

SOUTH CENTRAL RAILWAY
OFFICE OF THE PRINCIPAL CHIEF ENGINEER,
'B' BLOCK – 4TH FLOOR, RAIL NILAYAM, SECUNDERABAD – 500 003.

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CUG: 9701370211

No: SCR-HQ0ENGG(WKS)/29/2025-Dy CE/WORKS/SCR

Date: 22.08.2025

Dy.CVO/ENGG

Sub: System improvement in regard to guidelines and mandatory frequency and procedure for weld testing -Reg

Ref: 1. Dy.CVO/Engg letter no.G.265/PC/E/20250201178 dt 23.05.2025
2. This office letter of even no. dt.20.08.2025 (Copy enclosed)

* * *

In order to ensure uniformity, quality assurance, and adherence to standard practices during the fabrication and execution of on-site welding activities for Foot Over Bridges (FOBs), Cover Over Platforms (COPs), and Sheds, the guidelines were issued for strict compliance during various fabrication stages and regular maintenance vide ref.2 above in accordance with the letter under ref.1 above.

This is for your kind information.

Digitally Signed by Peddu
Murali Krishna
Date: 22-08-2025 15:03:00
Reason: Approved

Dy.CE/LM

SOUTH CENTRAL RAILWAY
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No: SCR-HQ0ENGG(WKS)/29/2025-Dy CE/WORKS/SCR
**CAO/C/SC, CAO/C/RSP,
CPM/GS/BZA, I/SC, II/SC, GTL
Sr.DEN/Co-Ord/SC,BZA,GTL,GNT,HYB & NED.
Dy.CE/EWS/LGD, Sr.DEN/LGDS,
Dy.CE/TM/lines/BZA, Dy.CE/CPOH/RYP**

Date: As signed

Sub: Standardization and System improvement regarding weld testing and quality control for fabrication of FOBs, COPs and Sheds -Reg

Ref:

1. BS 140 - Guidelines for fabrication, Quality control, Erection, Inspection and maintenance of Steel Plate/Composite steel girder Foot over bridges.
2. Foot over Bridges in railways -IRICEN Book

* * *

In order to ensure uniformity, quality assurance, and adherence to standard practices during the fabrication and execution of on-site welding activities for Foot Over Bridges (FOBs), Cover Over Platforms (COPs), and Sheds, the following technical guidelines are issued for strict compliance during various fabrication stages and regular maintenance.

1. Inspection & Approval Schedule

The inspection and approval process for FOBs, COPs and Sheds shall strictly follow the **Schedule prescribed under Annexure-II of BS-140**, applicable to both Open Line and Construction Organization of zonal railway.

2. Quality Assurance Program (QAP)

The standard **Quality Assurance Program (QAP)** shall be adhered to Para 3.0 & as per **Annexure-I of BS-140**, which consists of **Part A**: Detailing the scope and nature of work to be undertaken. **Part B**: Standard Model QAP to be uniformly adopted at all sites.

3. Welding Procedure Specification Sheet (WPSS)

All on-site welding works shall be carried out in accordance with the standard **Welding Procedure Specification Sheet (WPSS)** prescribed under Para 4.0 of BS-140 & **Annexure-I of the IRICEN Book on FOBs in Indian Railways**. No deviations shall be permitted without prior technical sanction and approval from the competent authority.

4. Welding Procedure Qualification Record (WPQR)

The qualification and competency of welders, as well as the welding process parameters, shall conform to the **Welding Procedure Qualification Record (WPQR)**

specified in Para 5.0 of BS-140 & **Annexure-II of the IRICEN Book on FOBs in Indian Railways**. All welder qualification records must be maintained on-site and made available for inspection.

5. General Compliance

All field officers, supervisors, and contractors shall ensure strict adherence to the technical provisions, inspection protocols, documentation, and maintenance guidelines laid out in **BS-140**.

This is issued with the approval of PCE/SCR.

Encl: Sample proforma for QAP, WPSS & WPQR.

Digitally Signed by
M.a.rehman
Date: 20-08-2025 12:26:14
Reason: Approved
Chief General Engineer

Copy to: Secy to PCE for kind information

CPD/SD, CBE, CTE, CE/P&D, CE/SD, CE/RSW, CE/TM,CE/TS,
DRM/SC,BZA,GTL,GNT,HYB & NED, Dy.CVO/Engg for kind information.

Standard QAP for Steel Plate/Composite Steel Girder FOB

<u>MODEL QUALITY ASSURANCE PLAN (QAP) FOR FABRICATION OF STEEL PLATE/COMPOSITE I-GIRDER TYPE FOB</u>		
<u>PART-A (DETAILS OF WORK)</u>		
S.No	Item	Details
1	Name of Project	
2	Project falls into Zonal Railway jurisdiction of	
3	Executing organization of the agreement (i.e. Zonal Railway/ Railway PSU/NHAI or any other government agency)	
4	Contractor Agency (Name and address)	
5	Fabricating Agency (Name and address)	
6	Inspecting Agency	
7	QAP No.	
8	Agreement No./LOA No.	
9	Date of Agreement/LOA	
10	Completion date as per Agreement/LOA	
11	Scope of fabrication (in no. of spans and tonnage)	
12	Drawing No.	
13	Any other relevant detail	

PART B - MODEL QAP

Sl. No.	Component / Operations	Characteristic to be checked	Frequency & type of check	Reference Document	Fabricators Quality Control	Inspection Details		Type of record	Acceptance Criteria	Remarks
						Inspection agency	Extent of Inspection			
1	2	3	4	5	6	7	8	9	10	11
1.0	RAW MATERIAL									
1.1	Steel Plates and other Structural Steel Sections	Identification and Co-relation with Mill Test Certificate from Supplier. Source/Brand of steel to be decided as per prevailing instructions issued from Railway Board.	As per Mill Test Certificate & test certificate from approved Laboratory/ Govt. approved Laboratory/ NABL/ NABCB for the test required by Zonal Railway or Railway PSU.	Challan, Mill T.C.	Verification of reference documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Fabricator's Record	Steel Plates or Rolled sections: IS 2062:2011 Grade E250 or higher of Quality "A" as mentioned in the respective approved drawings.	1. Grade and Quality of Steel Plates, structural section to be same as mentioned in the respective approved drawings 2. For other details of structural steel plates and structural section A&C no. 5 of IRS-B1: 2000, IS 2062-2011 and codes referred in these shall be complied as applicable. 3. Raw Material clearance shall be done by Zonal Railway/ Railway PSUs as per prevailing instructions issued from Railway Board.

		Physical Condition i.e.- Pitting, rusting, straightness, rolling defects etc.	Visual	--	Complete Visual inspection	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Fabricator's Record	A&C no. 5 of IRS-B1:2000, IS 2062-2011 and codes referred in these shall be complied as applicable	
		Mechanical Test as per IS-2062:2011 UTS,YS,%EL, Bend Test	Lab test at approved laboratory / Govt. approved Laboratory/NABL/NABCB	-	Lab Test Report	Proj. Executing Authority of Zonal Railway/ Railway PSUs	-	-	Table 2 along with notes below and other relevant clauses of IS- 2062-2011 and codes referred in it, for quality and grade of steel as mentioned in respective drawings as applicable.	
		Chemical Analysis as per IS 2062-2011	Lab test at approved laboratory Govt. approved Laboratory/NABL/NABCB	-	Lab Test Report	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Heat / Cast no. section wise as per IS 2062-2011	-	Table 1 along with notes below and other relevant clauses of IS- 2062-2011 and codes referred in it, for quality and grade of steel as mentioned in respective drawings as applicable.	
		Ultra sonic test for 12mm and above thick plates as per IS- 4225/ ASTM SA-435/435M	By ASNT level- II operator	-	Lab Test Report	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	-	IS-4225 or ASTM SA-435/435M and codes referred in it as per applicability	

		Dimension	Measurement	Challan	Measurement of dimension		100%	Fabricator's Record & Zonal Railway Record	IS 2062: 2011 or other relevant codes referred in it as applicable	
1.2	HSFG Bolt with DTI washers	Dimensions	Visual / Measurement	Challan and Manufacturer's Test Certificate	Verification of reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	As per BS - 111 (Latest revision)	Fabricator's Record	As per BS - 111 (Latest revision)	Procure from RDSO approved Vendor only.
		Mechanical & Chemical properties	T.C. And tests required from Govt./NABL / NABCB approved lab As per BS - 111 (Latest revision)	Manufacturer Test Certificate	Verification of reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs				
1.3	Paints and Primers	Verification of Manufacturer's Test Certificate, Inspection Certificate, Challan	Visual	Challan , Manufacturer's Test Certificate	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Each Batch	Manufacturer's Test Certificate	IRS B1-2001, IS: 5666 ,IS: 51, IS: 104, IS: 2339 and applicable codes referred in these codes therein.	Test at the approved laboratory suitable for the purpose shall be done as per the instruction of the Zonal Railway/ Railway PSU.
		Tests as per specification	Lab test at approved laboratory Govt. approved Laboratory/ NABL/ NABCB	Challan, Manufacturer's Test Certificate	Verification of Reference Documents		Random	Lab Test Report		

1.4	Aluminium wire	Properties of Aluminium wire such as Dia, class and purity as mentioned in appendix-VII of IRS B1-2001	Review of reference documents with material	Challan , Manufacture's Test Certificate	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Each Batch	Manufacturer's Test Certificate	IRS B1-2001, IS:2590 and applicable codes referred in these codes	Test at the approved laboratory suitable for the purpose shall be done as per the instruction of the Zonal Railway/ Railway PSU.
		Tests as per specification	Lab test at approved laboratory Govt. approved Laboratory/ NABL/ NABCB	Challan , Manufacture's Test Certificate	Verification of Reference Documents		Random	Lab Test Report		
1.5	Welding Consumables	As Per Specification and approved WPSS	Any Test as required	Challan & Manufacturer's Test Certificate	Verification of reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	As per requirement	Fabricator's record	IRS Welded Bridge Code 2001, IRS M28, IRS M39, IRS M46 and other applicable codes referred in these codes and specifications	As per specification and WPSS.
1.6	Stud	Visual Inspection , dimensions inspection	Test as mentioned in BS 115 (Latest Revision)	Approved Fabrication Drawings and WPSS	100 % Visual inspection & verification of dimension by gauge and test record	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Test Reports & Fabricator report	Approved Fabrication Drawing, IS 9595-96, IRS B1-2001 and codes as applicable instructions issued by Railway Board also to be followed.	
2.0	Manufacturing Process									

2.1	Layout	Dimension	Measurement with calibrated steel Tape	Approved Drawings	Measurement of dimensions	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Inspection Report of Inspection officials	Approved fabrication Drawings and relevant IS/IRS codes.	
2.2	Master Plates	Dimension, intersection line, pitch, gauge, Dia. of holes & No. of holes.	Measurement with calibrated steel Tape & gauges.	Approved Drawings	Measurement of dimensions	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Record for Master Plates on proforma same as of Appendix I (1) proforma given in IRS B1-2001	Approved fabrication drawings, IRS B1- 2001 and BS-110 (Latest Revision)	
2.3	Preparatory work such as Cutting, Straightening, Edge Preparation, Marking, Drilling, Fit up, Pre-assembly, End finishing	Dimension, freedom from defects	Visual / Measurement with master plates and templates	Inspection Report of Inspection officials & fabricator's record	Visual & Measurement of dimensions	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Inspection Report of Inspection officials & fabricator's record	Approved fabrication drawings, IRS B1-2001, IS- 1852-85 and codes referred in these codes as applicable	--
3.0	Welding									
3.1	WPSS	Approval of WPSS	Verification	IS 9595-96, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	Verification Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Fabricator's Record	Approved fabrication Drawings, IS 9595-96, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	Welding to be performed following the different specification and parameters mentioned in WPSS

3.2	WPQR	i) Witnessing of established WPSS. ii) Witnessing of Welder Qualification test	Visual DT and NDT at approved laboratory / Govt. approved Laboratory/NABL/NABCB	As per Codal Requirement	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	WPQR Sheet to be recorded in presence Project Executing Authority of Zonal Railway/ Railway PSU	IS 7307 (Part-1), IS 7310 (Part-1), IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	Only welders approved by Project Executing Agency to be engaged in the job
3.3	Preheating	Measurement of Temperature	Visual with thermal Chalk or Infrared Thermometer	Approved WPSS	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Random	Inspection Report of Inspection officials & fabricator's record	IS 9595-96, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	--
3.4	Baking of Electrode, flux	To have moisture free electrode and flux	Visual check of Electrodes and heating	As per Manufacturers Recommendation	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Inspection Report of Inspection officials & fabricator's record	IRS B1-2001 and other applicable codes.	--
3.5	Selection of Correct Electrodes & flux	Reference to WPSS.	Visual	As per Approved WPSS	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Inspection Report of Inspection officials & fabricator's record	IRS Welded Bridge Code 2001, IRS M28, IRS M39, IRS M46 and other applicable codes referred in these codes and specifications	As per WPSS and other codes applicable.
3.6	Current Condition	Measurement of Amp./ Voltage	Visual with Ammeter and Voltmeter	As per Approved WPSS	Verification of Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Random	Inspection Report of Inspection officials & fabricator's record	IS 9595-96, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	As per WPSS and other codes applicable.

3.7	Sequence of Welding	Controlling Distortion	Visual	As per Approved WPSS	Verification Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Random	Inspection Report of Inspection officials & fabricator's record	IS 9595-96, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	--
3.8	Provision of Run-on and Run-off Plates	To avoid crater defects	Visual	As per Approved WPSS	Verification Reference Documents	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Inspection Report of Inspection officials & fabricator's record	IS 9595-96, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	--

Sl. No.	Component /Operations	Characteristic to be checked	Frequency & type of check	Reference Document	Fabricators Quality Control	Inspection Details		Type of record	Acceptance Criteria	Remarks
						Inspecting agency	Extent of Inspection			
1	2	3	4	5	6	7	8	9	10	11
4.0	Inspection of Welded components	For Fillet Welds - Visual, D.P. Test, Fillet Size, Penetration, Leg length, Throat thickness etc.	Visual, Gauge and Macro etching	Approved fabrication Drawings & WPSS	Visual Inspection & Verification of Dimension by Gauge	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Fabricator's Record	Approved fabrication Drawings, IRS B1-2001, IRS WBC-2001 and codes referred in these codes as applicable	It is to be ensured during fabrication process that fabrication has been done as per the WPSS approved by Project executing Authority and Welders approved by Project executing Authority. This is to be ensured by Zonal Railway/ Railway PSUs
4.1	Stud Welding (in case of composite steel girder FOB)	Visual Inspection, dimensions inspection, ring test and bend test etc. As applicable, for good penetration & crack free weld.	Test as mentioned in BS 115 (Latest revision)	Approved Fabrication Drawings and WPSS	100 % Visual inspection & verification of dimension by gauge and test record	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100%	Test Reports & Fabricator report	Approved Fabrication Drawings 9595-96, IRSB1-2001 and codes as applicable instructions issued by Railway Board also to be followed.	

7.0	Cleaning & Painting	Surface condition before painting	Visual checking with reference to surface preparation	Approved Fabrication Drawing & IRS -B1-2001 and codes referred in these	Verification of stage clearance records	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100% by fabricator & Random by Zonal Railway	Fabricator's Record	Clause 39.2.1 and appendix VII of IRS B1-2001, IS: 5666, IS: 51, IS: 104, IS: 2339 and applicable codes referred in these codes	
		Surface finish after painting	Visual checking	Approved Fabrication Drawing & IRS -B1-2001 and codes referred in these	Verification of stage clearance records	Proj. Executing Authority of Zonal Railway/ Railway PSUs	100% by fabricator & Random by Zonal Railway	Fabricator's Record		
		DFT checking	Measurement	Approved Fabrication Drawing & IRS -B1-2001 and codes referred in these	Verification of stage clearance records	Proj. Executing Authority of Zonal Railway/ Railway PSUs	Minimum on reading per square meter	Measurement Record		
8.0	Final Dispatch including packing, Shipping mark and loading etc.	1. Shipping Mark on all Components as per Approved Fabrication drawings 2. Fixing of Inscription Plate 3. Packing 4. Loading	Visual	Fabricator's Record		Proj. Executing Authority of Zonal Railway/ Railway PSUs	Random	Approved Fabrication Drawing & Fabricator's record	Approved Fabrication Drawing & Clause 42, 43 and 44 of IRS -B1-2001 and codes referred in these	Site Painting is to be done after assembly and erection of girder on site as per IRS B1-2001

Annexure-II

Schedule for the Inspection and Approvals for FOBs

Executing Agency		Zonal Railway (Open Line) & Construction Org. of Zonal Railway	Railway PSU like RVNL, DFCCIL etc.
(1)		(2)	(3)
1.	QAP preparation	Fabricator	Fabricator
2.	QAP Approval	Project Executing Authority (minimum JAG officer)	Project Executing Authority (equivalent of Minimum JAG officer)
3.	WPSS preparation	Fabricator	Fabricator
4.	WPSS Approval	Project Executing Authority (minimum JAG officer)	Project Executing Authority (minimum JAG officer)
5.	WPQR - Preparation	Fabricator	Fabricator
6.	WPQR - Approval	Project Executing Authority (minimum JAG officer)	Project Executing Authority (minimum JAG officer)
10.	Camber checking of Steel/Composite Girders in Fabricator's workshop	Project Executing Authority (minimum JAG officer)	Project Executing Authority
11.	Component Inspection & Approval	Project Executing Authority (minimum JAG officer)	Project Executing Authority (minimum JAG officer)
12.	Test-check of assembly/ camber at site before & after launching	Project Executing Authority (minimum JAG officer)	Project Executing Authority (minimum JAG officer)

Note: In case of Multiple FOBs of similar type, Project Executing Authority may waive off stage no. 10 for subsequent FOBs after the approval of First FOB.

Annexures

ANNEXURE-I (Ref.: Cl.4.1.8)

1. **Proforma for Welding Procedure Specification Sheet (WPSS)**

Name and address of Fabricator:

Welding procedure specification No.

1.0 Weld joint description :

2.0 Base Metal :

3.0 Welding Process :

4.0 Welding position :

5.0 Welding consumables :

5.1 Electrode/wire Class :

Dia :

Drying method :

5.2 Flux Class :

Dia :

Drying method :

5.3.1 Shielding gas :

6.0 Base Metal preparation :

6.1 Joint design details :
(Give sketch showing arrangement of parts, welding groove details, weld passes & their sequence etc.)

6.2 Joint preparation :

7.0 Welding current : Type :
Polarity :

8. Welder qualification :

9. Welding parameters and technique:

9.1 Welding Parameters :

Weld Pass No.	Electrodes/ wire dia. (mm)	Current (amp)	Arc Voltage (volt)	Wire feed speed (m/min)	Travel speed (m/min)	Electrical stick out (mm)	Gas flow rate (litre/min.)
1	2	3	4	5	6	7	8

9.2 Welding sequence and technique :
(Give sketch showing sequence and direction of welding).

10.0 Provision of run in and run-off tabs:

11.0 Cleaning of weld bead before laying next weld bead:

12.0 Root preparation before welding other side of groove weld:

13.0 Preheating and inter pass temperature:

- 
- 
- 14.0 Peening:
15.0 Post weld treatment:
16.0 Rectification of weld defects:
17.0 Inspection of weld:
18.0 Any other relevant details:

Prepared by

Signature _____

Designation _____

Date _____

(for & on behalf of Fabricator)

Annexures

ANNEXURE-II
(Ref.: Cl.4.1.8)**1. Proforma for Welding Procedure Qualification Record (WPQR)**

Name and address of Fabricator

- | | | | |
|------|-------------------------------------|------------|--|
| 1.0 | Description of Weld | : | |
| 2.0 | Welding procedure specification no. | : | |
| 3.0 | Name of welder | : | |
| 4.0 | Date of preparation of test piece | : | |
| 5.0 | Dimensions of test piece | : | |
| 6.0 | Base Metal | : | |
| 7.0 | Welding Process | : | |
| 8.0 | Welding position | : | |
| 9.0 | Welding Current | : Type : | |
| | | Polarity : | |
| 10.0 | Weld joint design details | : | |
| 11.0 | Welding consumables | : | |
| 11.1 | Electrode/wire | Class : | |
| | | Dia : | |
| | | Brand : | |
| 11.2 | Flux | Class : | |
| | | Type : | |
| | | Brand : | |

11.3 Shielding gas :

12.0 Welding parameters :

Weld Pass No.	Electrodes/ wire dia. (mm)	Current (amp)	Arc Voltage (volt)	Wire feed speed (m/min)	Travel speed (m/min)	Electrical stick out (mm)	Shielding gas flow rate (lit/min.)
1	2	3	4	5	6	7	8

13.0 Preheating and interpass temperature:

14.1 Results of Qualification Tests:

Test	Specimen No.	Result
1	2	3
Non-destructive tests		
i) Visual examination:		
ii) Dye penetrant test:		
iii) Magnetic particle test:		
iv) Radiographic/Ultrasonic test:		
Destructive tests:		
i) Macro-examination:		
ii) Hardness survey:		
iii) Fillet weld fracture test:		
iv) Transverse tensile test:		

Tensile strength Yield Stress Location of fracture v) All-weld tensile test: Tensile strength Yield Stress Elongation % vi) Guided bend test: Root bend test Face bend test Side bend test vii) Any other tests		
--	--	--

Signature _____

Designation _____

Date _____

(for & on behalf of Fabricator)

Confidential

दक्षिण मध्य रेलवे/ SOUTH CENTRAL RAILWAY



महाप्रबंध कार्यालय /General Manager's Office,
सतर्कता शाखा / Vigilance Branch,
रेल निलयम् / Rail Nilayam,
सिकंदराबाद / Secunderabad.
तारीख/Date: 23.05.2025

सं/ No. G.265/PC/E/20250201178

Principal Chief Engineer,
South Central Railway.

विषय/Sub: System improvement in regard to guidelines and mandatory frequency and procedure for weld testing - Reg.

Currently, in South Central Railway (SCR), as part of the ongoing infrastructure development works, components such as COPs, FOBs, sheds, etc., are being fabricated extensively using structural steel. A majority of these structural steel members are joined primarily through welding.

During weld testing (Dye Penetrant Tests) conducted by the Vigilance Organisation as part of preventive checks, several tested welds were found to exhibit pinholes and cracks. It has also been observed that adequate quality control measures are not being enforced for on-site welding activities. In most instances, welds are not being tested by the field executives.

At present, there are no standard guidelines or prescribed frequency for mandatory weld testing by field officials during the execution of structural steel works in SCR.

Given that welding is a critical method of jointing in structural steel components of COPs, FOBs, etc and that recent vigilance checks have highlighted serious quality issues, this represents a significant systemic gap in quality assurance.

In light of the above, it is requested that PCE/SC may kindly formulate and issue clear guidelines, including mandatory frequency and procedures for weld testing (such as DPT and Magnetic Particle Inspection – MPI) by field staff, to ensure consistent quality control and enhance system reliability during execution in form of system improvement.

This issues with the approval of SDGM & CVO/SCR.

के. मुत्याला नायडू (K. MUTYALA NAIDU)
उ.मु.स.अधिकारी/इंजी Dy.CVO/Engg.

May Pl. see.

CC/E

20/5

23/5/2025