

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.

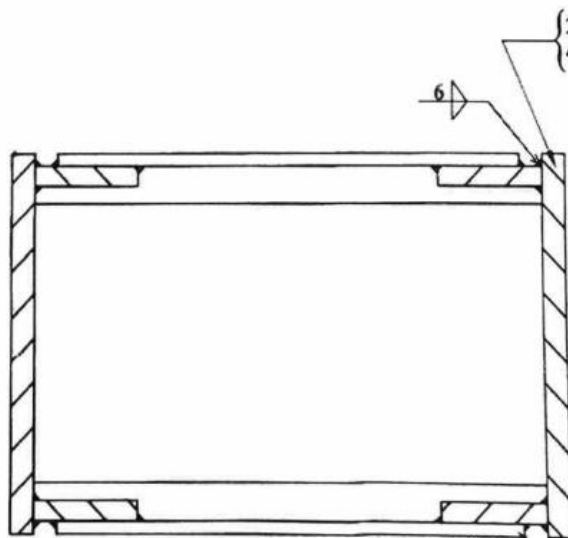
Model WPSS for
Railway OPEN WEB GIRDER
(25t Loading)

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)

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.,)	:	 <p>2 SIDE PL.s. 300x20 4 FL. PL.s. 90x16</p> <p>6</p> <p>Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	

ज. श्री निवास राव/J. Srinivas Rao

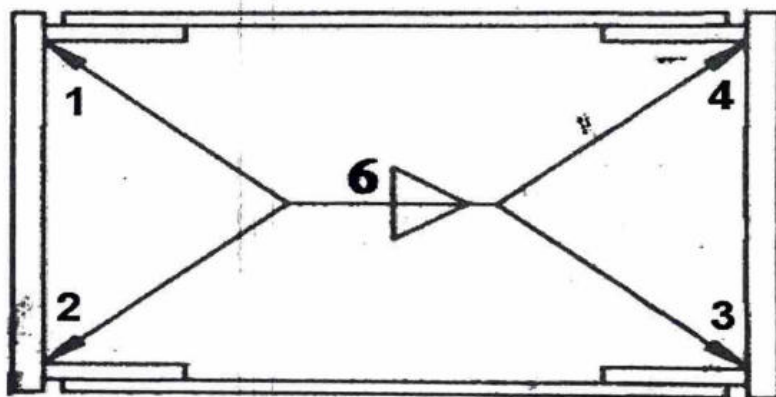
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL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

12/11/2025
Research Officer (M)
S.C. Rly, Lallagoda

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

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

Name and address of Fabricator	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Mandal, Medak Dist.
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Welding Procedure specification No.	: GSC/22/SRC-30.5M/WPSS/SAW/02
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1	Drawing No.	RDSO/B-17166/R, Section A-A
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2	Weld Joint description	:	Fillet 6mm (Top Chord)
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3	Base Metal	:	IS:2062:2011, Gr E250B0 (10MMX10MM)
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4	Welding Process	:	SAW
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5	Welding Position	:	1F
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6	Welding Consumable
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6.1	Electrode/Wire
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Class : W1 of IRS M.39/2001.

Type : Copper coated Mild Steel Wire.

Drying Method	:	N.A.
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6.2	Flux
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Class	:	F1 of IRS M.39-2001
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Type	:	Agglomerated
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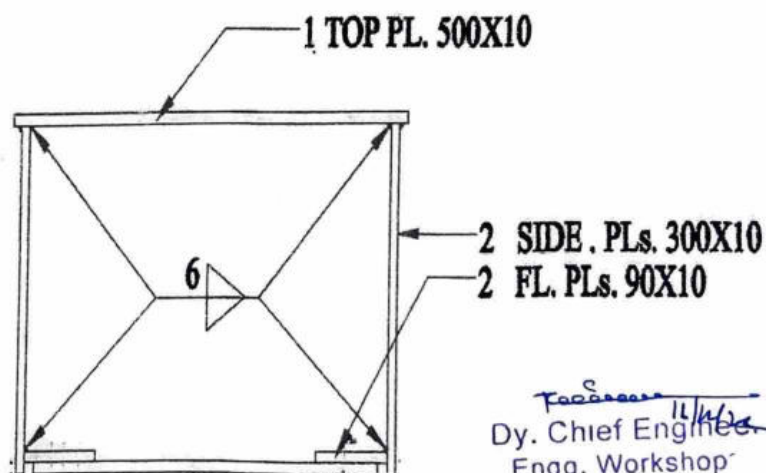
Type	: Agglomerated
Drying Method	: 250 C for one hour before uses OR Recommendation as per manufacturer.

6.3	Shielding Gas
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7	Base metal preparation
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7.1	Joint design details
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(Sketch showing arrangements of parts, weld groove details, weld passes & their sequence etc.,)



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

7.2	Joint preparation	: As per IS 4353 -1995, Cl.7, IRS B1 – 2001, Cl. 17.3 & WBC - 2001
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7.2	Welding Current	Type	:	DC
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Type	:	DC
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Polarity	:	Reverse
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ज. ४। As per IS: 7310 (Part-I) - 817

व रूपः मर्यादाबंधक (वि) / S.D.C.

4.3.14. 4.3.14.10 (M)/Sr. Dy. General Manager(C

Executive Engineer/Divi

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.

A diagram of a rectangular frame structure. The frame consists of four vertical members and four horizontal members. The vertical members are labeled 1, 2, 3, and 4 from left to right. The horizontal members are labeled 5, 6, 7, and 8 from top to bottom. The frame is divided into four quadrants by the central horizontal member (6) and the central vertical member (3). The quadrants are labeled 1, 2, 3, and 4 from top-left to bottom-right. The central horizontal member (6) is shown with a triangular cross-section, indicating it is a beam. The frame is supported by a foundation at the bottom, with a central support point labeled 9.

Terrasa
Dy. Chief Engineer
Engg. Workshop

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.

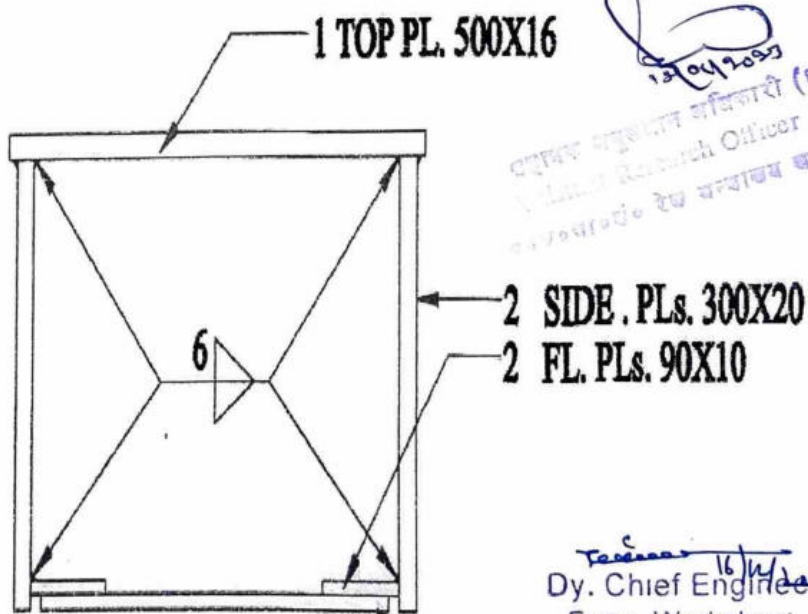
6.3 Shielding Gas : NA

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.,)



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

7.2 Joint preparation

: As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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

Executive Engineer

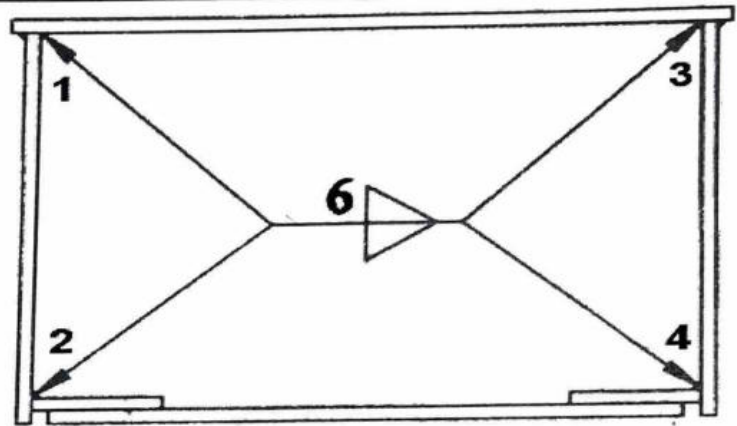
Construction Division

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



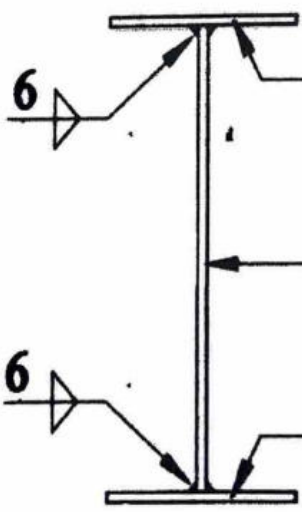
11	Provision of run-on/run-off tabs	: Yes
12	Cleaning of weld bead before laying of next weld bead	: N.A.
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 150°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld 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

12/01/2022
 Dy. Chief Engineer.
 Engg. Workshop
 S.C. Ry, Lallaguda

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, CI.7, IRS B1 - 2001, CI. 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
 Dy. Chief Engineer (M)
 Research Officer (M)
 S.C. Rly, Lallaguda

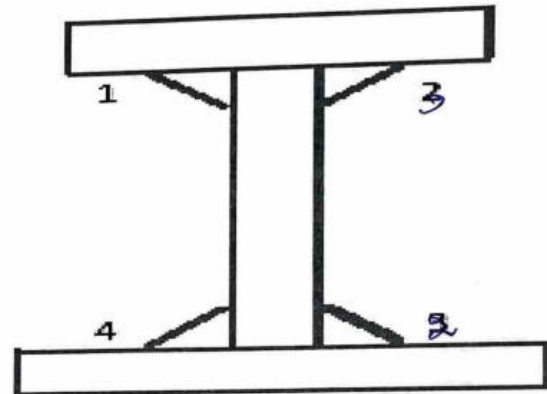
16/1/22
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

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

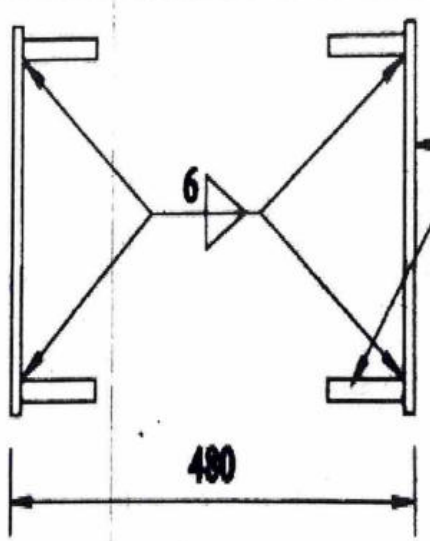
12/04/2022
 Dy. Chief Engineer (M)
 S.C. Rly, Lallaguda

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

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.,)	 <p>2 SIDE . PL. 300X12 4 FL. PL. 90X16</p> <p>400</p>	
7.2	Joint preparation	: As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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

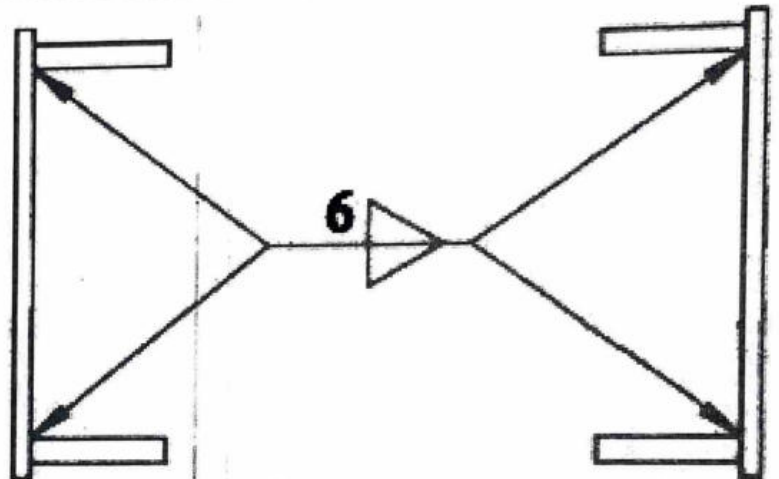
Executive Engineer/Civil
Construction Division-I/CC-11
5x800 MW, YTPS, Veerapalem (V)

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.

19/04/22
 Dy. Chief Engineer (M)
 Research Officer (M)
 S.C. Rly, Lallaguda

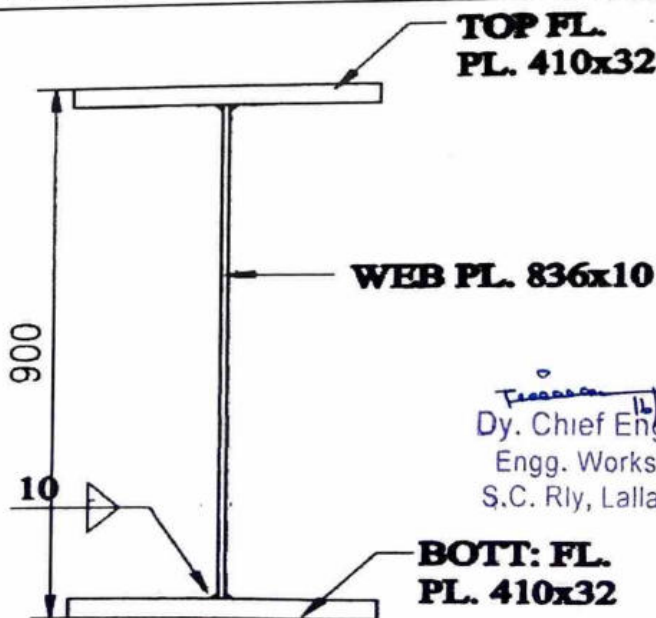
Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

STEEL CO.

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	:	W1 of IRS M.39/2001.
Class	:	Copper coated Mild Steel Wire.
Type	:	N.A.
Drying Method	:	
6.2 Flux	:	F1 of IRS M.39-2001
Class	:	Agglomerated
Type	:	250 C for one hour before uses OR Recommendation as per manufacturer.
Drying Method	:	
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.,)	:	 <p>TOP FL. PL. 410x32</p> <p>WEB PL. 836x10</p> <p>900</p> <p>10</p> <p>BOTT: FL. PL. 410x32</p> <p>Dy. Chief Engineer. Engg. Workshop S.C. Rly, Lallaguda</p>
7.2 Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	

Executive Engineer/Civil
Construction Division I/CC-II

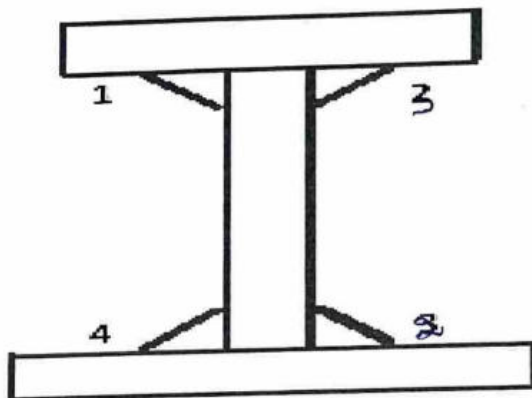
J. Srinivas Rao
5000 MW, YTPS, Veerapalem (V)
Damacherla (M) Nellore (DL) 502 355

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



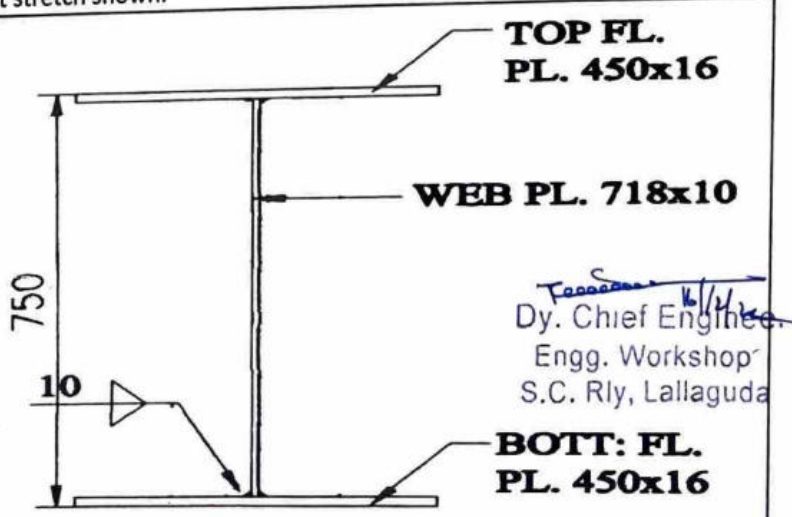
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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.

13/04/2023
 Dy. Chief Engineer (M)
 Assistant Research Officer (M)
 S.C. Rly, Lallaguda

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

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.

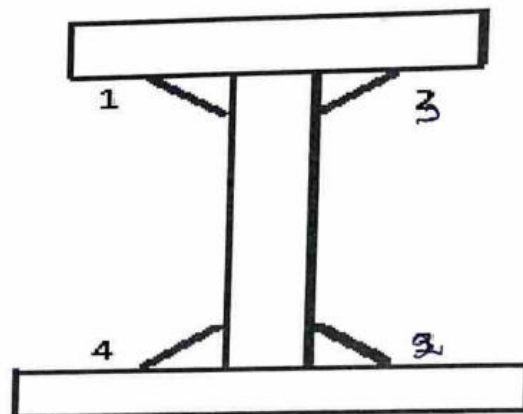
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-30.5M/WPSS/SAW/07
1	Drawing No.	:	RDSO/B-17173 (Section B-B) & RDSO/B-17161(Stringer)
2	Weld Joint description	:	Fillet 10mm (Stringer)
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	:	W1 of IRS M.39/2001.
	Class	:	Copper coated Mild Steel Wire.
	Type	:	N.A.
	Drying Method	:	
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.,).		 <p>TOP FL. PL. 450x16</p> <p>WEB PL. 718x10</p> <p>BOTT: FL. PL. 450x16</p> <p>Dy. Chief Engineer. Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

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

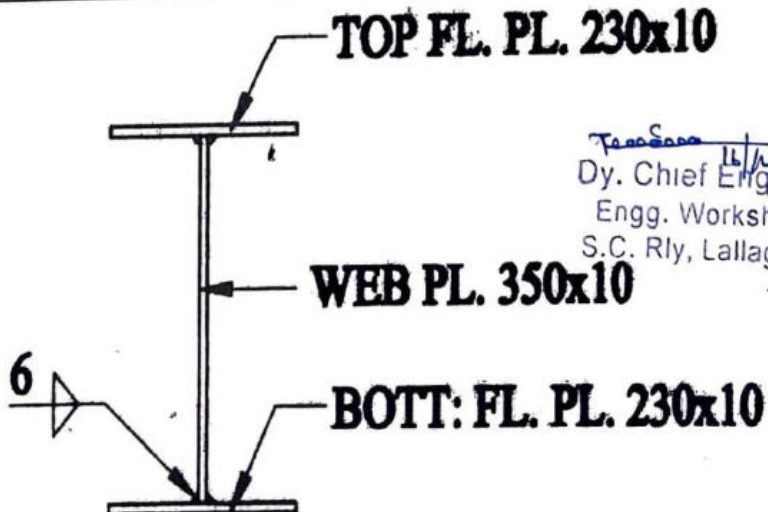


11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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.

13/01/2023
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

"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.

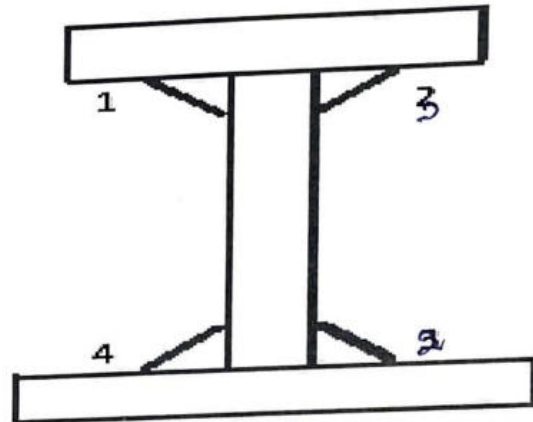
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-30.5M/WPSS/SAW/08
1	Drawing No.	:	RDSO/B-17167/R & RDSO/B-17161(Portal Girder U ₁ -U ₁ ¹)
2	Weld Joint description	:	Fillet 6mm (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	:	W1 of IRS M.39/2001.
	Class	:	Copper coated Mild Steel Wire.
	Type	:	N.A.
	Drying Method	:	
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.,).		 <p>TOP FL. PL. 230x10</p> <p>WEB PL. 350x10</p> <p>BOTT: FL. PL. 230x10</p>
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	:	

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 J. 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

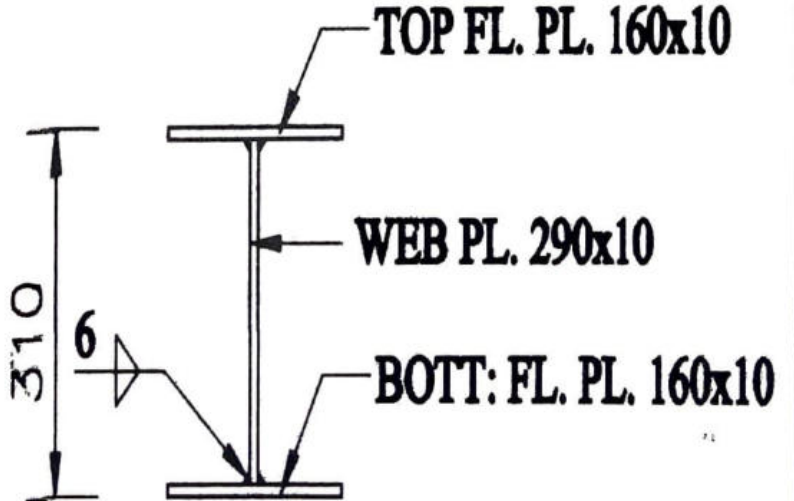


11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld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

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 ($U_2-U_1^1$, $U_3-U_1^1$))
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, CI.7, IRS B1 - 2001, CI. 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

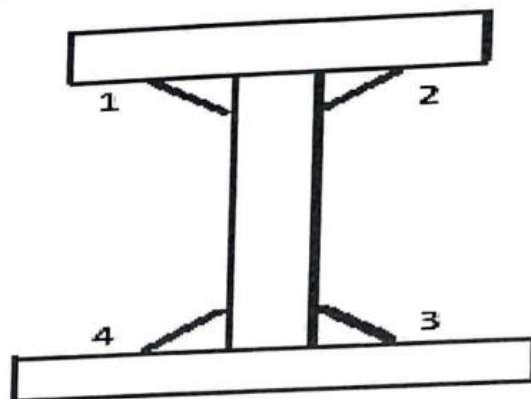
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE D. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL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

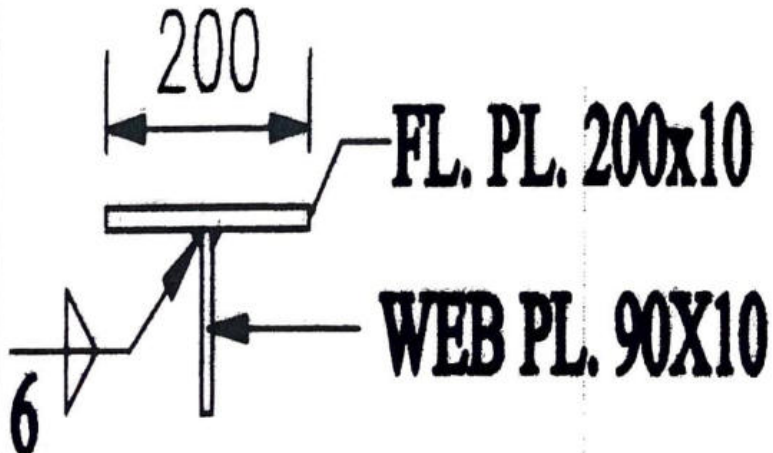


11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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

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, CI.7, IRS B1 – 2001, CI. 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

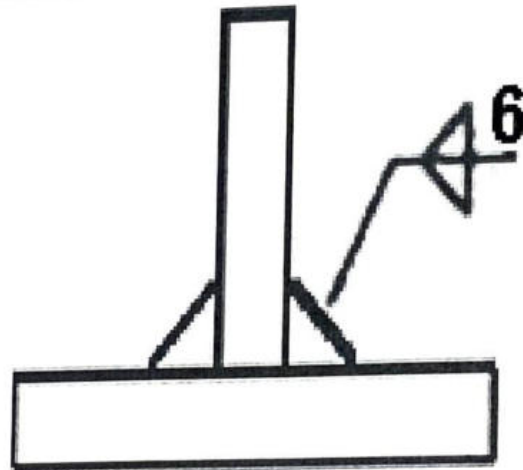
Engg. Workshop

S.C. Rly, Lallaguda

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

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.

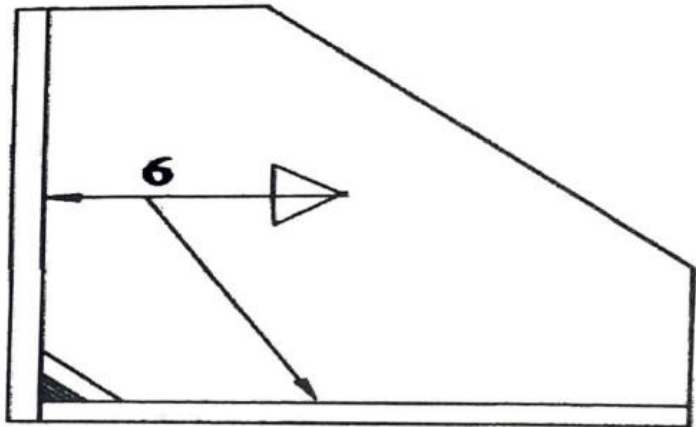
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-30.5M/WPSS/GMAW/11
1	Drawing No.	:	RDSO/B-17172 (Detail at "H")
2	Weld Joint description	:	Fillet 6mm (Rib Plate)
3	Base Metal	:	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.,)	:	<p>RIB PL. 190x10x190</p> <p>200</p> <p>6</p> <p>200</p> <p>Dy. Chief Engg. Workshop S.G. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	श्रीनिवास राव/J. Srinivas Rao

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 :

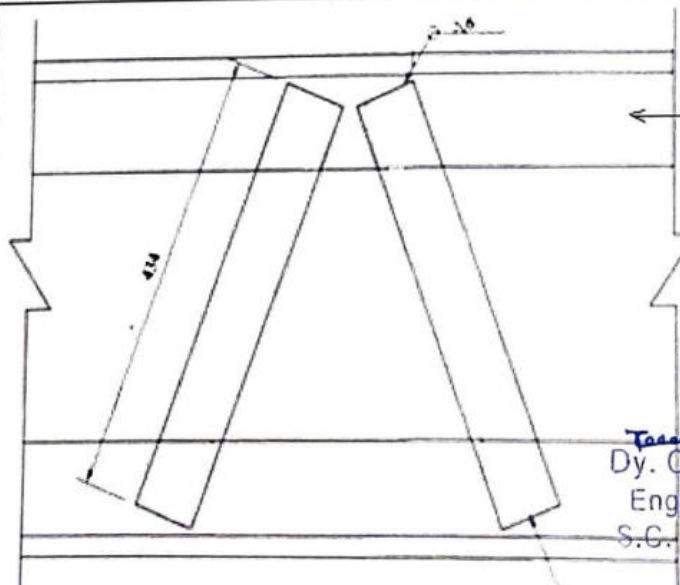


11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld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

16/1/22
Dy. Chief Engineer.
Engg. Workshop
S.C. Rly, Lallaguda

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 : 1 of IRS M.46	
	Type	: 1.2mm MIG Wire	
	Drying Method	: N.A.	
6.2	Flux	Class : N.A	
	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.,)	 <p>Flat 90x10mm</p> <p>414</p> <p>EXECUTED BY: S.C. Rly, Lallaguda</p>	
7.2	Joint preparation	: As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001	
8	Welding Current	Type : DC	
	Polarity	: Reverse	
9	Welder qualification	: As per IS 7310 (Part-I) - 817	
	Welding parameters and technique	: As per IS 7310 (Part-I) - 817	

Executive Engineer/Civil
Construction Division-I/CO-II
Srinivas Rao 5x800 MW, YTPS, Veerapalem (V)

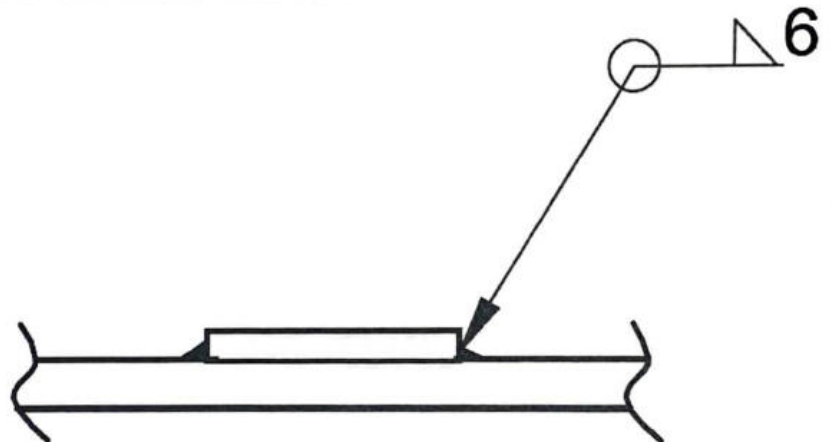
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 37/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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

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

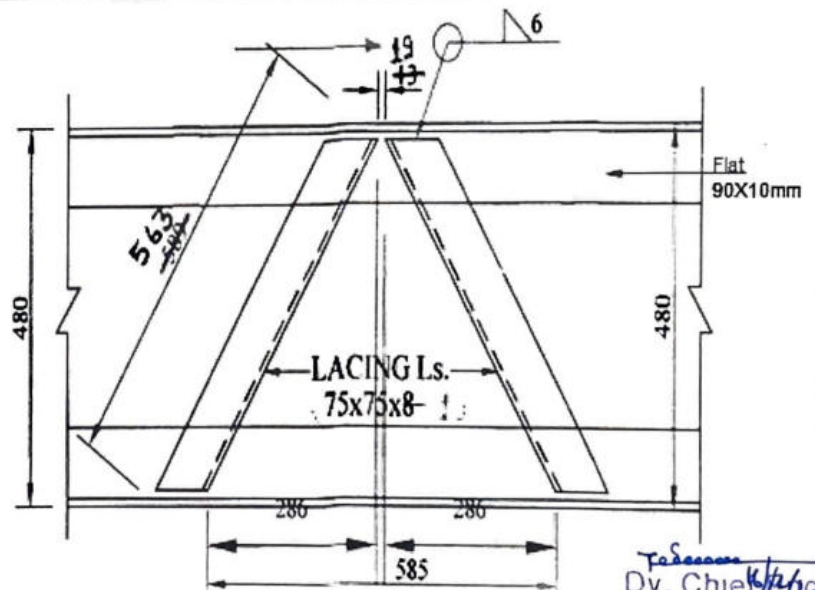
Class :
Type : N.A
Drying Method :

6.3 Shielding Gas : 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
Rly, Lallaguda

Executive Engineer/Civil
Construction Division I/CC-II

5-800 MW, YTPS, Veerapalem (V)
Damodaram (M), Malavada (D) 502 355

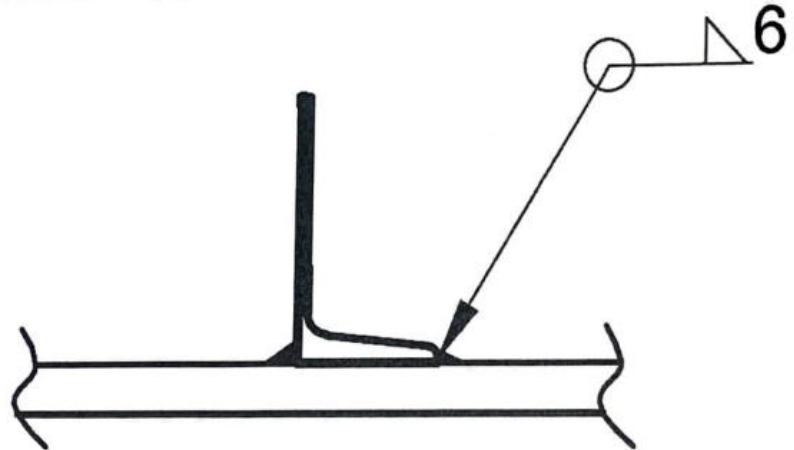
श्रीनिवास राव/J. Srinivas Rao
अध्यक्ष, यूपीएस (यु.पी.एस.)

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.

13/01/2020
 Assistant Research Officer (M)
 10304000-250 K. Narayana Murthy

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

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.

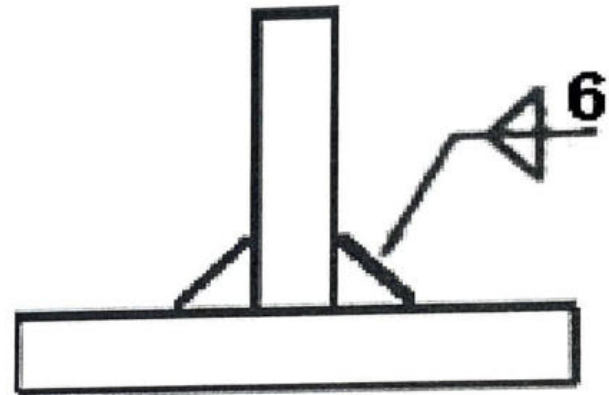
Name and address of Fabricator		: M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.	
Welding Procedure specification No.		: GSC/22/SRC-30.5M/WPSS/GMAW/14	
1	Drawing No.	: RDSO/B-17165/R (Section A-A)	
2	Weld Joint description	: Fillet 6mm (Diaphragm Plate welding 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	: N.A	
	Type	: N.A	
	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	: 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, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001	
8	Welding Current		
	Type	: DC	
	Polarity	: Reverse	
	Welder Qualification	: As per IS 7310 (Part-I) - 817	
	Welding parameters and technique	<p>Executive Engineer/Civil Construction Division I/CC 5x200 MW VTDG, Medak Dist.</p> <p>ज. श्रीनिवास राव/J. Srinivas Rao</p>	

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.

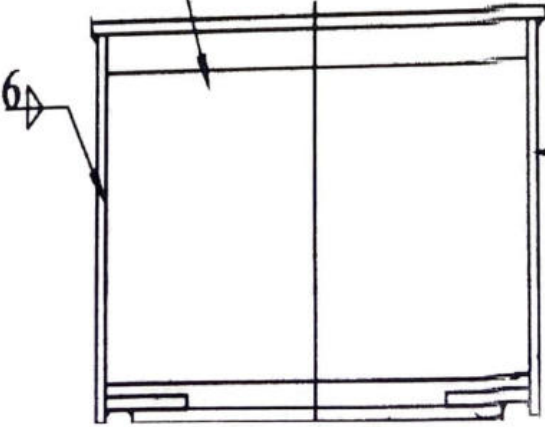
[Signature]
Assistant Research Officer (M)
S.C. Rly, Lallaguda

[Signature]
Jy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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.,)		<p>DIAPHRAGM</p> <p>1 PL. 240x10x460</p>  <p>2 SIDE PL. 300x10</p> <p>Dy. Chief Engineer. Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	

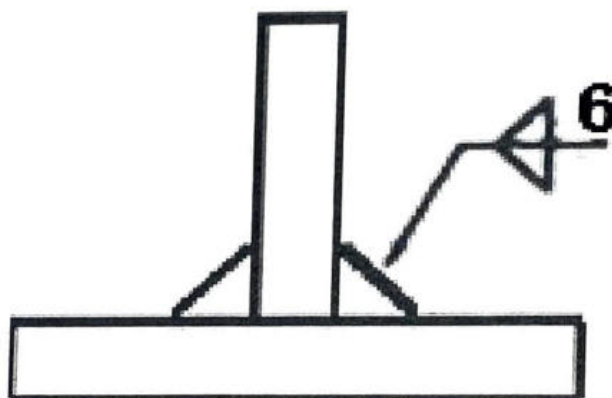
Executive Engineer/Civil
Construction Division-I/CC-II

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 :



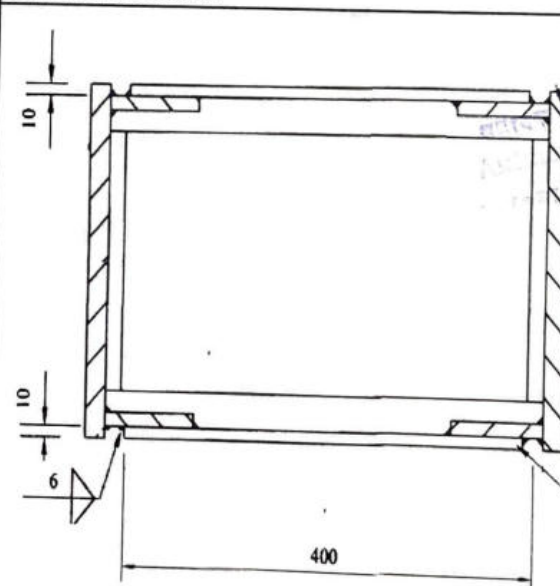
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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.

12/1/2022
 Dy. Chief Engineer

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.

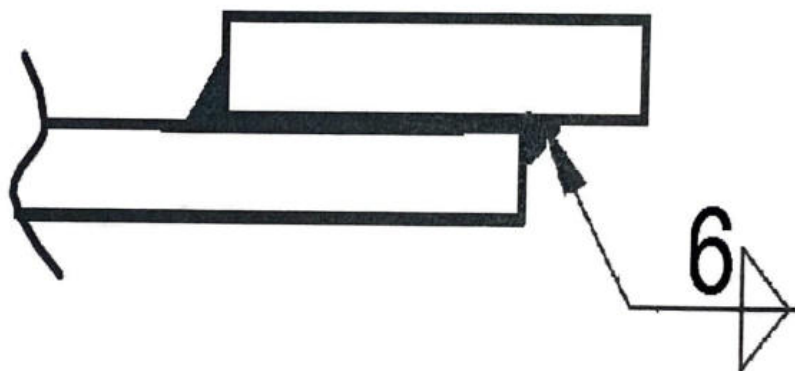
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY, Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-30.5M/WPSS/GMAW/16
1	Drawing No.	:	RDSO/B-17165/R, Section A-A & B-B
2	Weld Joint description	:	Fillet 6mm (Batten Plate welding 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, CI.7, IRS B1 - 2001, CI. 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	:	

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 CI.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.

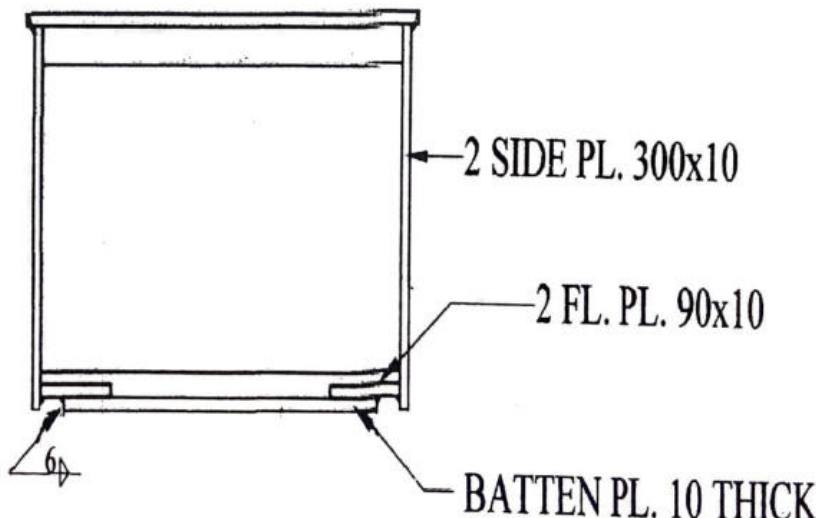
12/01/2020
 Dy. Chief Engineer (R&D)
 Assistant Research Officer (M)
 S.C. Rly, Lallaguda

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

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	:	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, CI.7, IRS B1 - 2001, CI. 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

Lallaguda

Executive Engineer/Civil

Construction Division-I/CC

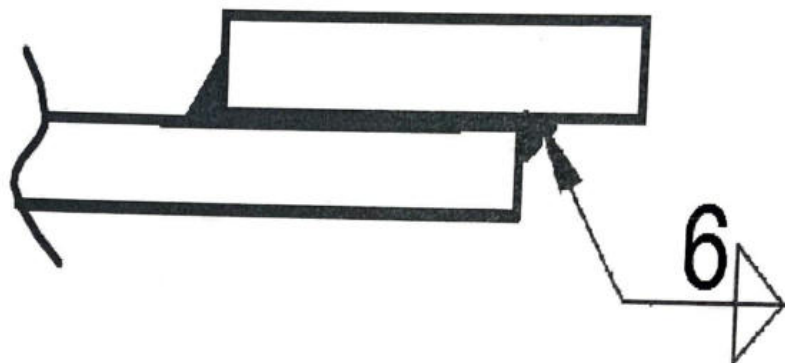
VTPS, Veerlaudem (V)

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 CI.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.

12/01/2020
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

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	:	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.,)	:	<p>PAD PL. 350X10X350</p> <p>410</p> <p>Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallagud</p>
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	:	

10/11/2018
Chief Research Officer (M)
S.C. Rly, Lallagud

Executive Engineer/Civil

Construction Division-I/CC-I

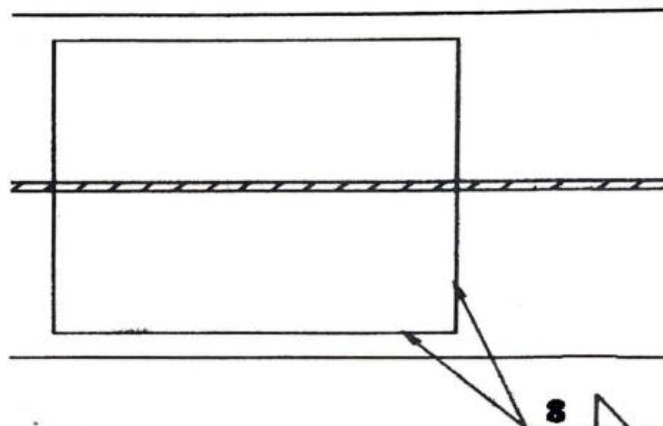
5x800 MW, YTPS, Veerapalem (V)

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 CI.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.

Signature of Dy. Chief Engineer
Assistant Research Officer (I)
S.C. Rly, Lallaguda

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

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 : 1 of IRS M.46
Type : 1.2mm MIG Wire
Drying Method : N.A.

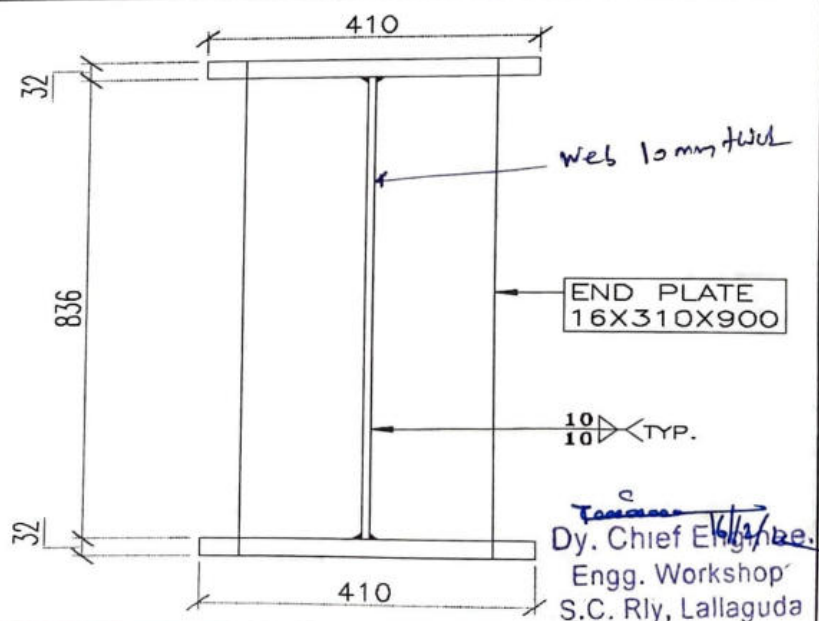
6.2 Flux
Class :
Type : N.A
Drying Method :

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

9 Welder Qualification : As per IS 7310 (Part-I) - 817
Polarity : Reverse

10 Welding parameters and technique : J. Srinivas Rao
Sr Dy General Manager (C)

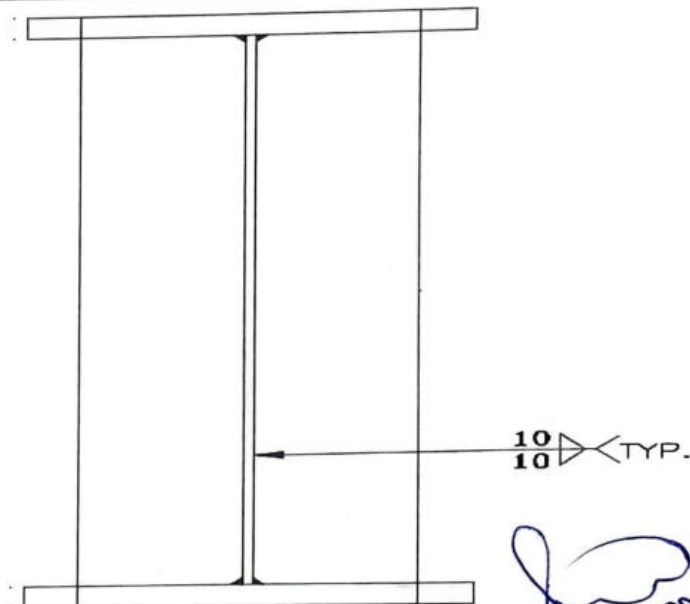
Executive Engineer/Civil
Construction Division-I/CC-1
5x800 MW, YTP-3, Veerlapalem (V)

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 CI.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.

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

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/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.,)		<p>PL. OF CROSS GIRDER</p> <p>5</p> <p>10</p> <p>32</p> <p>FILLED UP BY WELD MATERIAL</p> <p>END PL. OF CROSS GIRDER 16 THICK</p> <p>Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	निवास राव/J. Srinivas Rao

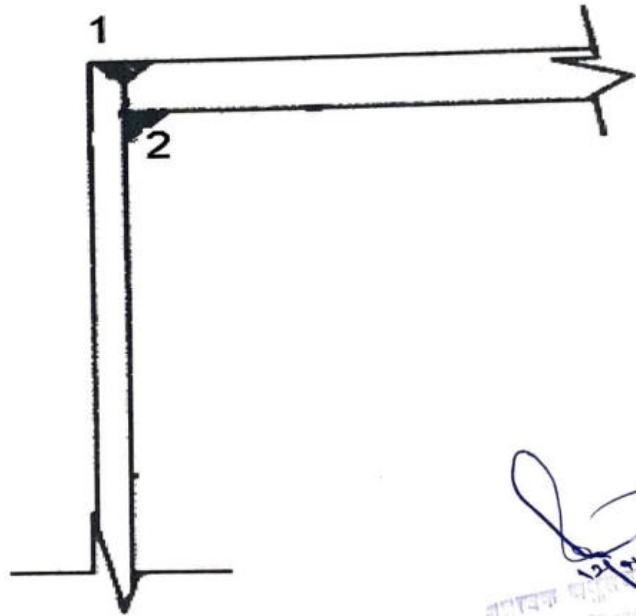
Executive Engineer/Civil
Construction Division-I/CC-1
5x800 MW, YTPS, Veerlaipalem (V)

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 7/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL - VISHNUPURAM 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



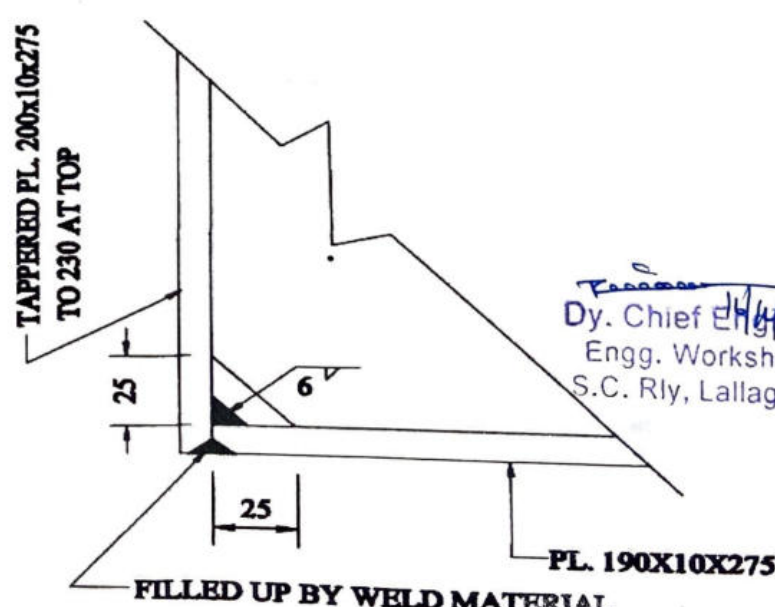
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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.

[Signature]
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

WELDING PROCEDURE SPECIFICATION SHEET

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

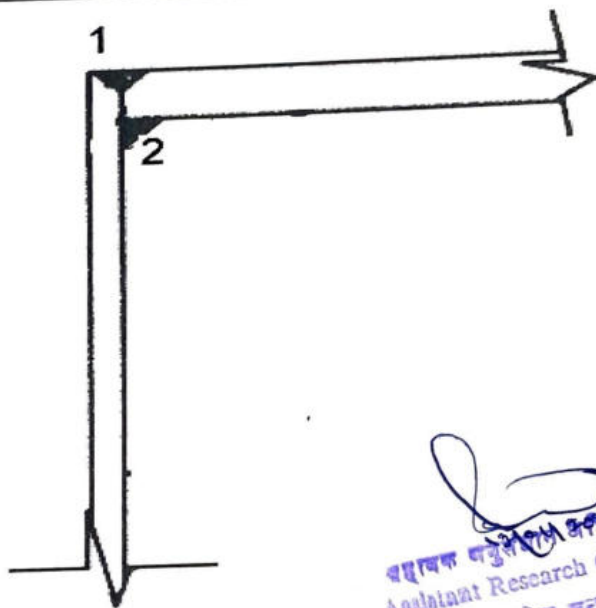
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL - 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, CI.7, IRS B1 - 2001, CI. 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	:	

10.1 Welding parameters :

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
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आश्विनक नवमि

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.

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	:	
	Type	:	N.A
	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, CI.7, IRS B1 – 2001, CI. 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	:	

13/04/2008
 Research Officer (M)
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

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

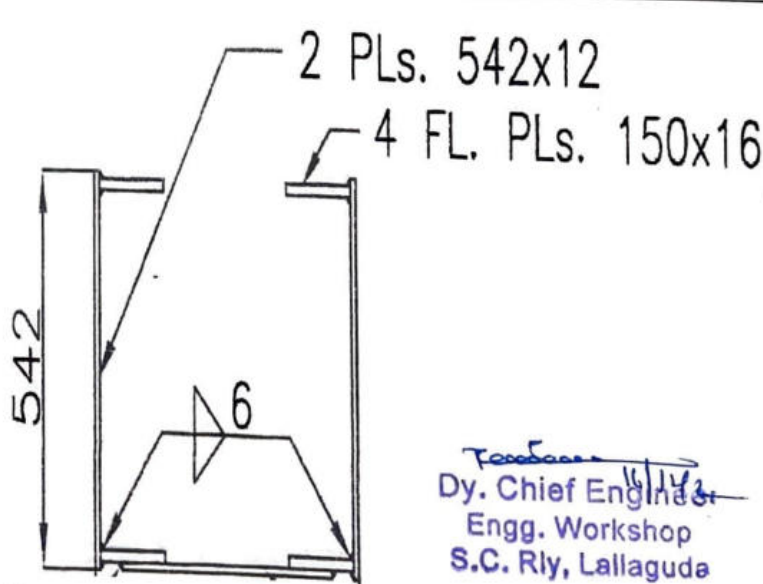
45.7m clear span

MODEL WPSS No- RDSO/ Infra-II/ B&S/ RG/
OWG./ WPSS / 45.7 series (22 nos)

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.

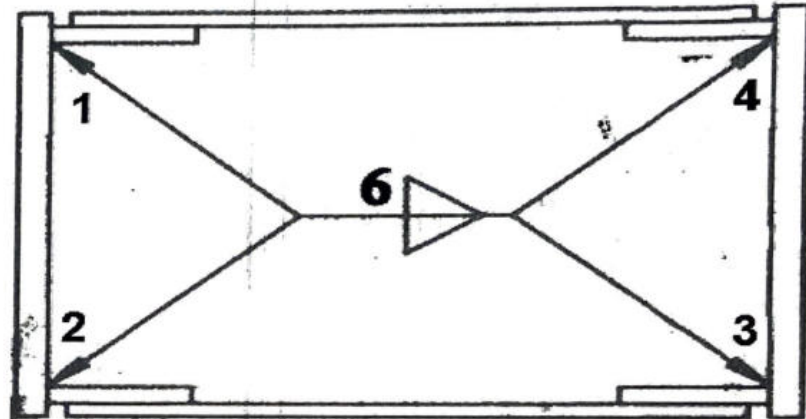
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/SAW/01
1	Drawing No.	:	RDSO/B-17181/4/R, Section A-A
2	Weld Joint description	:	Fillet 6mm (Bottom Chord, L0-L1 & L1-L2)
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.,)	:	 <p>2 PLs. 542x12 4 FL. PLs. 150x16</p> <p>542</p> <p>6</p> <p>Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	

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

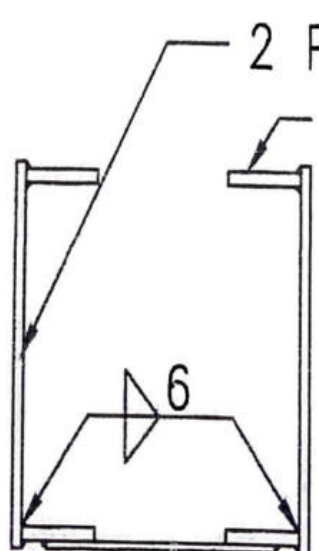
[Signature]
 Assistant Research Officer (M)
 S.C. Rly, Lallaguda

[Signature]
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda



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

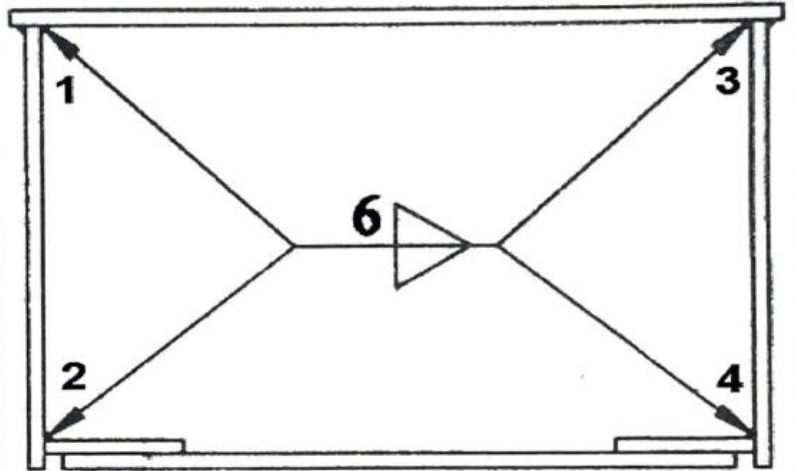
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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.,)	:	 <p>2 PLs. 542x20 4 FL. PLs. 150x25 6</p> <p><i>Tejaswini</i> Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse <i>J-S</i>
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	<i>Srinivas Rao</i> Sr.Dy.General Manager(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 (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

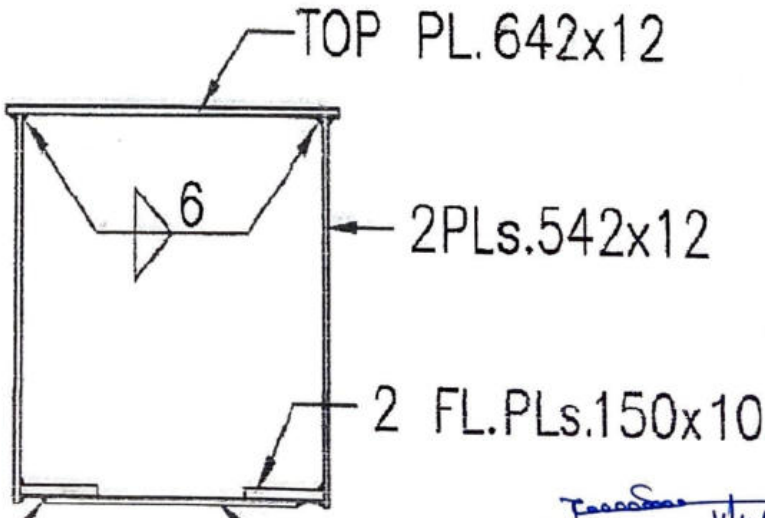
11	Provision of run-on/run-off tabs	: Yes
12	Cleaning of weld bead before laying of next weld bead	: N.A.
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 150°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld defect	: By re-welding after complete removal of defective weld & rectifying the weld as per CI.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

[Signature]
 Assistant Research Officer (M)
 S.C. Rly, Lallaguda

[Signature]
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

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

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN 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/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, CI.7, IRS B1 – 2001, CI. 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
Sr Dy General Manager (S)

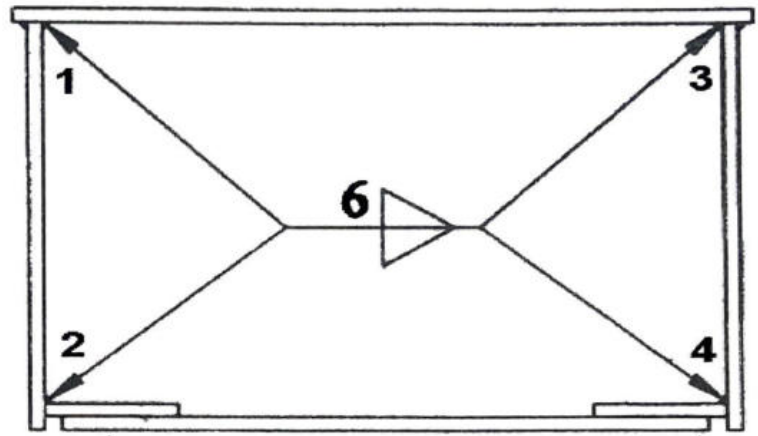
Executive Engineer

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

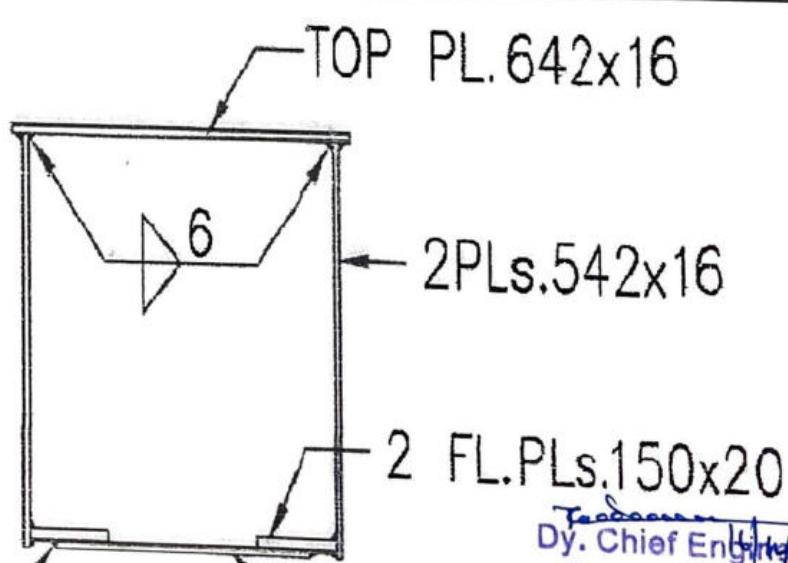


11	Provision of run-on/run-off tabs	: Yes
12	Cleaning of weld bead before laying of next weld bead	: N.A.
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 150°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld 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

[Signature]
Dy. Chief Engineer

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, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS:7310 (Part-I) – 817
10	Welding parameters and technique	:	ज. श्रीनिवास राव/J. Srinivas Rao

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

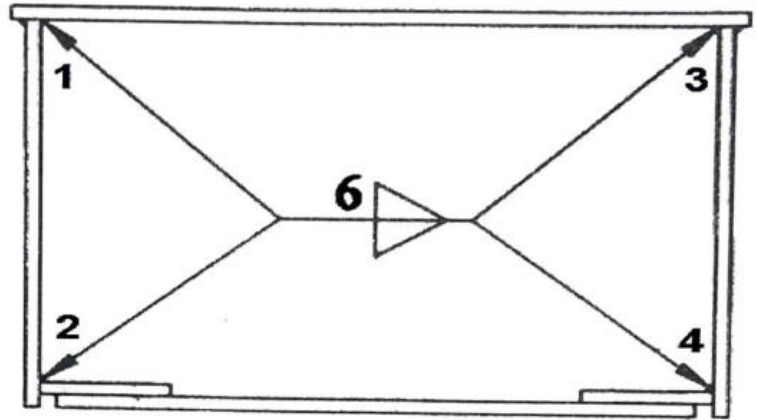
Executive Engineer

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



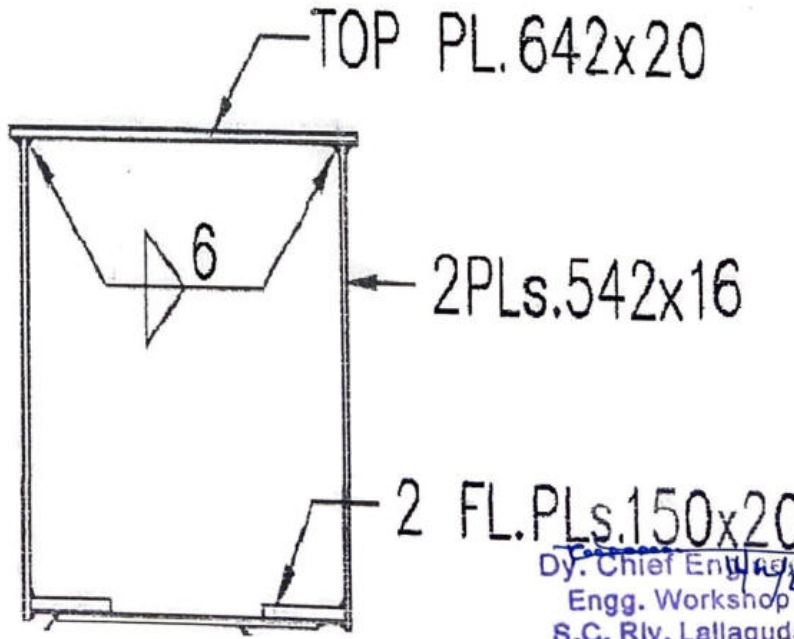
11	Provision of run-on/run-off tabs	: Yes
12	Cleaning of weld bead before laying of next weld bead	: N.A.
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 150°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld 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 (M)
 S.C. Rly, Lallaguda

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

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

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN 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 : Type : Drying Method :	W1 of IRS M.39/2001. Copper coated Mild Steel Wire. N.A.
6.2	Flux	Class : Type : Drying Method :	F1 of IRS M.39-2001 Agglomerated 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.,)	:	 <p>TOP PL. 642x20</p> <p>2PLs. 542x16</p> <p>2 FL.PLs. 150x20</p> <p>6</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	Type : Polarity :	DC Reverse
9	Welder Qualification	:	As per IS 7310 (Part I) – 1974
10	Welding parameters and technique	:	

[Signature]
22/01/2020

Assistant Research Officer (M)

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

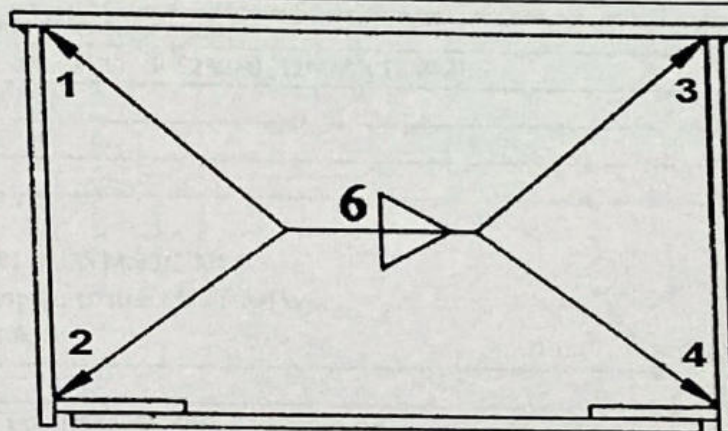
Executive Engineer
Construction Division-
5-800 MW YTPS, Veerla

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



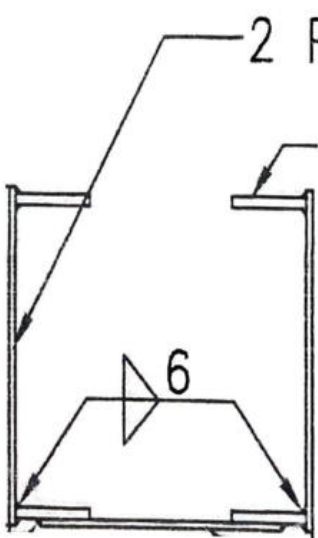
11	Provision of run-on/run-off tabs	: Yes
12	Cleaning of weld bead before laying of next weld bead	: N.A.
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 150°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld 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

Dr. Chief Engineer (M)
Assistant Research Officer (M)
Dr. Chief Engineer (M)
Dr. Chief Engineer (M)

Dr. Chief Engineer (M)
Dr. Chief Engineer (M)
Dr. Chief Engineer (M)
Dr. Chief Engineer (M)

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.

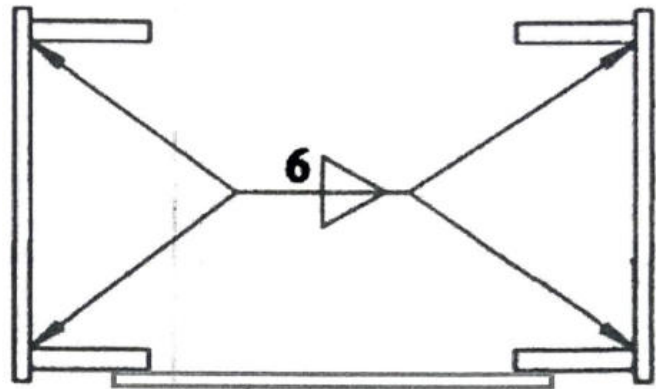
Name and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.	:	GSC/22/SRC-45.7M/WPSS/SAW/06
1 Drawing No.	:	RDSO/B-17181/R, Section U1-L2
2 Weld Joint description	:	Fillet 6mm (Diagonals)
3 Base Metal	:	IS:2062:2011, Gr E250B0 (12MM X 16MM)
4 Welding Process	:	SAW
5 Welding Position	:	1F
6 Welding Consumable	:	
6.1 Electrode/Wire	:	W1 of IRS M.39/2001.
Class	:	Copper coated Mild Steel Wire.
Type	:	N.A.
Drying Method	:	
6.2 Flux	:	F1 of IRS M.39-2001
Class	:	Agglomerated
Type	:	250 C for one hour before uses OR Recommendation as per manufacturer.
Drying Method	:	
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.,)	:	 <p>2 PLs. 400x16 4 FL. PLs. 100x12 6</p> <p align="right">Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda</p>
7.2 Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 17.3
8 Welding Current	:	
Type	:	DC
Polarity	:	Reverse
9 Welder Qualification	:	As per IS 7310 (Part-I) – 817
10 Welding parameters and technique	:	

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

10.1 Welding parameters :

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

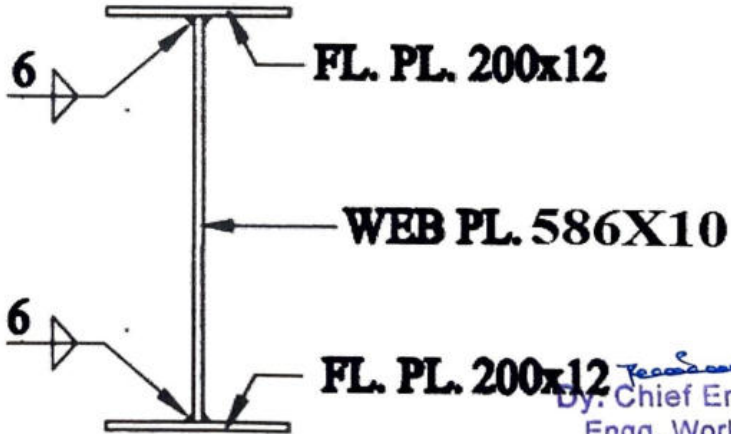


11	Provision of run-on/run-off tabs	: Yes
12	Cleaning of weld bead before laying of next weld bead	: N.A.
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 150°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld 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

[Signature]
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly. Lallaquda

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, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

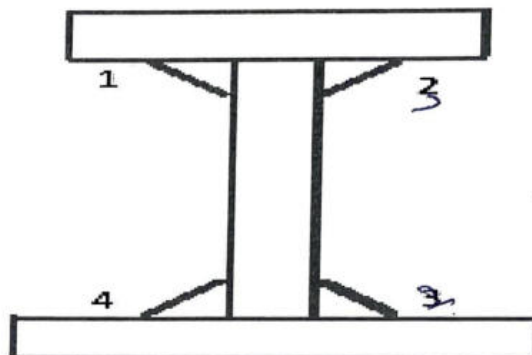
By: Chief Engineer
Engg. Workshop
S.C. Rly. Lallaguda

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – VISHNUPURAM STATIONS ON BN-NDKD SECTION OF GUNTUR DIVISION) OF SPAN (1 X 30.5m + 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.

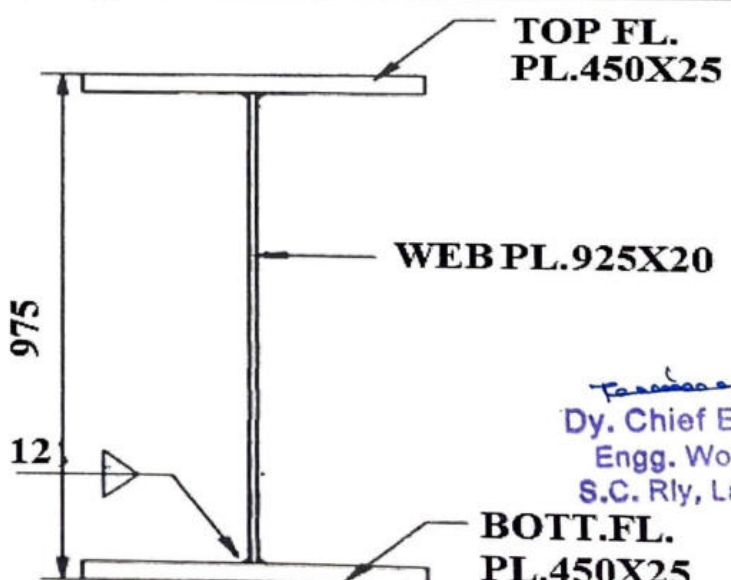
वर्तमान अनुसंधान अधिकारी (बाह्य)
Acadmic Research Officer (M)
अनुसंधान एवं रेल अनुसंधान केंद्र

Dy. Chief Engineer
Engg. Workshop

WELDING PROCEDURE SPECIFICATION SHEET

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

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

Name 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	:	W1 of IRS M.39/2001.
	Class	:	Copper coated Mild Steel Wire.
	Type	:	N.A.
	Drying Method	:	
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, CI.7, IRS B1 – 2001, CI. 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

BOTT.FL.
PL.450X25

975

12

WEB PL.925X20

TOP FL.
PL.450X25

Srinivas Rao

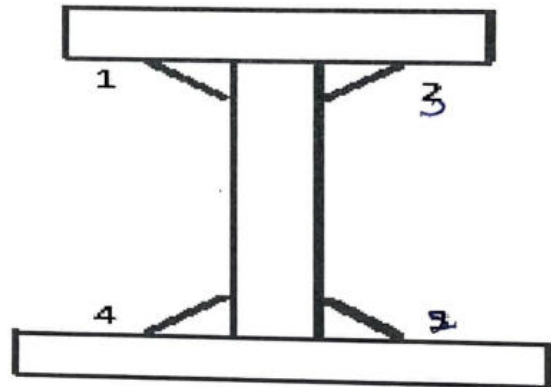
Executive Engineer

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 30.5m + 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



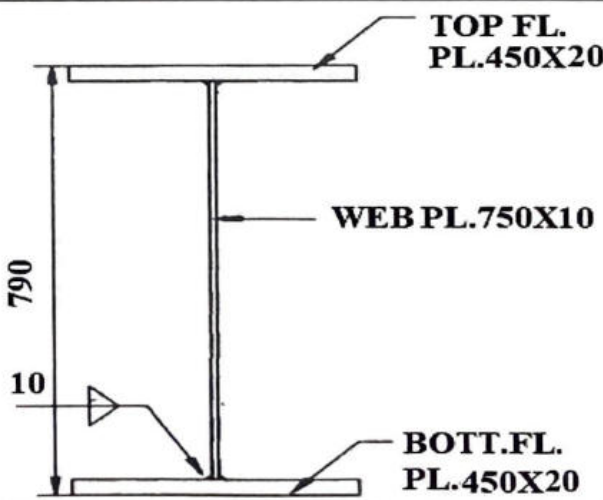
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld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

17 May 2023
 Dy. Chief Engineer (M)
 S.C. Rly. Lallaguda

16/4/23
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly. Lallaguda

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

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN 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, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

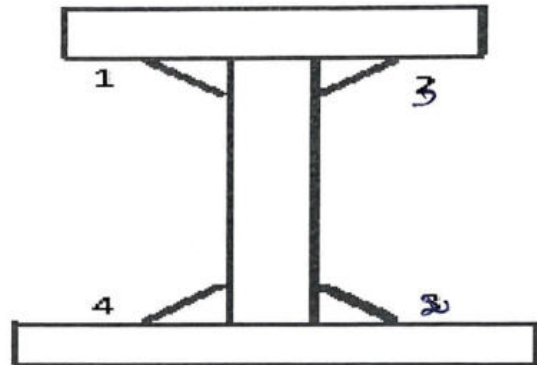
[Signature]
Dy. Chief Engineer
 Engg. Workshop
 S.G. Ry, Lallaguda

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



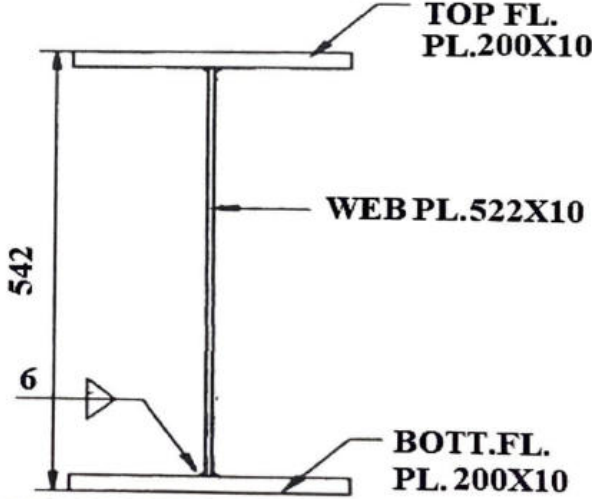
11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	N.A.
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of 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
 Dy. Chief Engineer (M)
 Ambiant Research Officer (M)
 S.C. Riv. Lallaquda

12/04/2022
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Riv. Lallaquda

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, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

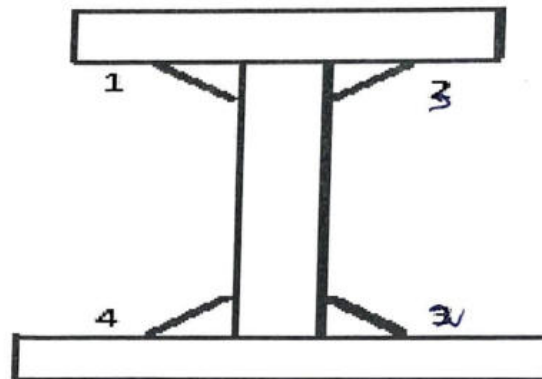
Signature
Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING 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 CI.32.2 of IS 9595-96, using A2 class electrode as per IRS M28-2020

18 Inspection of weld : Visual, D.P. Test.

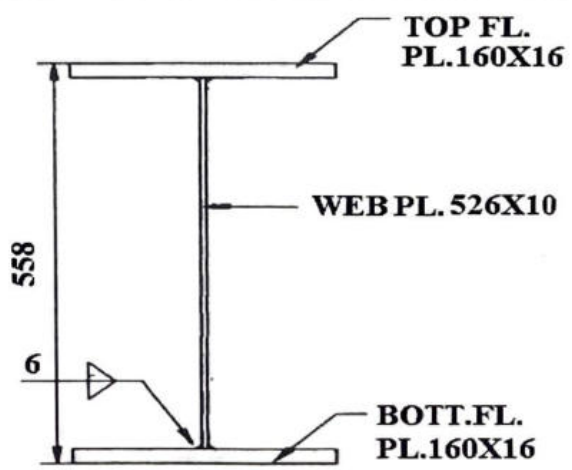
19 Any other relevant detail : None.

[Signature]
Research Officer (M)
S.C. Rly, Lallaguda

[Signature]
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN 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, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

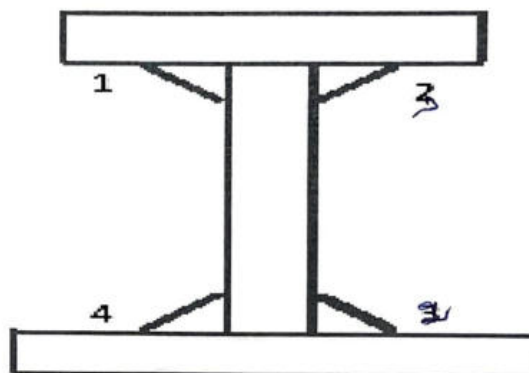
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallaguda

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.

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

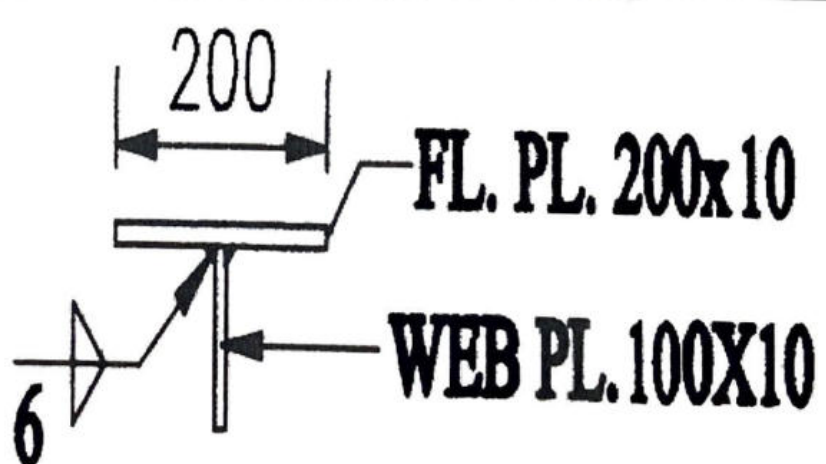


11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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.

[Signature]
Dy. Chief Engineer
Engg. Workshop

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

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

Name 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, CI.7, IRS B1 – 2001, CI. 17.3
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

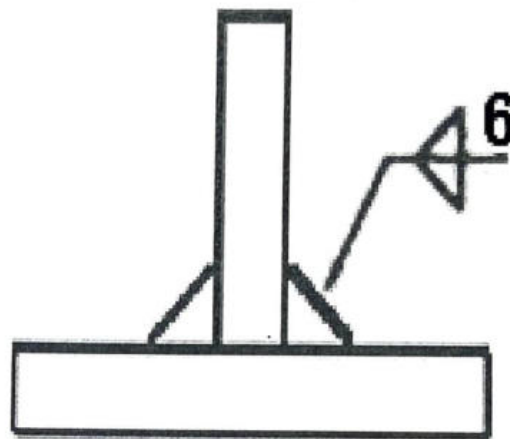
For Approval
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda

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

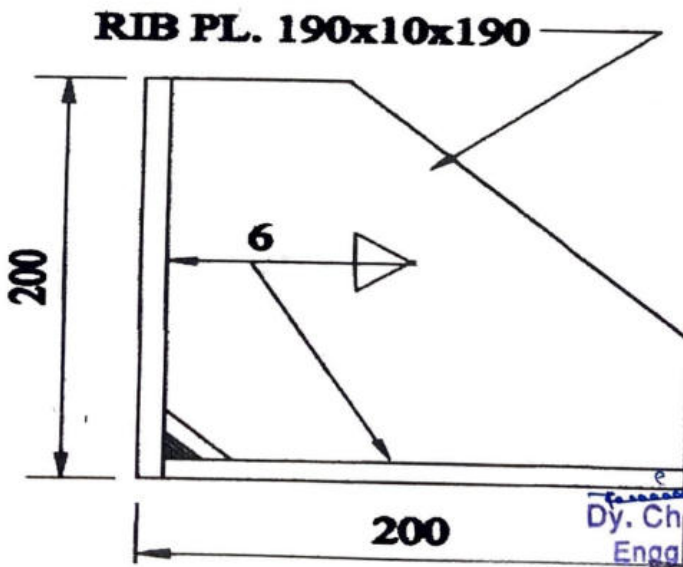
Assistant Research Officer (M)
S.C. Rly. Lallaguda

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

WELDING PROCEDURE SPECIFICATION SHEET

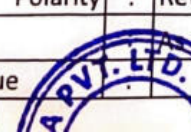
"25T LOADING-2008" 45.7 M SPAN OPEN WEB GIRDER

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN 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	:	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.,)		 <p>RIB PL. 190x10x190</p> <p>200</p> <p>6</p> <p>200</p>
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 J. Srinivas Rao
10	Welding parameters and technique	:	Sr Dy General Manager(C)

12/01/2022
 बहालक अनुसंधान अधिकारी (बाह्य)
 Assistant Research Officer (M)

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



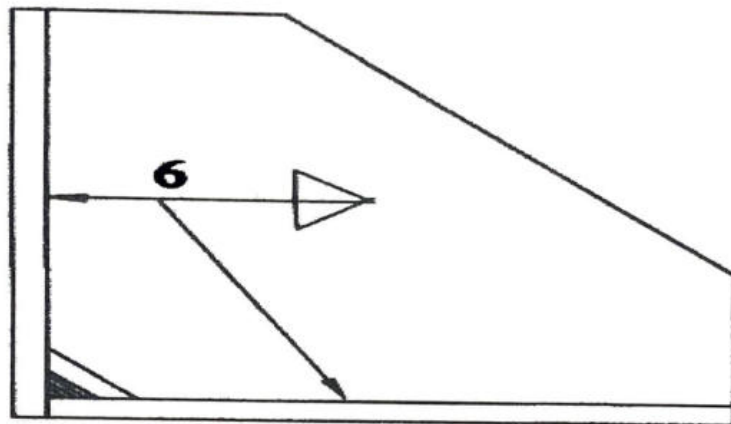
Elective Engineer
 Construction Division
 5-800 MW YEPD, Medak

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 :

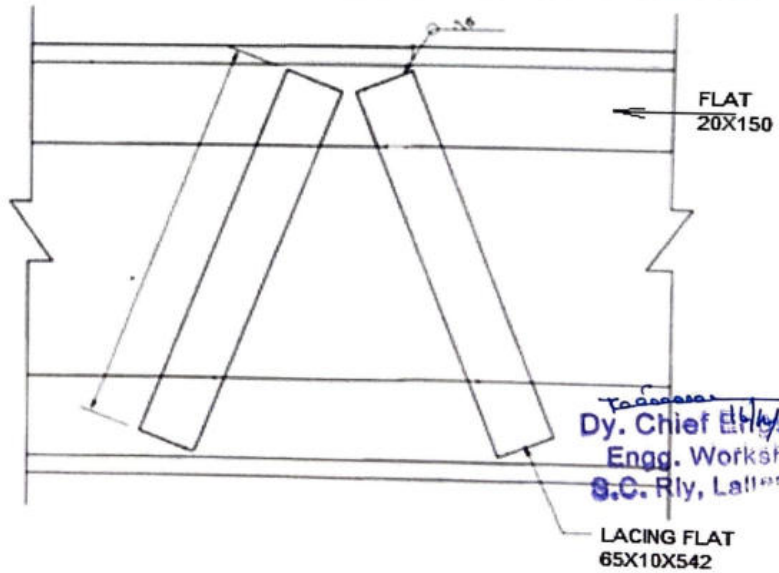


11	Provision of run-on/run-off tabs	:	N.A.
12	Cleaning of weld bead before laying of next weld bead	:	Yes
13	Root preparation before welding other side of groove weld	:	N.A.
14	Preheating and inter pass temperature	:	100°C to 250°C
15	Peening	:	N.A.
16	Post weld treatment	:	N.A.
17	Rectification of weld defect	:	By re-welding after complete removal of defective weld & rectifying the weld as per CI.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.

Signature
Dy. Chief Engineer
Engg. Workshop
S.C. Ry, Lattaguda

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.

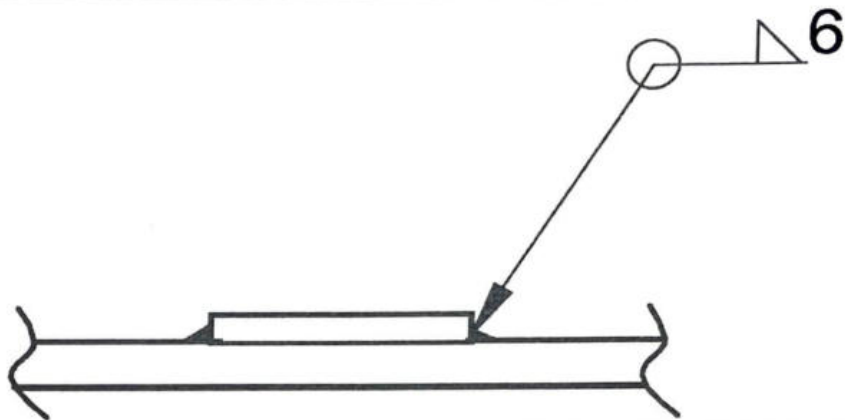
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/14
1	Drawing No.	:	RDSO/B-17181/6/R (Details of Lacing)
2	Weld Joint description	:	Fillet 6mm (Lacing flat welding 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	:	1 of IRS M.46
	Class	:	1.2mm MIG Wire
	Type	:	N.A.
	Drying Method	:	
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.,)	:	 <p>FLAT 20X150</p> <p>LACING FLAT 65X10X542</p> <p>Dy. Chief Engrg. Workshop S.C. Rly, Lateral</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 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	:	<p>Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.</p> <p>Executive Engineer Construction Division 5x800 MW, YTPS, Veerla Palem</p>

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.

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 CI.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.

[Signature]
Dy. Chief Engineer
Engg. Workshop
S.C. Rly, Lallabanda

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/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	:	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, CI.7, IRS B1 - 2001, CI. 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. Ry. Lal Bahadur

S.S.

J. Srinivas Rao

Sr. Dy. General Manager (C)

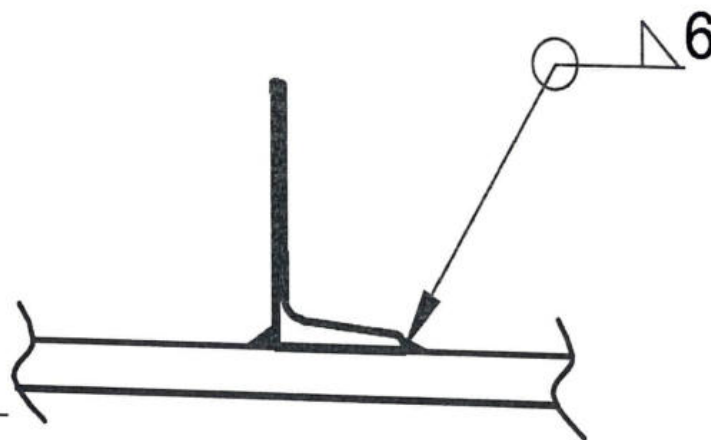
Executive Engineer
Construction Division

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 CI.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.

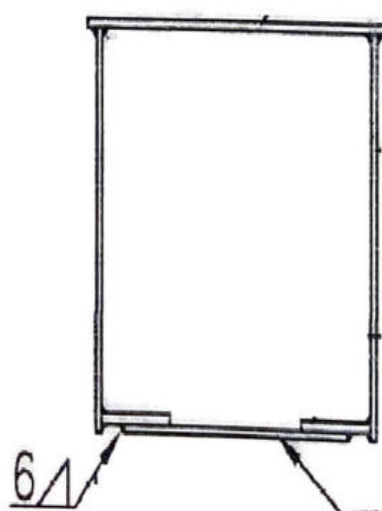
Assistant Research Officer (M)

Dy. Chief Engineer
Engg. Work

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.

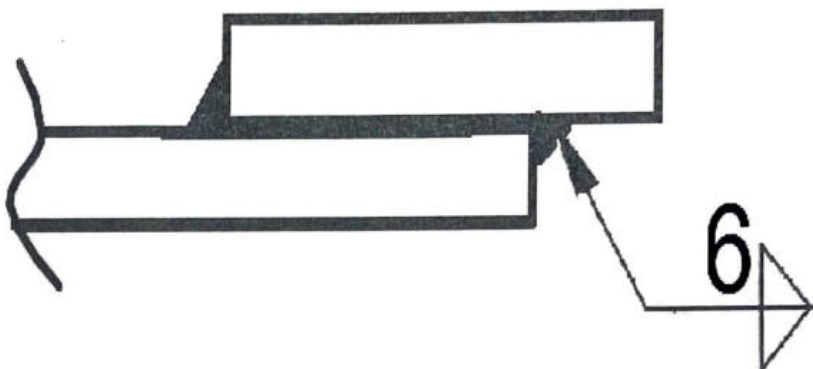
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/16
1	Drawing No.	:	RDSO/B-17181/4/R & B-17184/5/R, Section A-A & B-B
2	Weld Joint description	:	Fillet 6mm (Batten 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.,)	:	 <p style="text-align: right;">Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallaguda</p> <p style="text-align: right;">BATTENS 10 THICK</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	As per IS 7310 (Part-I) - 817 Srinivas Rao
10	Welding parameters and technique	:	Sr Dy General Manager(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 :

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 CI.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.

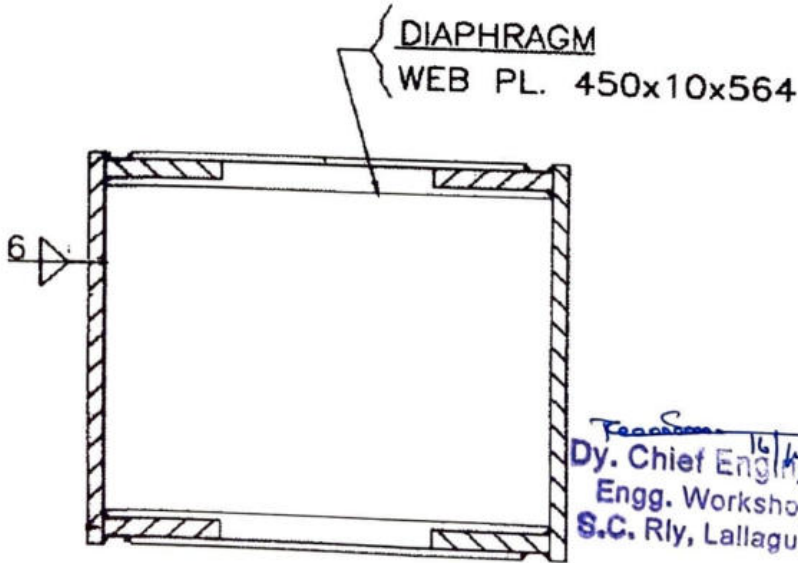
12/04/2023
Assistant Research Officer (M)
S.C. Rly, Lallaguda

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

WELDING PROCEDURE SPECIFICATION SHEET

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

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

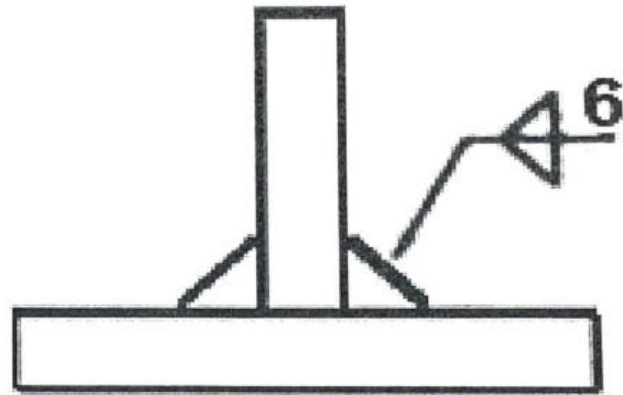
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/17
1	Drawing No.	:	RDSO/B-17181/4/R & B-17184/5/R, Section A-A & B-B
2	Weld Joint description	:	Fillet 6mm (Diaphragm 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	:	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.,)	:	 <p>DIAPHRAGM WEB PL. 450x10x564</p> <p>6</p> <p>Dy. Chief Engg. 16/4/24 Engg. Workshop S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	

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.

16/11/2023
 Dy. Chief Engineer (M)
 Engg. Workshop
 S. S. Fly. Lallaguda

16/11/23
 Dy. Chief Engineer
 Engg. Workshop
 S. S. Fly. Lallaguda

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

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

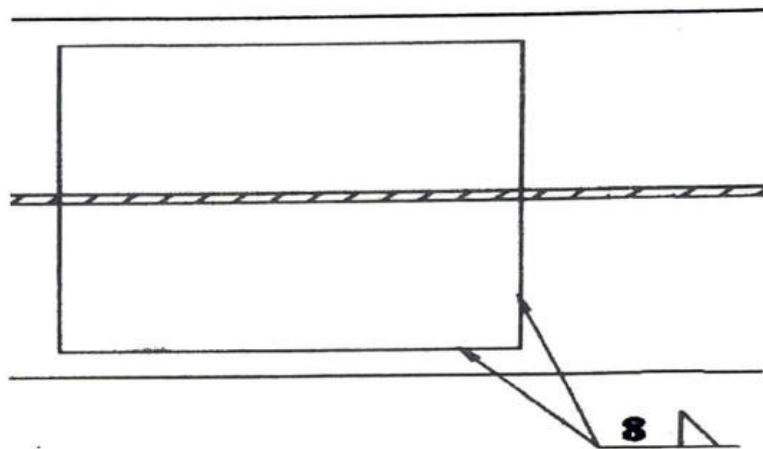
Name and address of Fabricator	:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.	:	GSC/22/SRC-45.7M/WPSS/GMAW/18
1 Drawing No.	:	RDSO/B-17181/13 (Sectional Plan)
2 Weld Joint description	:	Fillet 8mm (Pad Plate Welding to End 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	:	N.A.
Type	:	
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, CI.7, IRS B1 - 2001, CI. 17.3& WBC - 2001
8 Welding Current	:	
Type	:	DC
Polarity	:	Reverse
9 Welder Qualification	:	As per IS 7310 (Part-I) - 817 Srinivas Rao
10 Welding parameters and technique	:	

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


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 CI.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)
 16/1/2020


 Dy. Chief Engineer
 Engg. Workshop
 S.G. Rly, Lallabettu

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.

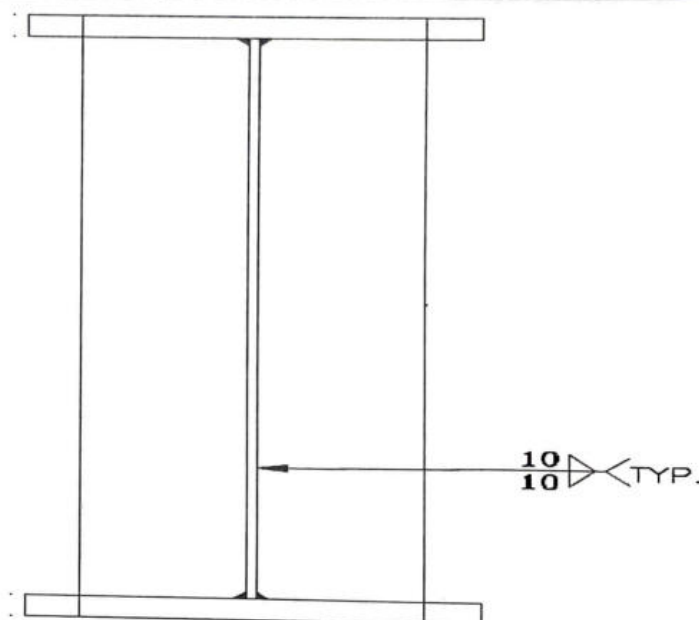
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/19
1	Drawing No.	:	RDSO/B-17181/13
2	Weld Joint description	:	Fillet 10mm (End Plate welding to Cross Girders)
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	:	
	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.,)	:	<p>25 450 20mm Thick Web 925 16X400X975 10 10 TYP. Dy. Chief Engineer, Engg. Workshop, S.C. Rly, Lallaguda</p>
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 – 2001, CI. 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	:	

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.

13/11/2023
 Dy. Chief Engineer (Railway)
 Assistant Research Officer (M)
 S.C. Rly. Laboratory

16/11/24
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly. Laboratory

STEEL.COM

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

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 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/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	:	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, CI.7, IRS B1 – 2001, CI. 17.3& WBC - 2001
8	Welding Current	:	
	Type	:	DC
	Polarity	:	Reverse
9	Welder Qualification	:	IS 7310 (Part-I) – 817
10	Welding parameters and technique	:	

Assistant Research Officer (M)
S.C. Rly, Lallaguda

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

GLOBAL STEEL COMPANY
Survey No.12

GLOBAL STEEL COMPANY
Survey No.12
Srinivas Rao
Sr.Dy.General Manager(C)

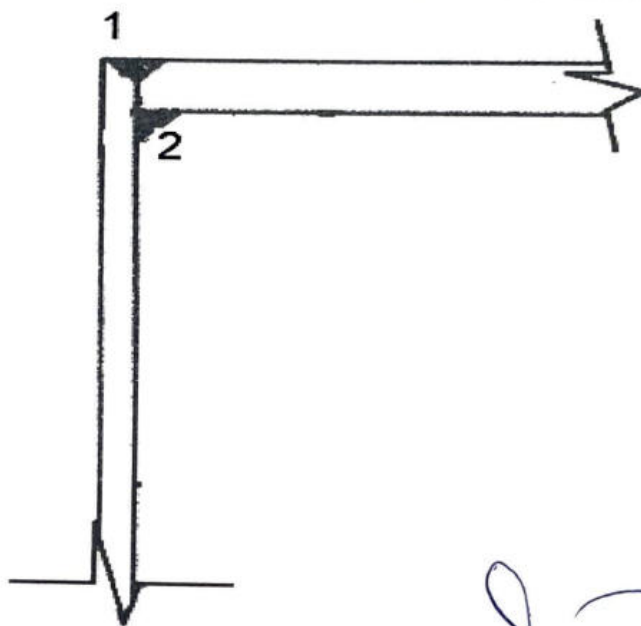
Executive Engineer
Construction Division-1/C
S.C. Rly, Lallaguda

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



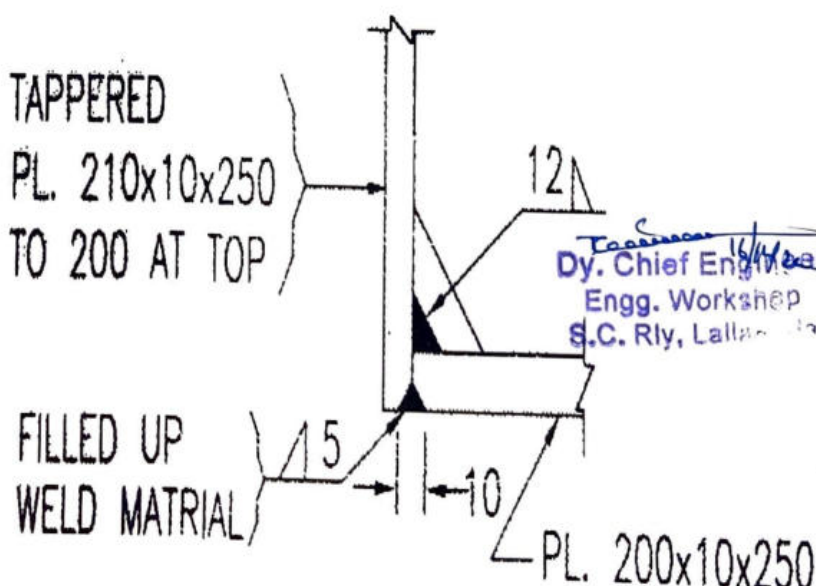
11	Provision of run-on/run-off tabs	: N.A.
12	Cleaning of weld bead before laying of next weld bead	: Yes
13	Root preparation before welding other side of groove weld	: N.A.
14	Preheating and inter pass temperature	: 100°C to 250°C
15	Peening	: N.A.
16	Post weld treatment	: N.A.
17	Rectification of weld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

12/01/2020
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallapur

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.

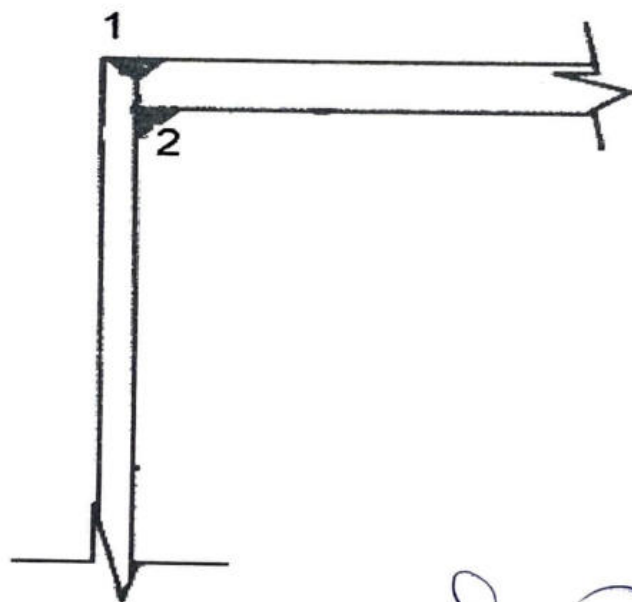
Name and address of Fabricator		:	M/s. GLOBAL STEEL COMPANY , Survey No-12, Kuchavaram Village, Toopran Mandal, Medak Dist.
Welding Procedure specification No.		:	GSC/22/SRC-45.7M/WPSS/GMAW/21
1	Drawing No.	:	RDSO/B-17181/13 (Detail "X")
2	Weld Joint description	:	Single Bewel Welding & Fillet 12mm of 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.,)		 <p>TAPPERED PL. 210x10x250 TO 200 AT TOP</p> <p>12</p> <p>FILLED UP WELD MATRIAL</p> <p>15</p> <p>10</p> <p>PL. 200x10x250</p> <p>Dy. Chief Engineer Engg. Workshop S.C. Rly, Lallab</p>	
7.2	Joint preparation	:	As per IS 4353 -1995, CI.7, IRS B1 - 2001, CI. 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	:	

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 CI.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.

13/04/2020
 Dy. Chief Engineer (M)
 Assistant Research Officer (M)
 S.C. Rly, Lallaguda

16/11/20
 Dy. Chief Engineer
 Engg. Workshop
 S.C. Rly, Lallaguda



WELDING PROCEDURE SPECIFICATION SHEET

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

PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 TAKEN 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	:	A2 of IRS M28-2012
	Type	:	Medium Coated.
	Drying Method	:	As recommended by the Electrode Manufacturer.
6.2	Flux	:	
	Class	:	
	Type	:	N.A
	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, CI.7, IRS B1 – 2001, CI. 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	:	

Signature of Dy. Chief Engineer
 Dy. Chief Engineer (M)
 Assistant Research Officer (M)
 S.G. Rly, Lallagudi

Signature of Dy. Chief Engineer
 Dy. Chief Engineer (M)
 Engg. Workshop
 S.G. Rly, Lallagudi

GLOBAL STEEL COMPANY

Signature of Dy. Chief Engineer

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

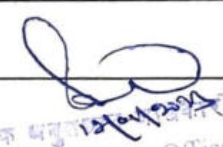
PROJECT: PROPOSED RAILWAY SIDING TAKING OFF FROM CH:2027m OF JNPD END OF VISHNUPURAM RAILWAY STATION AT KM 137/970 (TAKEN AS CH: 00.00m) FOR (5X800MW) YADADRI THERMAL POWER PLANT AT VEERLA PALEM VILLAGE. PROPOSED BRIDGE NO. 4 (ROR) AT CH: 1138.00m (CROSSING EXG. TRACK AT KM: 133/8-9, BETWEEN KONDRAPOL – 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)
 18/12/2020


 Dy. Chief Engineer