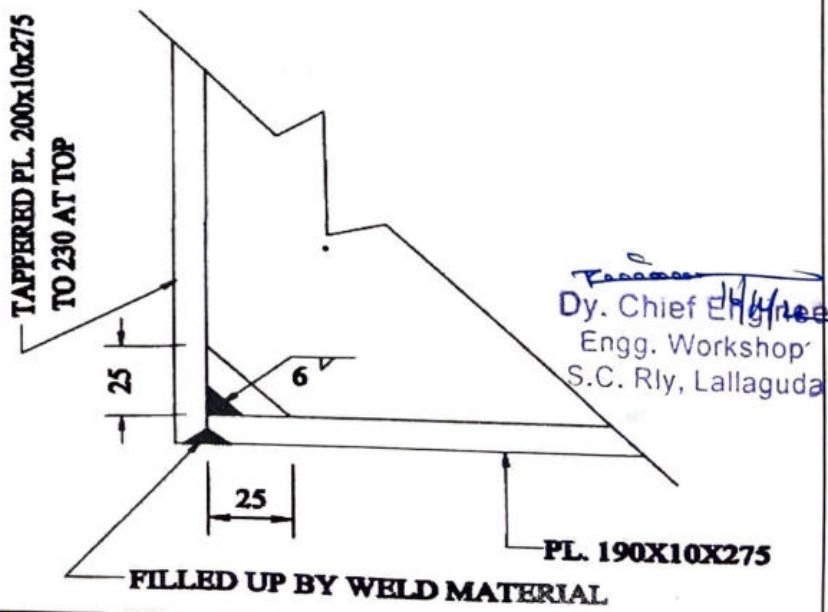
Dy. Chief Engineer
Engg Workshop
S.C. Rly, Lallaguda

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

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: 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/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	:	
	Type	:	N.A
	Drying Method	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer/Civil
Construction Division-I/CC-I

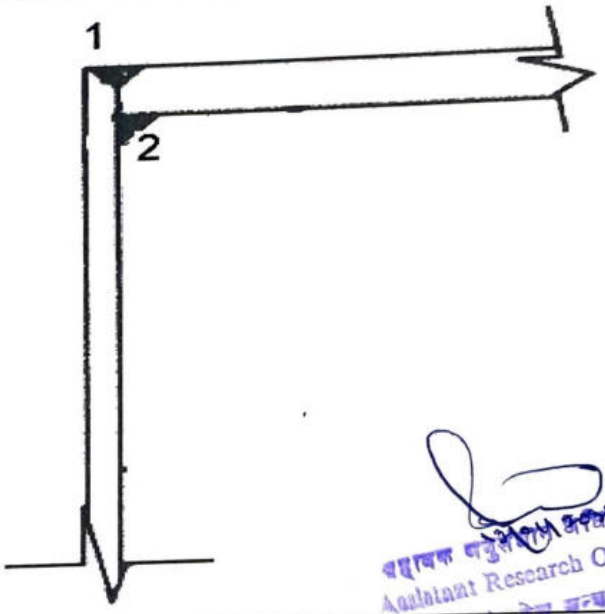
निवास राव/J. Srinivas Rao

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 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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

सहायक अनुसंधान अधिकारी (मा
Assistant Research Officer (M
दक्षिण मध्य रेल अनुसंधान संगठन

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.

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/MMAW/22
1	Drawing No.	:	RDSO/B-11761
2	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		
6.1	Electrode/Wire		
	Class	:	A2 of IRS M28-2012
	Type	:	Medium Coated.
	Drying Method	:	As recommended by the Electrode Manufacturer.
6.2	Flux		
	Class	:	N.A
	Type	:	
	Drying Method	:	
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 weld 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, Cl.7, IRS B1 – 2001, Cl. 17.3
8.0	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9.0	Welder Qualification	:	As per IS 7310 (Part-I) – 1974
10.0	Welding parameters and technique	:	

सहायक अनुसंधान अधिकारी (सा
Assistant Research Officer (M
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Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/min)
1	4	180-210	24-27	N.A.	N.A.	N.A.	N.A.

10.2	Welding Sequence and technique	:	
11.0	Provision of run-on/run-off tabs	:	N.A.
12.0	Cleaning of weld bead before laying of next weld bead	:	N.A.
13.0	Root preparation before welding other side of groove weld	:	N.A.
14.0	Preheating and inter pass temperature	:	N.A.
15.0	Peening	:	N.A.
16.0	Post weld treatment	:	N.A.
17.0	Rectification of weld defect	:	By re-welding after complete removal of defective weld.
18.0	Inspection of weld	:	Visual, D.P. Test.
19.0	Any other relevant detail	:	None.

16/4/22
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

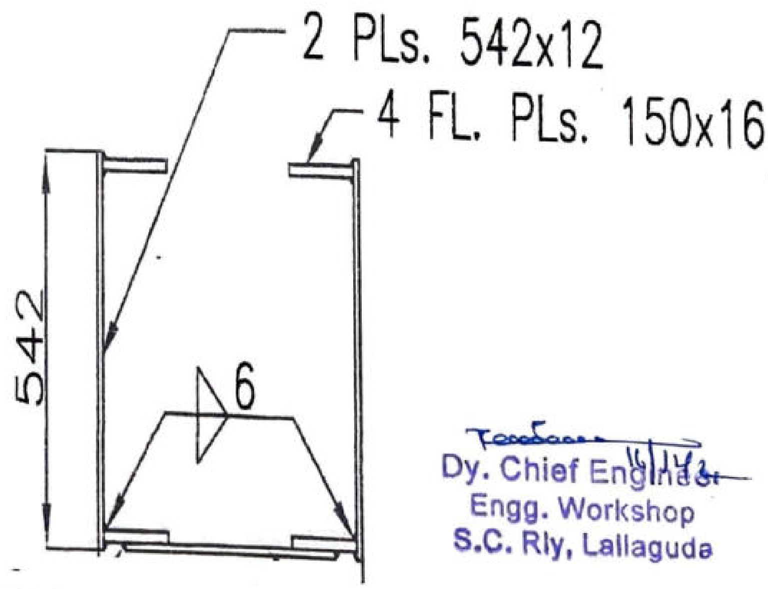
Railway Open Web Girder (25t loading)
45.7m clear span
MODEL WPSS No- RDSO/ Infra-II/ B&S/ RG/ OWG./ WPSS / 45.7 series (22 nos)

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/01
1	Drawing No.	:	RDSO/B-17181/4/R, Section A-A
2	Weld Joint description	:	Fillet 6mm (Bottom Chord, L0-L1 & L1-L2)
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.
	Type	:	Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	N.A
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	

सहायक अनुसंधान अधिकारी (धातु) Assistant Research Officer (M) अ०अ०मा०सं० रेल मंत्रालय लखनऊ

Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda

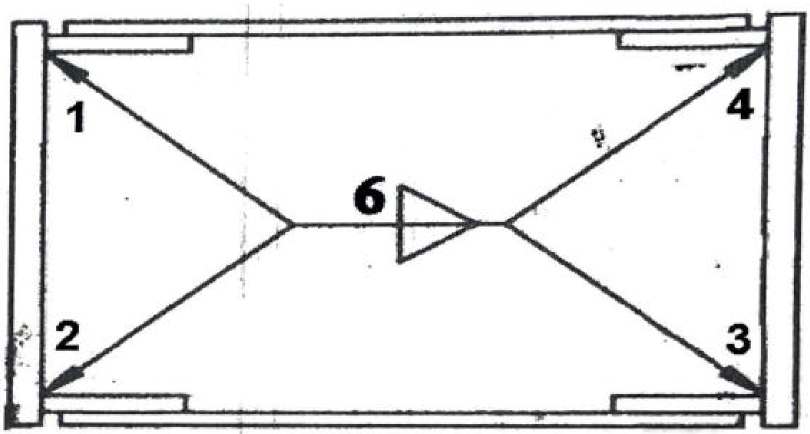
Appendix-V (Ref.Cl.26 of BI-2001

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 :

Weld Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

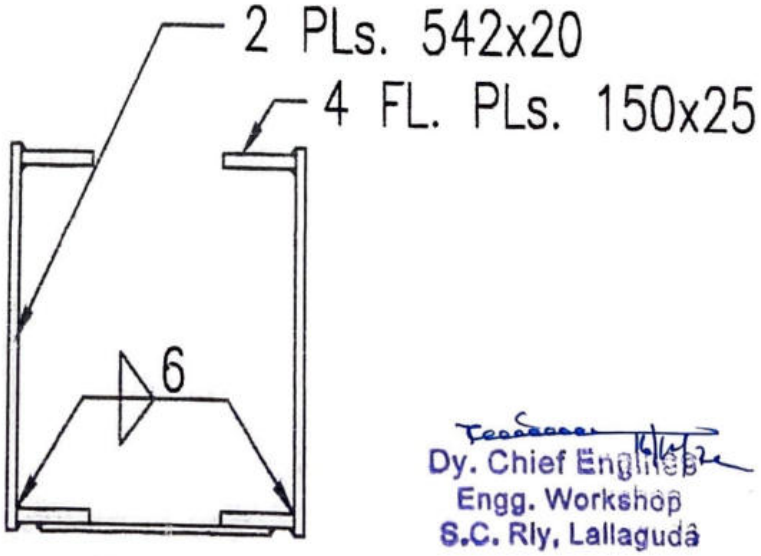
Assistant Research Officer

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/02
1	Drawing No.	:	RDSO/B-17181/4/R, Section B-B
2	Weld Joint description	:	Fillet 6mm (Bottom Chord, L2-L3 & L3-L4)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (20MM X 25MM)
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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	N.A
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer/

व.उप महाप्रबंधक(सि)/Sr.Dy.General Manager(C)

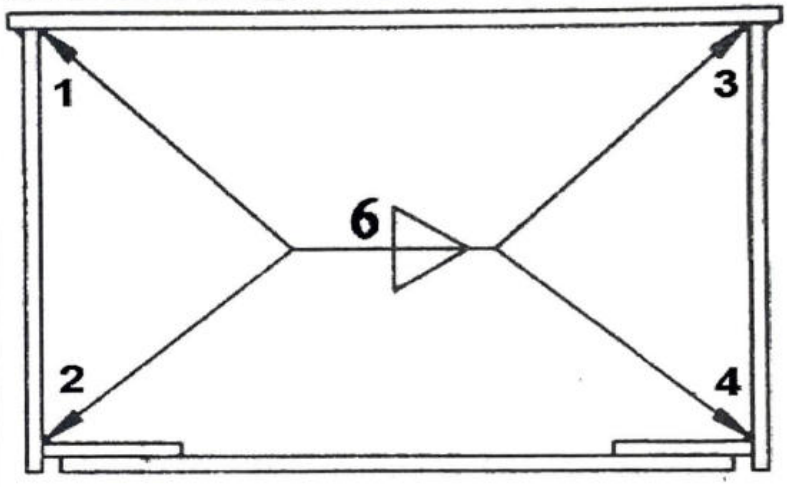
Appendix-V (Ref.Cl.26 of BI-2001

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 :

Weld Pass No.	Electrodes wire dia. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (m/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

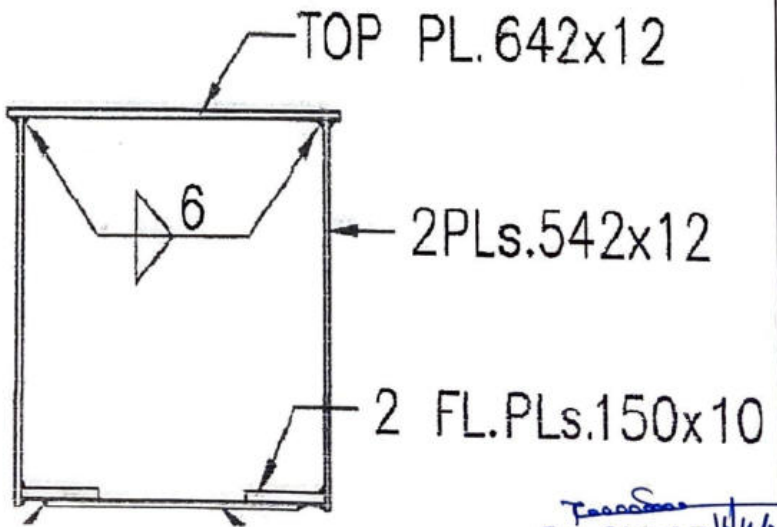
Assistant Research Officer (M)

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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 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/SAW/03
1	Drawing No.	:	RDSO/B-17181/R, Section of U1-U2 & U2-U3
2	Weld Joint description	:	Fillet 6mm (Top Chord, U1 - U2 &U2 - U3)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 12MM & 12MM X 12MM)
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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	N.A
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

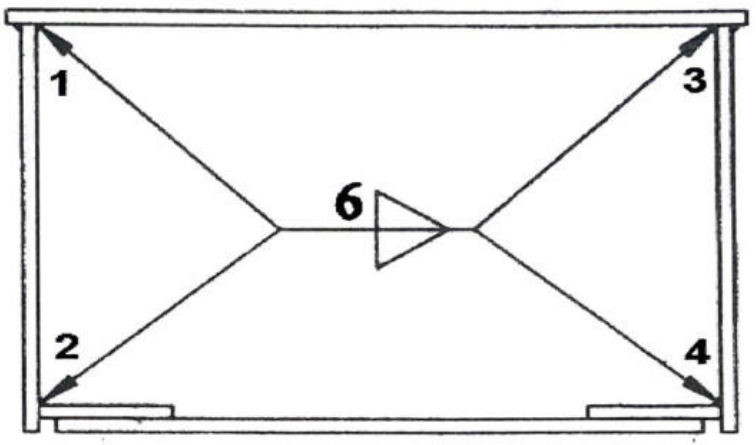
J. Srinivas Rao
Executive Engineer/C
Sr Dy General Manager (S)

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. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (l/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



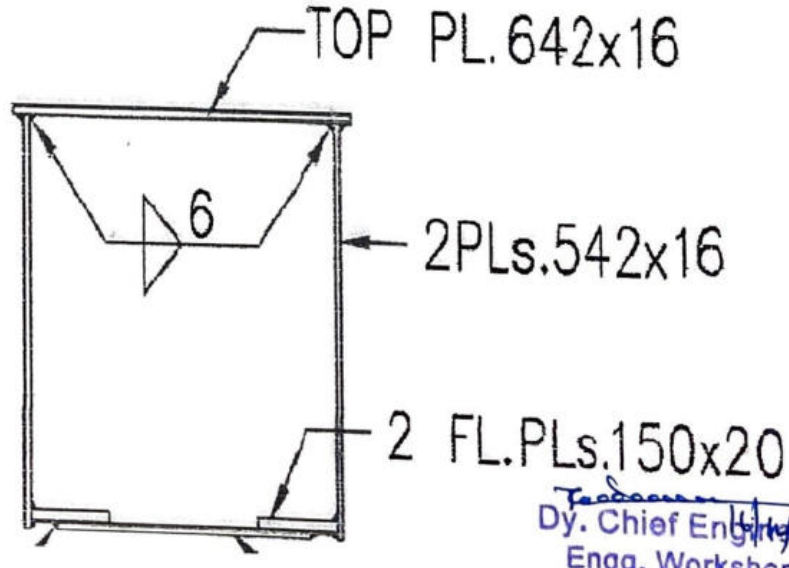
11	Provision of run-on/run-off tabs	:	Yes
12	Cleaning of weld bead before laying of next weld bead	:	N.A.
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 150°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld 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.
19	Any other relevant detail	:	None

Dy. Chief Engineer

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/04
1	Drawing No.	:	RDSO/B-17181/R, Section of U3-U4
2	Weld Joint description	:	Fillet 6mm (Top Chord, U3 - U4)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (16MM X 16MM & 16MM X 20MM)
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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	N.A
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer

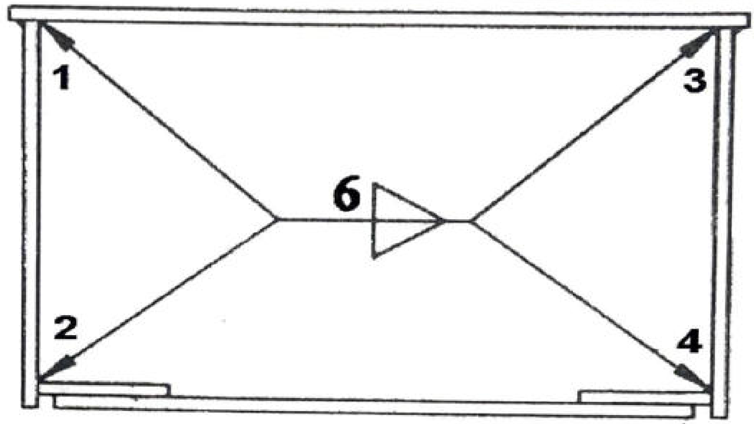
जे. श्रीनिवास राव/J. Srinivas Rao

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. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

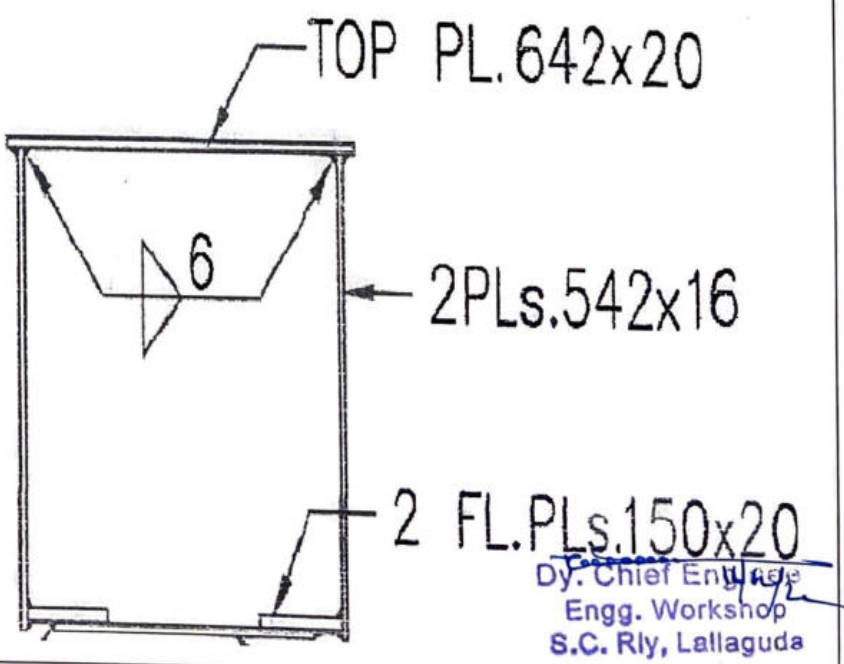
Assistant Research Officer (M

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/05
1	Drawing No.	:	RDSO/B-17181/R, Section L0-U1
2	Weld Joint description	:	Fillet 6 mm (End Raker)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (16MM X 20MM)
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
	Drying Method	:	250 C for one hour before uses OR Recommendation as per manufacturer.
6.3	Shielding Gas	:	NA
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 weld quality.
7.1	Joint design details	:	
	(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part I) – 1974
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

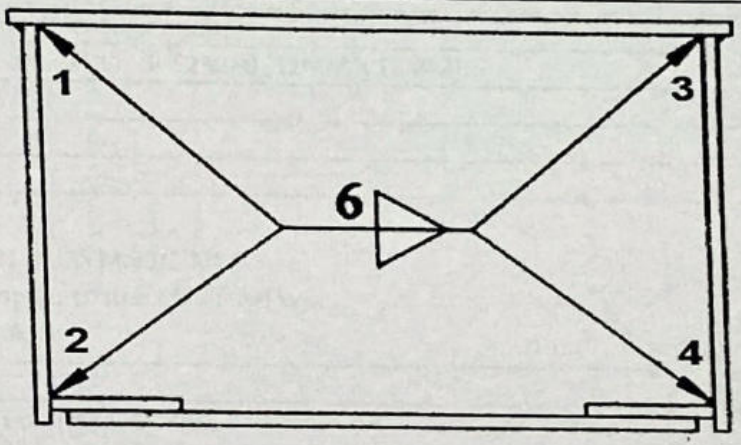
Executive Engineer
Construction Division-I
5x800 MW YTPS, Veerlapalem

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. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

Assistant Research Officer (M

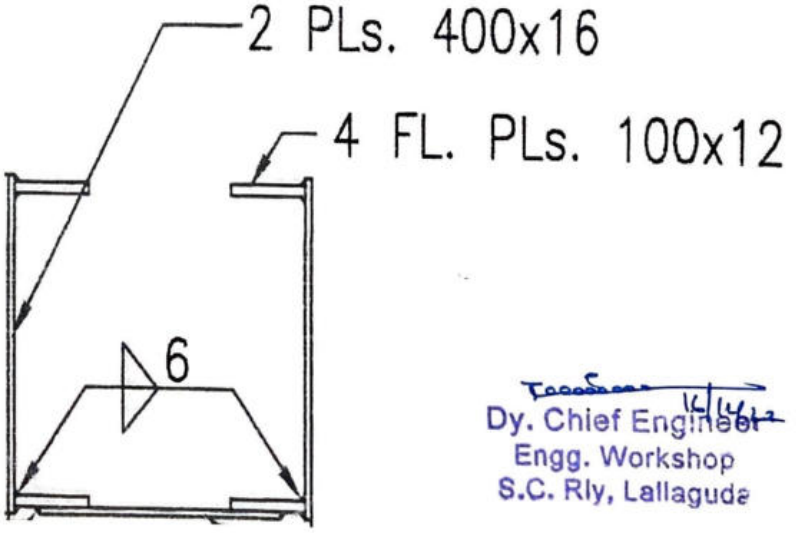
Dy. Chief Engineer
Engg. Workshop

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

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: 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/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.
	Type	:	Copper coated Mild Steel Wire.
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

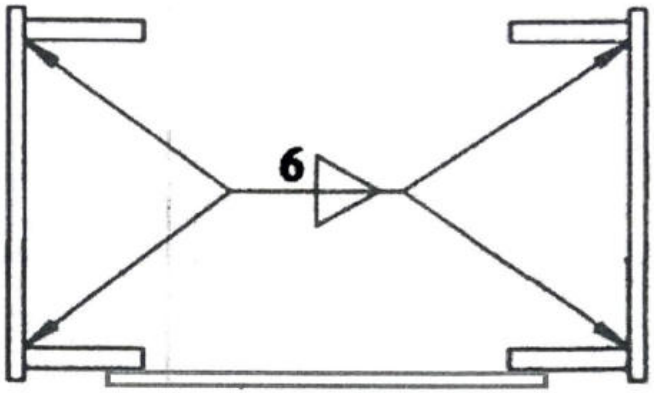
Executive Engineer/Civ

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. (mm)	Current (Amps)	Arc Voltage (Volt)	Travel Speed (mm/Min)	Electrical Stick out (mm)	Gas Flow (l/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



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
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.
19	Any other relevant detail	:	None

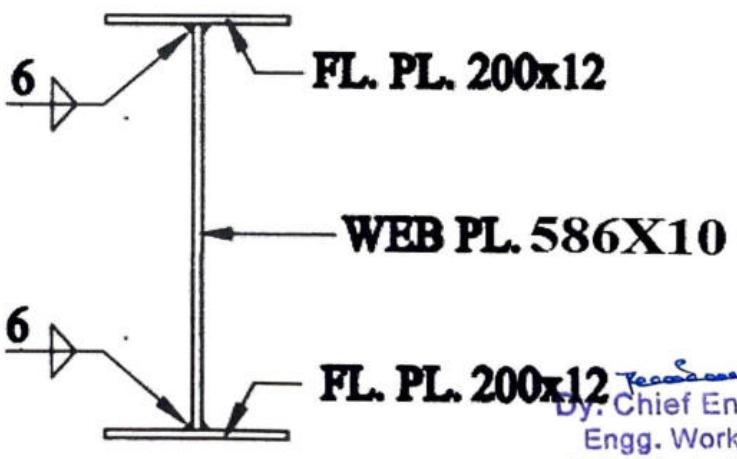
सहायक अनुसंधान अधिकारी (यां
Assistant Research Officer (M
दक्षिण मध्य रेल कार्यशाला सिकंदराबाद

Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/07
1	Drawing No.	:	RDSO/B-17181/R, Section of Verticals
2	Weld Joint description	:	Fillet 6mm (Verticals)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 12MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Assistant Research Officer (M)

By: Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

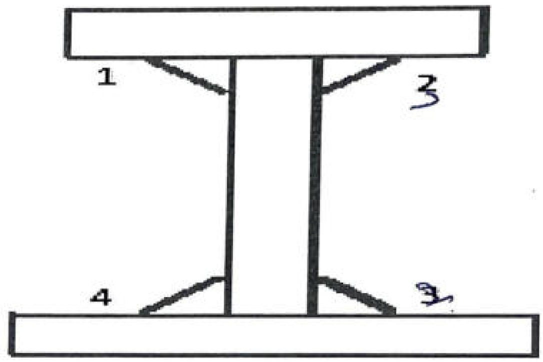
Appendix-V (Ref.Cl.26 of BI-2001)

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 :

Weld Pass No	Electrodes wire dia. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		~~AC~~	DC	~~AC~~	DC			
1	4	~~450-500~~	450-550	~~25-28~~	25-30	0.45.0.55	20-25	N.A.

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



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.

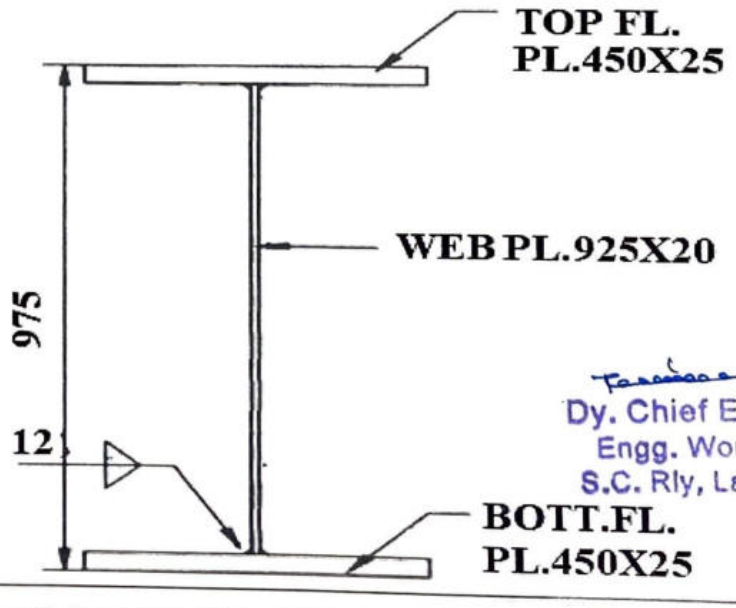
सहायक अनुसंधान अधिकारी
Assistant Research Officer

16/1/2
Dy. Chief Engineer
Engg. Workshop

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/08
1	Drawing No.	:	RDSO/B-17181/R (L_0-L'_0, L_1-L'_1, L_2-L'_2, L_3-L'_3, L_4-L'_4)
2	Weld Joint description	:	Fillet 12mm (Cross Girder)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (20MM X 25MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

श्रीनिवास राव/J. Srinivas Rao
Executive Engineer/

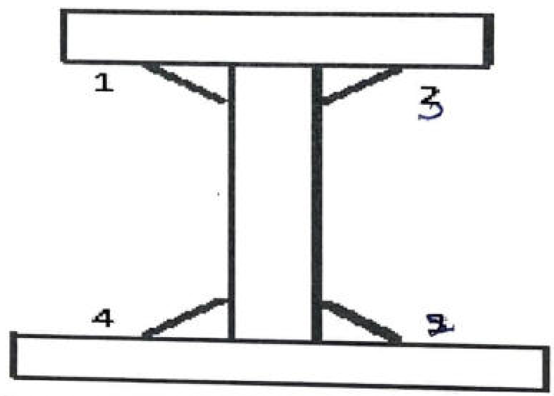
Appendix-V (Ref.Cl.26 of BI-2001)

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 (X30.5m + 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 (l/min)
		AC	DC	AC	DC			
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	Welding Sequence and technique	:	1&2, 3&4



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.

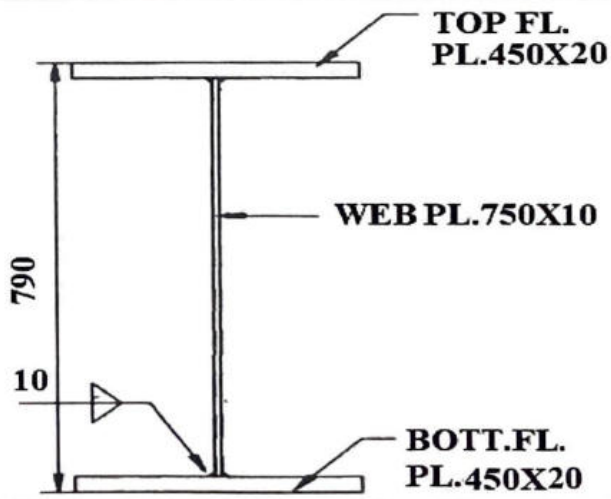
Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

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

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.

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/SAW/09
1	Drawing No.	:	RDSO/B-17181/R (L_0-L_1, L_1-L_2, L_2-L_3, L_3-L_4)
2	Weld Joint description	:	Fillet 10mm (Stringer)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 20MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

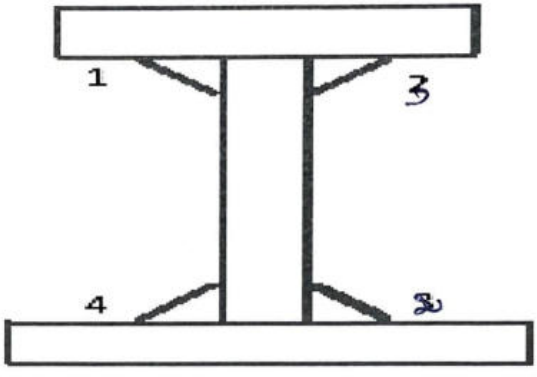
Appendix-V (Ref.Cl.26 of BI-2001)

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 :

Weld Pass No	Electrodes wire dia. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



11	Provision of run-on/run-off tabs	:	N.A.
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 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.

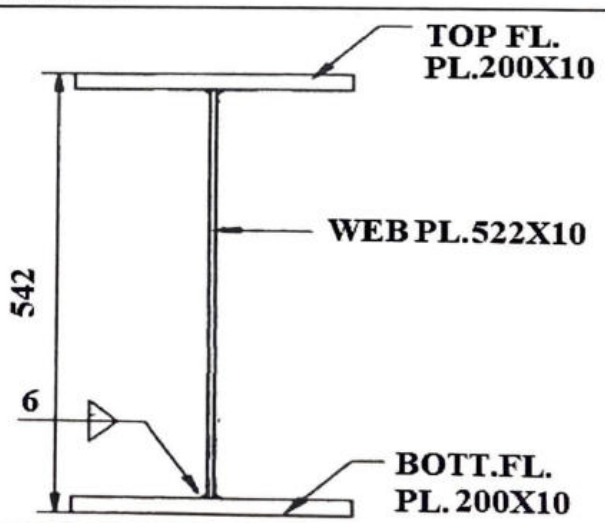
12/04/2022
Assistant Research Officer (M)

Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/10
1	Drawing No.	:	RDSO/B-17181/R Portal Girders (U_1-U'_1)
2	Weld Joint description	:	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		
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
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
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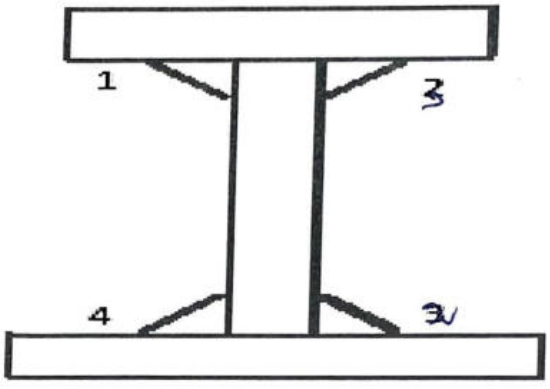
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



11	Provision of run-on/run-off tabs	:	N.A.
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 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.

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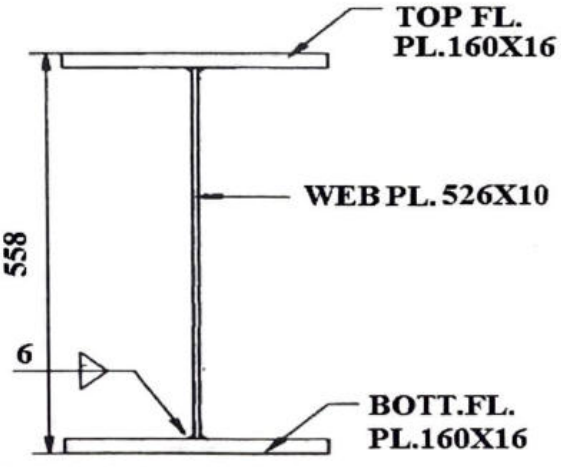
WELDING PROCEDURE SPECIFICATION SHEET

"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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/11
1	Drawing No.	:	RDSO/B-17181/R (Sway Girder U_2-U'_2, U_3-U'_3, U_4-U'_4)
2	Weld Joint description	:	Fillet 6mm (Sway Girder)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 16MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

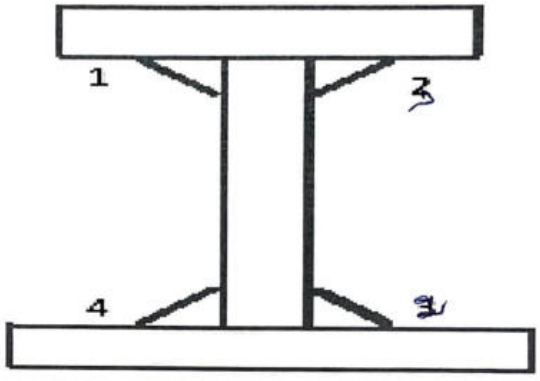
Appendix-V (Ref.Cl.26 of BI-2001)

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 :

Weld Pass No	Electrodes wire dia. (mm)	Current (Amps)		Arc Voltage (Volt)		Travel Speed (M/Min)	Electrical Stick out (mm)	Gas Flow (l/min)
		AC	DC	AC	DC			
1	4	450-500	450-550	25-28	25-30	0.45.0.55	20-25	N.A.

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



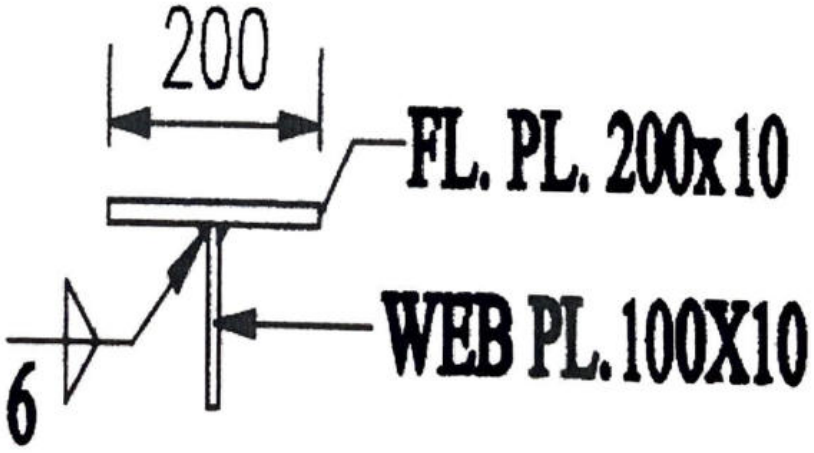
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld 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 Engineer
Engg. Workshop

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/12
1	Drawing No.	:	RDSO/B-17181/R (U_1-U'_2, U_2-U'_3, U_3-U'_4)
2	Weld Joint description	:	Fillet 6mm (Top Lateral Bracings)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MM X 10MM)
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.
6.2	Flux		
	Class	:	F1 of IRS M.39-2001
	Type	:	Agglomerated
	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, 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.,).		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

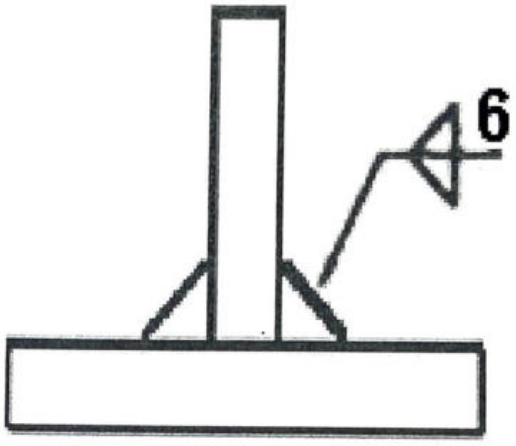
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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 (l/min)
1	4	450-550	28-32	0.45.0.55	25 - 30	N.A.

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	:	N.A.
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.

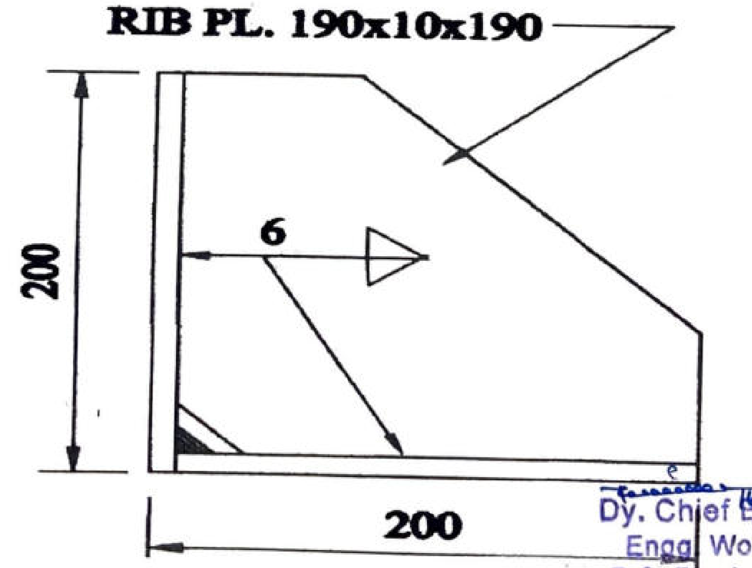
Assistant Research Officer (M

Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

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

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: 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/13
1	Drawing No.	:	RDSO/B-17181/13, 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	:	1 of IRS M.46
	Type	:	1.2mm MIG Wire
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	
	Type	:	N.A
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

12/01/2023
सहायक अनुसंधान अधिकारी (धातु)
Assistant Research Officer (M)

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

J. Srinivas Rao
व.उप महाप्रबंधक(सि)/Sr Dy General Manager(C)

Executive Engineer
Construction Division

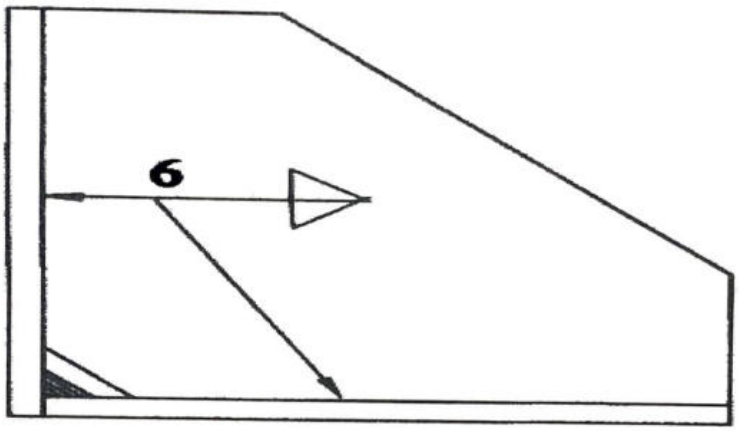
GLOBAL STEEL COMPANY, Survey No. 12

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

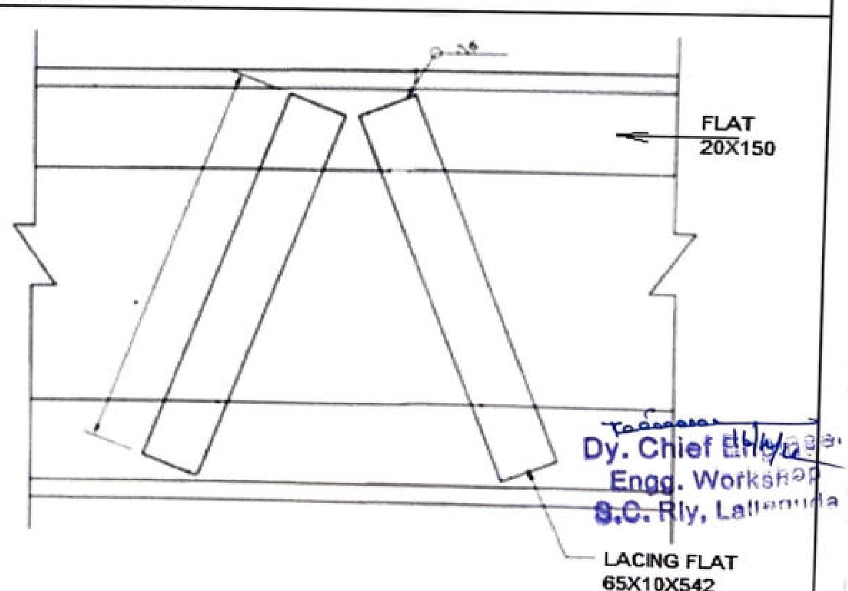
Consultant Research Officer (M

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/14
1	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
	Type	:	1.2mm MIG Wire
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	
	Type	:	N.A
	Drying Method	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) - 817
10	Welding parameters and technique		

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

सहायक अनुसंधान अधिकारी
Assistant Research Officer

जे. श्रीनिवास राव/J. Srinivas Rao
उप महाप्रबंधक(सि)/Sr.Dy.General Manager(C)

Executive Engineer
Construction Division
5x800 MW YTPS, Vee

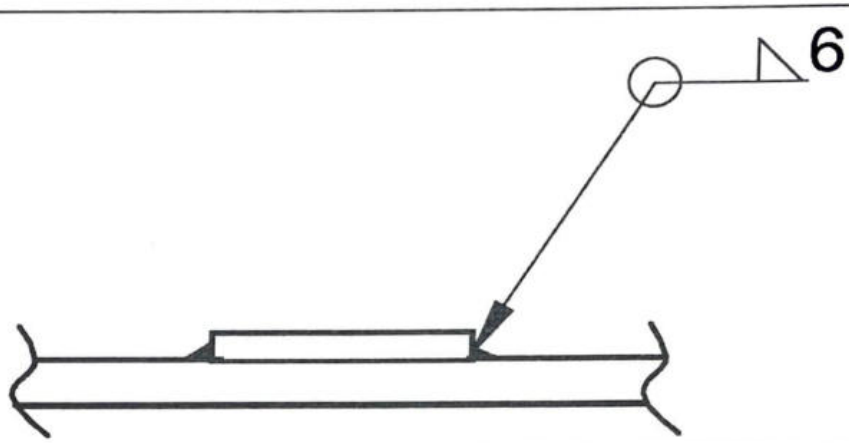
GLOBAL STEEL COMPANY Survey No 12

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: 4138.00m (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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

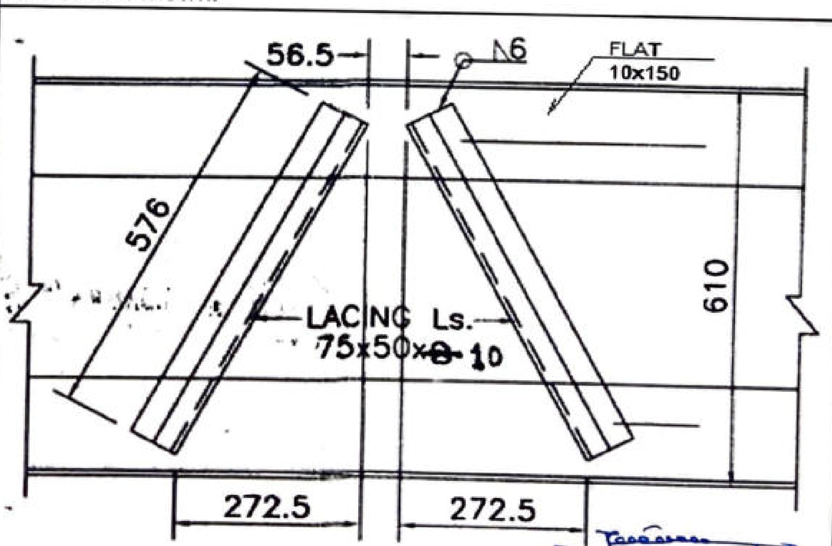
12/04/2025
Assistant Research Officer (M

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/15
1	Drawing No.	:	RDSO/B-17181/5/R (Details of Lacing)
2	Weld Joint description	:	Fillet 6mm (Lacing Angle welding on Top Chord)
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	:	
	Type	:	N.A
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

Dy. Chief Engr/Wksp
Engg. Workshop
S.C. Rly. Lallaguda

Assistant Research Officer

J. Srinivas Rao
Sr Dy.General Manager(C)

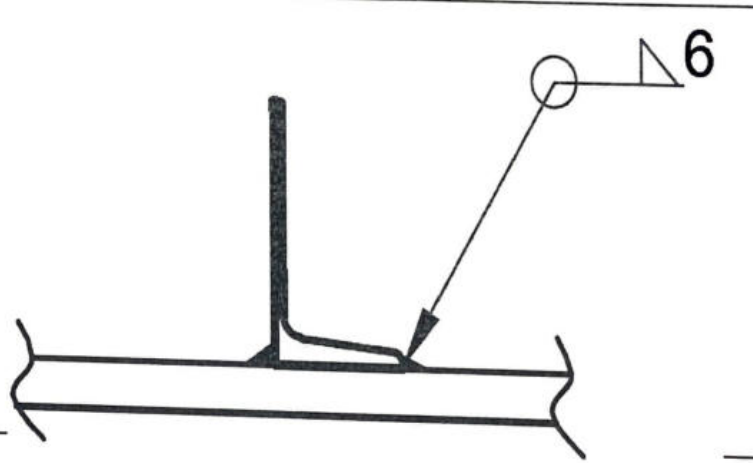
Executive Engineer
Construction Division

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

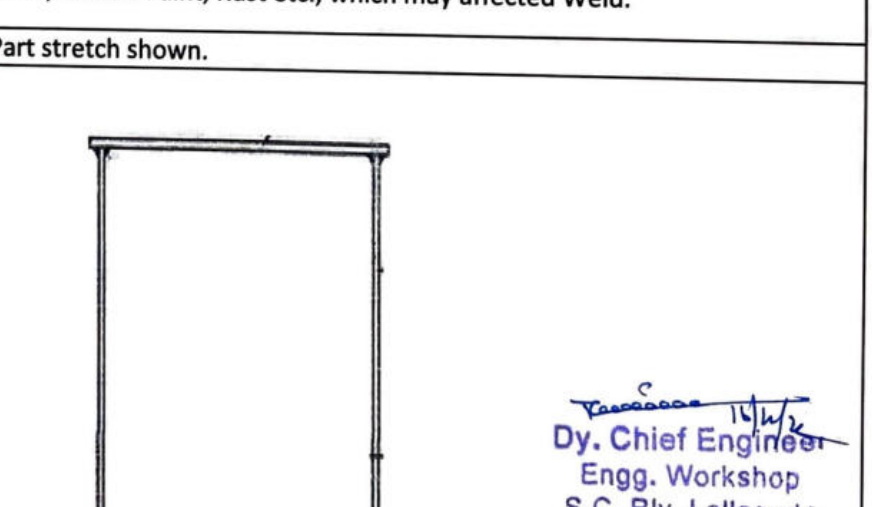
Assistant Research Officer (M

Dy. Chief Engineer

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

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: 2138.00m (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
1	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))
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	:	
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, 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.,)		 BATTENS 10 THICK
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Srinivas Rao
Sr Dy General Manager(C)

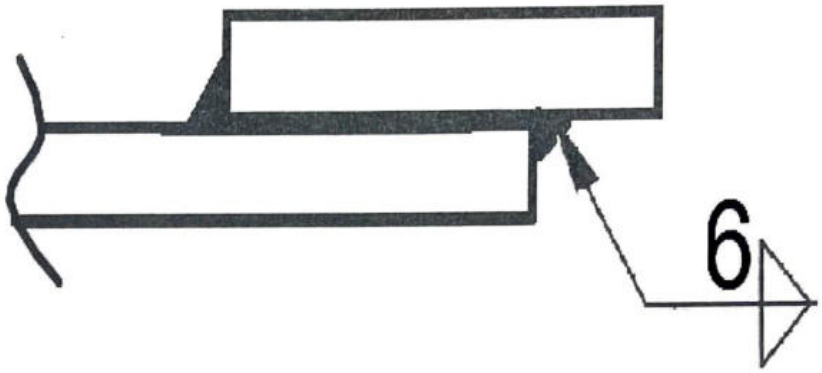
Executive Engineer
Construction Division
5x800 MW, YTPS, Veerlapalem

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

Assistant Research Officer (M)

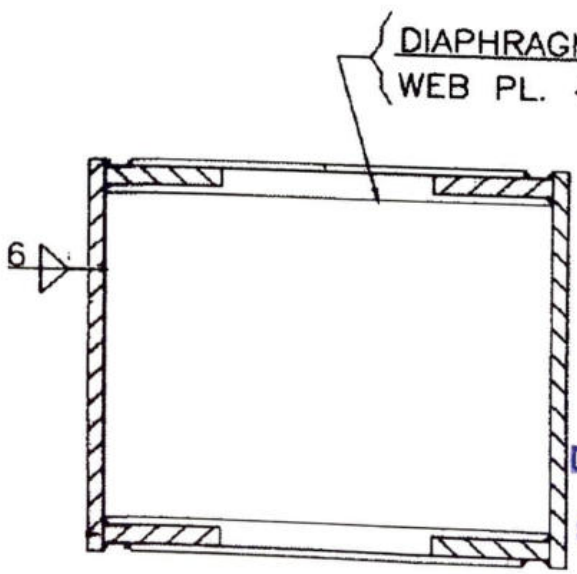
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding 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 IRS M.46
	Type	:	1.2mm MIG Wire
	Drying Method	:	N.A.
6.2	Flux		
	Class	:	
	Type	:	N.A
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

सहायक अनुसंधान अधिकारी (आर
Assistant Research Officer (M
लखनऊ। रेल मन्त्रालय भारत

Dy. Chief Engr
Engg. Workshop
S.C. Rly, Lallaguda

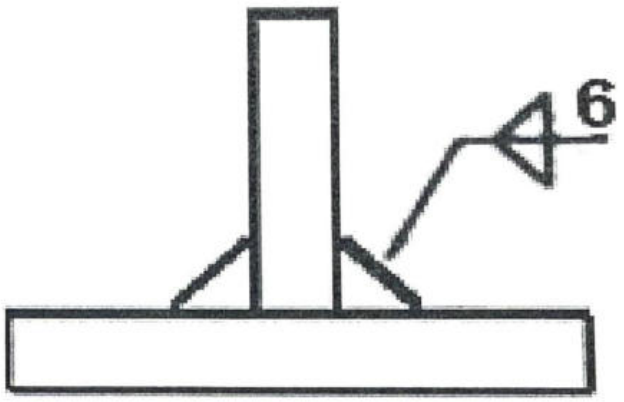
Executive Engineer/Civil
Construction Division-I/CC-II

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

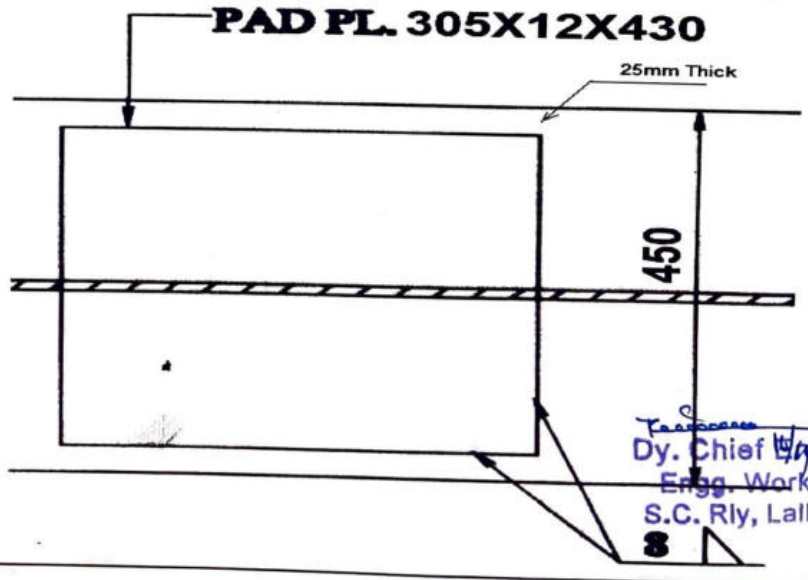
Assistant Research Officer (M

Dy. Chief Engineer
Engg. Workshop

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/18
1	Drawing No.	:	RDSO/B-17181/13 (Sectional Plan)
2	Weld Joint description	:	Fillet 8mm (Pad Plate Welding to End Cross Girder)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (12MM X 25MM)
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	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engin
Engg. Workshc
S.C. Rly, Lallag

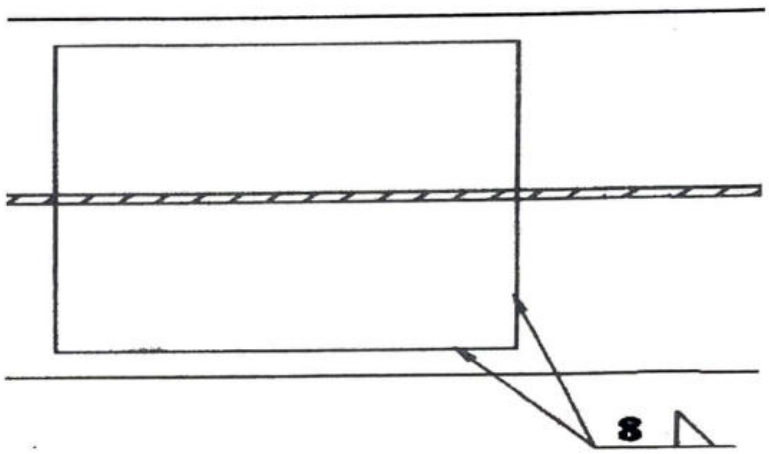
Executive Engineer/C
Construction Division-I/C

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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.

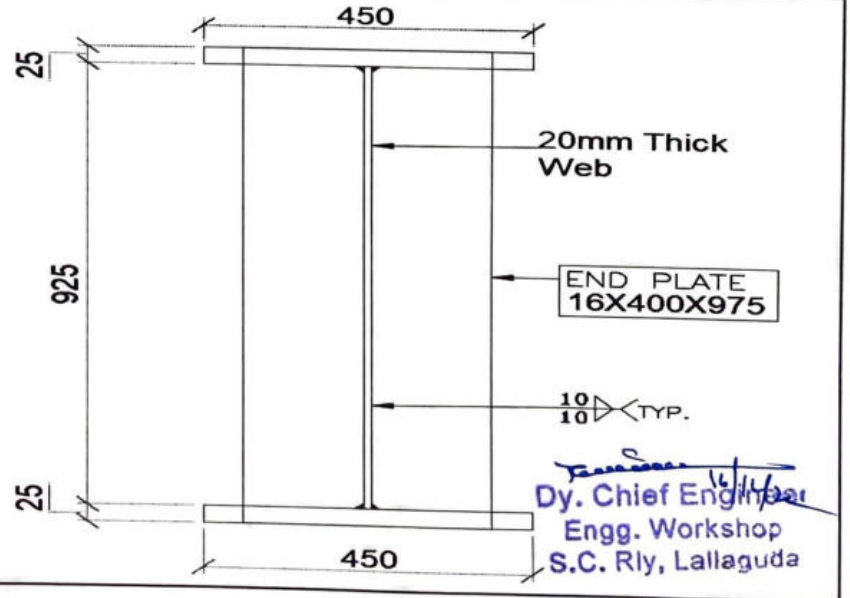
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/19
1	Drawing No.	:	RDSO/B-17181/13
2	Weld Joint description	:	Fillet 10mm (End Plate welding to Cross Girders)
3	Base Metal	:	IS:2062:2011, Gr E250B0 (16MM X 20MM)
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	:	
	Drying Method	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique		

सहायक अनुसंधान अधिकारी (वाहु
Assistant Research Officer (M
रेल मन्त्रालय भारत सरकार

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

जे. श्रीनिवास राव/J. Srinivas Rao
मुख्य महाप्रबंधक(नि)/Sr.Dy.General Manager(C)

Executive Engineer
Construction Division

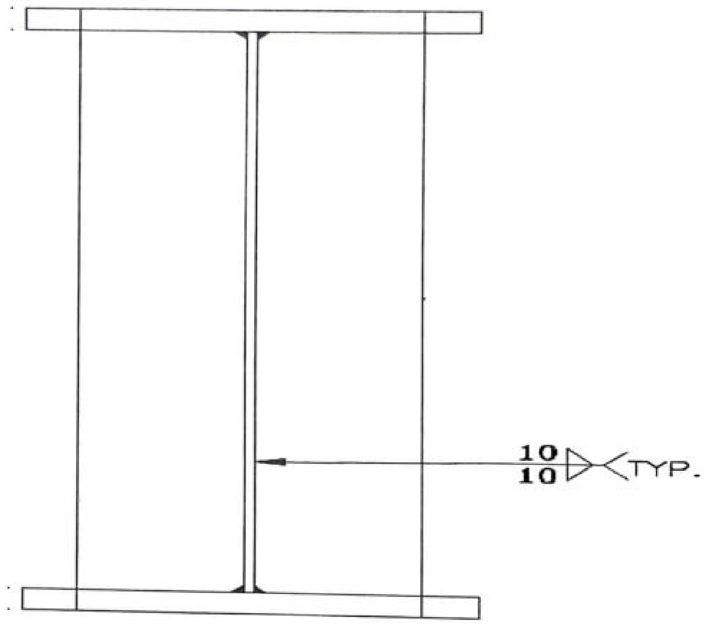
Appendix-V (Ref.Cl.26 of BI-2001)

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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 :



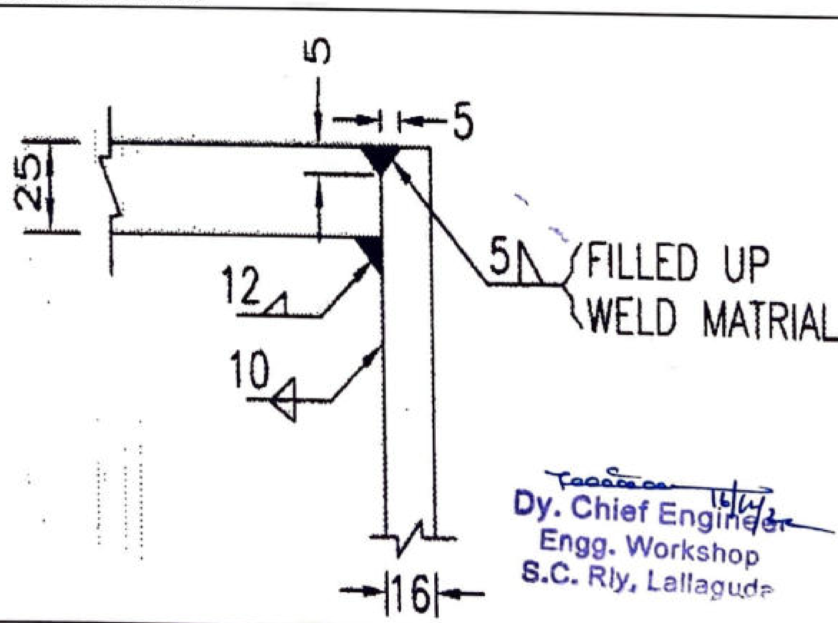
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld 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.

Assistant Research Officer

Dy. Chief Engineer
Engg. Workshop
S.C. Rly.

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/20
1	Drawing No.	:	RDSO/B-17181/13 (Detail "Y")
2	Weld Joint description	:	Single Bewel Welding of End Plate with Cross Girder & Fillet 12mm
3	Base Metal	:	IS:2062:2011, Gr E250B0 (16MM X 25MM)
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	:	
6.3	Shielding Gas	:	CO_2
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Assistant Research Officer

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

L. Srinivas Rao
Sr.Dy.General Manager(C)

Executive Engineer/
Construction Division-I/C

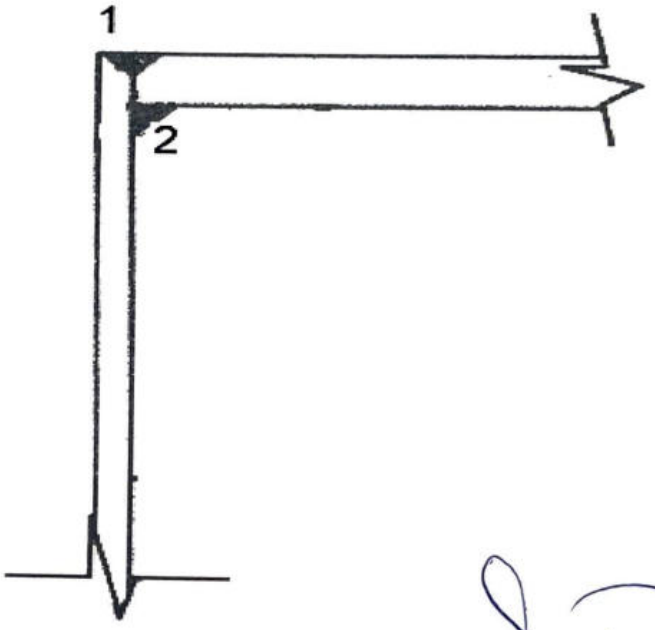
Appendix-V (Ref.Cl.26 of BI-2001)

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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	:	1, 2



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.

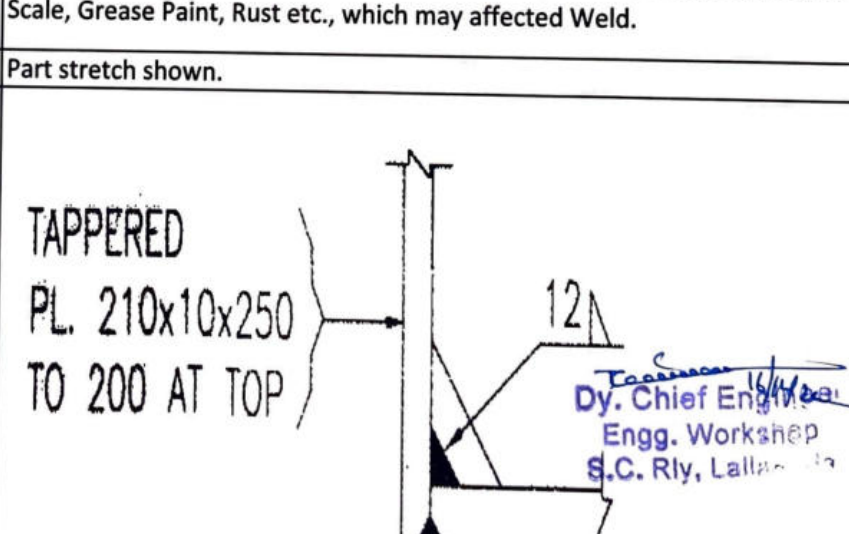
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/21
1	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)
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	:	
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, 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.,)		
7.2	Joint preparation	:	As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3& WBC - 2001
8	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

Executive Engineer
Construction Division
5x800 MW, YTPS, Veerla

J. Srinivas Rao
Sr.Dy.General Manager(C)
RITES LIMITED

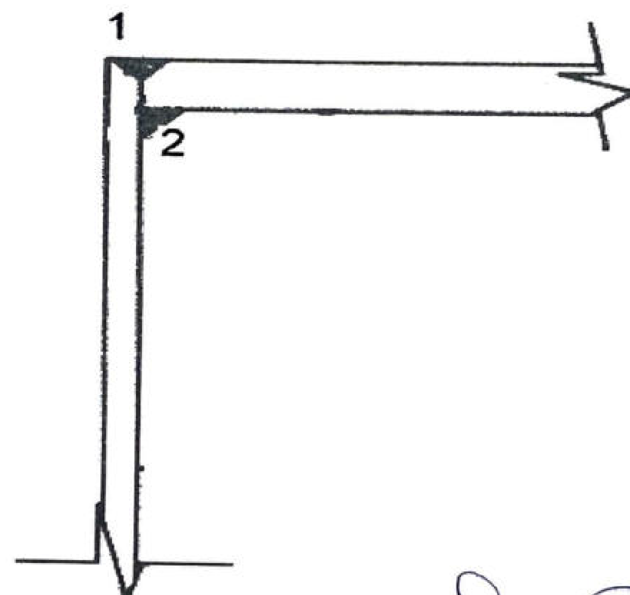
Appendix-V (Ref.Cl.26 of BI-2001

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/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 Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

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: 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/MMAW/22
1	Drawing No.	:	RDSO/B-17181/R
2	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		
6.1	Electrode/Wire Class Type Drying Method	: : :	A2 of IRS M28-2012 Medium Coated. As recommended by the Electrode Manufacturer.
6.2	Flux		
	Class Type Drying Method	: : :	N.A
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 weld 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, Cl.7, IRS B1 – 2001, Cl. 17.3
8.0	Welding Current		
	Type	:	DC
	Polarity	:	Reverse
9.0	Welder Qualification	:	As per IS 7310 (Part-I) – 1974
10.0	Welding parameters and technique	:	

Assistant Research Officer (M

Dy. Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

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)	Wire Feed Speed (m/min)	Travel Speed (m/min)	Electrical Stick out (mm)	Gas Flow (l/min)
1	4	180-210	24-27	N.A.	N.A.	N.A.	N.A.

10.2	Welding Sequence and technique	:	
11.0	Provision of run-on/run-off tabs	:	N.A.
12.0	Cleaning of weld bead before laying of next weld bead	:	N.A.
13.0	Root preparation before welding other side of groove weld	:	N.A.
14.0	Preheating and inter pass temperature	:	N.A.
15.0	Peening	:	N.A.
16.0	Post weld treatment	:	N.A.
17.0	Rectification of weld defect	:	By re-welding after complete removal of defective weld.
18.0	Inspection of weld	:	Visual, D.P. Test.
19.0	Any other relevant detail	:	None.

Assistant Research Officer (M

Dy. Chief Engineer