

Bureau of Indian Standards  
Central Marks Department-3

Our Ref: CMD-3/16:11513

05 12 2012

Subject: Implementation of IS 11513:2011 "Hot Rolled Carbon Steel Strip for Cold Rolling Purposes" and STI (Doc: STI/11513/3, December 2012)

1) IS 11513:1985 has been revised as IS 11513:2011 "Hot Rolled Carbon Steel Strip for Cold Rolling Purposes". In the revised version of specification, the following changes have been made:

- a) Amendment No.1, 2 and 3 have been incorporated.
- b) A new clause on reference has been incorporated.
- c) Hot rolled steel strips having carbon content up to a maximum of 0.25 percent have been incorporated.
- d) Requirements of additional grades such as hard quality, extra deep drawing (stabilized interstitial free), micro alloyed and high strength quality have been added.
- e) Clause on retest has been modified.
- f) International grades designation system has been adopted, simultaneously old designations have also been given.
- g) Requirements of dimensions and tolerances have been separated from the standard and adopted IS/ISO 16160:2005 'Continuously hot rolled steel sheet products – Dimensional and shape tolerance.
- h) Designations such as CR0, CR1, CR2, CR3, CR4 and CR5 have been aligned with IS 513 : 2008 ' Cold reduced low carbon steel sheets and strips (*fifth revision*) as these are intended for cold rolling purposes.
- i) Designations such as CR6 and CR7 are for low carbon high strength cold rolled steel sheets and coils for cold forming grades.

2) After publication of new specification IS 11513:2011, the existing Scheme of Testing and Inspection (STI) has also been revised as **Doc: STI/11513/3, December 2012** (Available on BIS Intranet).

3) In order to implement the revised IS 11513:2011 and Scheme of Testing and Inspection, the following procedure shall be adopted:

For Existing Licensees:

- i) The Endorsement in the licence document shall be made after the firm submits their acceptance of revised STI.
- ii) The implementation of revised STI by the licensee shall be ensured during next surveillance inspection.
- iii) Action shall be taken as per OMPC, November 2004, if the licensee fails to submit the acceptance of revised STI in stipulated time.

*Contd.*

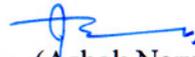
For Applicants:

a) The applications, received for grant of licence/inclusion of new varieties in the existing licence under simplified procedure before **1<sup>st</sup> January 2013**, shall be processed as per specification (old or revised) requested by the firm. However, if the case is processed as per old specification, an undertaking shall be obtained from the firm that the actions, required as per revised IS 11513:2011, shall be completed before **1<sup>st</sup> January 2013**.

b) The applications received for grant of licence under old scheme of BIS shall be recorded and processed as per IS 11513:2011 from the date of issue of this circular.

4) IS 11513:2011 along with STI, Doc: **STI/11513/3, December 2012** shall be implemented with effect from **1<sup>st</sup> January 2013**. The revised STI is available on BIS Intranet.

5) This issues with the approval of Competent Authority.

  
(Ashok Narula)  
Sc'F'(CMD-3)

Sc.F&H(CMD-3)

  
5/12/12

Sc G & Chief(Certification) (Approved at N/3 dated 03 12 2012)

Circulated to all ROs/BOs/Labs/CMD-1

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**SCHEME OF TESTING AND INSPECTION  
FOR CERTIFICATION OF  
HOT ROLLED CARBON SEEL STRIP FOR COLD ROLLING PURPOSES  
ACCORDING TO IS 11513:2011**

**1. LABORATORY** – A laboratory shall be maintained which shall be suitably equipped and staffed where different tests given in the specification shall be carried out in accordance with the method given in the specification.

**2. TEST RECORDS** - All records of tests, inspection and calibration shall be kept in suitable forms approved by the Bureau.

2.1 All testing apparatus/measuring instruments shall be periodically checked and calibrated and records of such checks/calibration shall be maintained. Tensile testing machine shall be calibrated at least once in a year.

2.2 Copies of any records and other connected papers that may be required by the Bureau shall be made available at any time on request.

**3. QUALITY CONTROL –**

3.1 It is recommended that, as far as possible, Statistical Quality Control (SQC) methods may be used for controlling the quality of the product during production as envisaged in this Scheme [See IS 397(Part I) to IS 397(Part 4)].

3.2 In addition, effort should be made to gradually introduce a Quality Management System in accordance with IS/ISO 9001.

**4 MARKING**

4.1 **Standard Mark-** The Standard Mark as given in Column (I) of the First Schedule of the licence shall be marked on the product, provided always that the product to which this mark is applied conforms to every requirement of the Specification and this Scheme.

4.2 **Other Marking-** In addition, each pack carry a metal tag/label bearing the cast number and the manufacturer's name or trade- mark or shall be marked at the top legibly.

**5. LEVELS OF CONTROL –**

5.1 The tests, as indicated in Table 1 attached and at the levels of control specified therein, shall be carried out on the whole production of the factory which is covered by this scheme and appropriate records and charts maintained in accordance with paragraph 2.0 above. All the production which conforms to the Indian Standards and covered by the licence shall be marked with certification mark of the Bureau.

5.2 In respect of all other clauses of the specification the factory will maintain appropriate control and checks to ensure that their product conforms to the various requirements of this specification.

**6. REJECTIONS** – A separate record shall be maintained giving information relating to the rejection of the production not conforming to the requirements of the specification and the method of its disposal. Such material shall in no circumstances be stored together with that conforming to the specification.

**7. SAMPLES** – The licensee shall supply, free of charge, the samples required in accordance with the Bureau of Indian Standards (Certification) Regulations, 1988, as subsequently amended, from the factory or godowns. The Bureau shall pay for the samples taken by it from the open market.

**8. REPLACEMENT –**

8.1 Whenever a complaint is received soon after the goods with Standard Marks have been purchased and used, and if there is adequate evidence that the goods have not been misused, defective goods or their components are replaced or repaired free of cost by the licensee in case the complaint is proved to be genuine and the warranty period (where applicable) has not expired. The final authority to judge the conformity of the product to the Indian Standard shall be with the Bureau. The firm should have own complaint investigation system as per IS/ISO10002.

8.2 In the event of any damages caused by the goods bearing the Standard Mark, or claim being filed by the consumers against BIS Standard Mark and not “conforming to” the relevant Indian Standard, entire liability arising out of such non conforming product shall be of licensee and BIS shall not in any way be responsible in such cases.

**9. STOP MARKING –**

9.1 The marking of the product shall be stopped under intimation to the Bureau if, at any time, there is some difficulty in maintaining the conformity of their product to the specification, or the testing equipment goes out of order. The marking may be resumed as soon as the deficiencies are removed under intimation to Bureau.

9.2 The marking of the product shall be stopped immediately if directed to do so by Bureau for any reason. The marking may then be resumed only after permission by the Bureau. The information regarding resumption of markings shall also be sent to the Bureau.

**10. PRODUCTION DATA** – The licensee shall send to BIS as per the enclosed proforma-1 to be authenticated by a Chartered Accountant, a statement of quantity produced, marked and exported by him and the trade value thereof at the end of each operative year of the licence.

Table 1.....

**IS 11513:2011  
SPECIFICATION FOR  
HOT ROLLED STEEL STRIP FOR COLD ROLLING PURPOSES  
TABLE 1 – LEVELS ON CONTROLS  
(Para 5 of Scheme of Testing and Inspection)**

Cl. No.	Requirements	Test Method		Levels of Control		Frequency
		Clause	Reference	No. of Specimen	Level of Lot Size	
6	Chemical Composition					
6.1	Ladle Analysis	Relevant Part of IS 228 or any other established instrumental/chemical method	IS 11513	3	One heat	Each heat of 100 t or less
6.2	Product Analysis	-do-		3	One Heat	
7	Retest	7	IS 11513	If a test does not give the specified results, two additional tests shall be carried out at random on the same lot. Both retests shall conform to the requirements of this standard; otherwise, the lot shall be rejected.		
8	Freedom from defects	8	IS 11513	Adequate inspection as far as practically possible to ensure each coil to be free from surface defects.		
9	Dimensions & Tolerances	9.1 to 9.6	IS 11513, IS 1730, IS/ISO 16160	Adequate inspection to insure each coil to be within limits of specification. Any special tolerances to suit specific requirements shall be mutually agreed to between the manufacturer and the customer.		
10	Delivery	11.1 & 11.2	IS 11513	The material shall be supplied in coil form in hot rolled condition. The mass of the coil shall be as agreed to between the contracting parties. The material shall be firmly strapped to prevent damage during transit.		

**PROFORMA – 1.....**

**PROFORMA – 1**

**PROFORMA FOR OBTAINING PRODUCTION DETAILS**

Period covered

Name of Licensee

CM/L No.

- |     | Name of Articles (s)   | IS No. |
|-----|--|--------|
|     | Grade/Type/Size/Variety/Class/Rating   |        |
| 1.1 | Brand/Trade/Name(s) of BIS Certification Marked Products   |        |
| 2.0 | Total production of the articles(s)<br>licensed for certification marking  |        |
| 2.1 | Total production of the article(s)<br>conforming to Indian Standard  |        |
| 3.0 | Production covered with BIS<br>Certification Mark and its Value  |        |
|     | a) Quantity  |        |
|     | b) Value (Rs.)   |        |
| 3.1 | Brand Name used on production covered under BIS Certification Mark   |        |
| 3.2 | Calculation of marking fee on unit-rate basis; Marking Fee per unit  |        |
|     | a) Unit  |        |
|     | b) Quantity covered with BIS Certification Mark  |        |
|     | c) Marking fee rounded off in whole rupees as obtained by applying unit rates given in<br>(a) on quantity given in (b) |        |
|     | Note: In case a clause is not applicable, suitable remarks may be given against it.                                    |        |
| 4.0 | Quantity not covered with BIS Certification Mark. If any, and the reasons for<br>such non-coverage                     |        |
| 4.1 | Brand Name under which non certified goods were sold   |        |
| 5.0 | Quantity Exported with BIS Standard Mark and its value   |        |
| 5.1 | Brand Name under which BIS Certified goods are exported  |        |
| 6.0 | Authentication by Chartered Accountant   |        |