



भारत सरकार - रेल मंत्रालय
अनुसंधान अभिकल्प और मानक संगठन
लखनऊ - 226 011
EPBX (0522) 2451200
Fax (0522) 2458500

Government of India-Ministry of Railways
Research Designs & Standards Organisation
Lucknow - 226 011
DID (0522) 2450115
DID (0522) 2465310



सं० : टीएम/एचएम/वगन/खन्ड 1
No./HM/ Wagon Vol. I

दिनांक : 21.02.2014
Dated: 20.02.2014

मुख्य रेलपथ अभियन्ता (ट्रैक मशीन)

मध्य रेलवे, सीएसटी, मुम्बई-400 001
पूर्व रेलवे, फेयरली प्लेस, कोलकाता-700 001
पूर्व मध्य रेलवे, हाजीपुर-844 101
पूर्व तट रेलवे, रेल विहार, चन्द्रशेखरपुर,
भुवनेश्वर-751023
उत्तर रेलवे, बड़ौदा हाउस, नयी दिल्ली-110 001
उत्तर मध्य रेलवे, महा प्रबन्धक कार्यालय,
सुबेदारगंज, इलाहाबाद-211033
उत्तरपूर्व रेलवे, गोरखपुर 273012
उत्तर पूर्व सीमान्त रेलवे, मालीगांव,
गुवाहाटी-781 011
उत्तर पश्चिम रेलवे, जयपुर-302 001
दक्षिण रेलवे, पार्क टाउन, चेन्नई-600 003
दक्षिण मध्य रेलवे, रेल निलायम,
सिकन्दराबाद-500 071
दक्षिण पूर्व रेलवे, गार्डन रीच, कोलकाता-700 043
दक्षिण पूर्व मध्य रेलवे, बिलासपुर-495 004
दक्षिण पश्चिम रेलवे, हुबली-580 023
पश्चिम रेलवे, चर्चगेट, मुम्बई-400 020
पश्चिम मध्य रेलवे, जबलपुर-482 001

Chief Engineer (Track Machines)

C R, CST Mumbai - 400 001.
E R, Fairlie Place, Kolkata-700 001.
E C R, Hazipur-844 101
East Coast Rly, Rail Vihar Chandrashekhar Pur
Bhubaneswar-751023
N R, Baroda House, New Delhi-110 001.
NCR, GM office Subedarganj Allahabad-211 033
N E R, Gorakhpur-273 012.
N F R, Maligaon, Guwahati -781 011.
N W R, Jaipur-302 001.
S R, Park Town, Chennai -600 003.
SCR, Rail Nilayam, Secunderabad-500 071.
S E R, Garden Reach, Kolkata-700 043.
South East Central Rly, Bilaspur-495 004
SWR, Hubli-580 023
W R, Churchgate Mumbai-400 020
WCR, Jabalpur-482 001

Sub: Corresponding welding electrode for Stainless Steel IRS:M-44 to EN-8, IS: 2062 Fe 410Cu WA and IS:2062:2011 E-450

For modification of BRN 22.9 wagons supplied to engineering department for use with Track Machines, welding and cutting works are involved. This wagon is made of stainless steel conforming to IRS:M44. For welding of this material with EN-8, IS: 2062 Fe 410Cu WA and IS:2062:2011 E-450 respectively and cutting of the stainless steel, suitable class of welding electrode and cutting process was asked from M&C Dte. Following directives has been advised by M&C Dte.:

1. For welding, M4 class of electrodes (IS Code E23.12LR26) to IRS:M28-12 may be used.
2. Stainless steel cannot be cut through oxy acetylene gas. The following two most common methods used for cutting of stainless steels are:
 - i) Plasma arc cutting process.
 - ii) Manual metal arc cutting process by using cutting electrodes of class N1 as per IRS:M 28-12

(Anil Choudhary)
(अनिल चौधरी)

निदेशक/टीएम-3Director/TM-III

Copy: Dir./Track Machine, Railway Board-for information please.

(Anil Choudhary)
(अनिल चौधरी)

निदेशक/टीएम-3Director/TM-III