भारत सरकार Government of India

रेल मंत्रालय Ministry of Railways

रेलवे बोर्ड Railway Board

नं-2015/M(N)/951/17 नई दिल्ली,दिनांक 17.12.2018

महाप्रबंधक (यांत्रिक)

सभी जोनल रेलवे

Sub: Modification to prevent cracks in centre sill of BTPN wagons

Ref: RDSO's letter No. MW/BTPN dated 27/28.11.2018 (copy enclosed)

Please refer to above mentioned letter of RDSO wherein it has been requested to ensure the implementation of modification in centre sill of BTPN wagons.

The matter has been examined and it has been decided to make the said modification as NTXR rejectable defect.

Vivek 17/12/18

(विवेक मोहन)

निदेशक, यांत्रिक अभियांत्रिकी (माल-भाड़ा)

रेलवे बोर्ड

प्रतिलिपि :

1. कार्यकारी निदेशक, स्टैंडर्स, अनुसंधान अभिकल्प और मानक संगठन, लखनऊ
2. निदेशक, तटस्थ नियंत्रण परीक्षक- आवश्यक कार्यवाही हेतु

फैक्स / Fax : 91-0522-2452494
Tele/Fax: 0522- 2465776

सत्यमेव जयते

भारत सरकार –रेल मंत्रालय
अनुसंधान अभिकल्प और मानक संगठन
लखनऊ – 226011
Government of India - Ministry of Railways
Research Designs & Standards Organisation
Lucknow – 226011

No. MW/BTPN

Date: 27/11/2018

महा प्रबंधक (यांत्रिक)

1. मध्य रेलवे, छत्रपति शिवाजी टर्मिनस, मुम्बई– 400 001.
2. पूर्व रेलवे, फेयरली प्लेस, कोलकाता – 700 001.
3. उत्तर रेलवे, बड़ौदा हाउस, नई दिल्ली – 110 001.
4. दक्षिण रेलवे, पार्क टाउन, चेन्नई – 600 003.
5. दक्षिण मध्य रेलवे, रेल निलायम, सिकन्दराबाद – 500 071.
6. दक्षिण पूर्व रेलवे, गार्डेन रीच, कोलकाता – 700 043.
7. पूर्वोत्तर रेलवे, गोरखपुर – 273 012.
8. पूर्वोत्तर सीमान्त रेलवे, मालीगॉव, गुवाहाटी – 781 011.
9. पश्चिम रेलवे, चर्चगेट, मुम्बई – 400 020.
10. पूर्व मध्य रेलवे, हाजीपुर – 844 101.
11. पूर्व तटीय रेलवे, बीडीए रेंटल कालोनी, रेलवे काम्पलेक्स,चन्द्रशेखरपुरा, भुवनेश्वर–751023.
12. उत्तर मध्य रेलवे, हास्टिंग रोड, इलाहाबाद – 211 001.
13. उत्तर पश्चिम रेलवे, जयपुर – 302 006.
14. दक्षिण पश्चिम रेलवे, हुबली – 580 023.
15. पश्चिम मध्य रेलवे, जबलपुर – 482 001.
16. दक्षिण पूर्व मध्य रेलवे, आर ई आफिस काम्पलेक्स, बिलासपुर – 495 004.
17. कोंकण रेलवे कार्पोरेशन लिमिटेड, पोस्ट बाक्स नं0 9, बेलापुर भवन, सेक्टर –11, सीबीडी बेलापुर, नवी मुम्बई – 400614

Sub: Modification to prevent cracks in center sill of BTPN tank wagon.

In the year 2008-09, certain cases of cracks in center sill of BTPN wagons were reported by Zonal Railways. RDSO has issued the repair procedure vide RDSO Drg No. WD-08097-S-01 and letter No MW/BTPN dated 07/07/2009 for wagons detected with crack in Centre sill and wagons without any crack in Centre sill. These modifications are required to be carried out in next POH to prevent any reoccurrence of such failures.

Also, RDSO has altered the Drg No WD-86081-S-55 & 56 in July, 2009 for new wagons to strengthen the section to prevent the chances of occurrence of any cracks in the center sill of BTPN wagons.

In Aug, 2015 and Nov, 2017, two similar case of Centre sill failure were again reported in Western Railway & Central Railway respectively and it is observed that both the wagons were not modified during POH/ROH. These instructions for modification were recirculated to all Zonal Railways for implementation.

Recently in Oct, 2018 a case of such failure was again reported in GTM-HAR of North Central Railway. Culprit wagon found without modification even after POH and two ROH. Therefore all Zonal Railways are thereby once again requested to ensure the implementation of above modifications to prevent occurrence of cracks in the center sill of BTPN wagons

D.A.-Drg No WD-08097-S-01

(Mohammad saif)
For Director General /Wagon

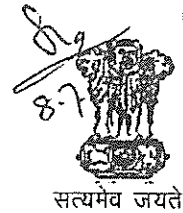
Copy to: EDME (Frt.), Railway Board, Rail Bhawan, New Delhi-110 001- For information.

(Railway Board)
3 DEC 2018

फैक्स / Fax : 91-0522-2452494
तार : 'रेलमानक' लखनऊ
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2450567 (DID)

Issued 8-7 Please issue Sd/ 7/7/09

S.No. 1229



भारत सरकार –रेल मंत्रालय
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लखनऊ - 226011
Government of India - Ministry of Railways
Research Designs & Standards Organization
Lucknow – 226011
dw1@rdso.railnet.gov.in

No. MW/BTPN

July 7, 2009

मुख्य कारखाना प्रबंधक

1. पश्चिम मध्य रेलवे, कोटा – 324002
2. उत्तर मध्य रेलवे, झाँसी – 248003
3. दक्षिण मध्य रेलवे, रायनापाडू
4. दक्षिण पूर्व रेलवे, खड़गपुर –721301
5. दक्षिण रेलवे, पैराम्बूर – 600023
6. पश्चिम रेलवे, प्रतापनगर, बडौदा – 390004

Sub: Repair procedure for center Sill Breakage/ Crack in BTPN Wagons.

The cases of cracks in flange portion of center sill (near bolster bottom plate towards head stock) in BTPN wagons have been reported by Railway workshops during POH.

RDSO has carried out the investigation to avoid such cases. A drawing no. WD-08097-S-01 Alt. NIL entitled **"Procedure for repair of center sill of BTPN wagon"** has been prepared for strengthening & repair of affected area of centre sill near body bolster plates in BTPN wagon.

224984

The item no. 1, 2, 3 & 4 shown in the drawing No. WD-08097-S-01, Alt. NIL are applicable only in those BTPN wagons where cracks have developed in the flange of center sill near body bolster plate.

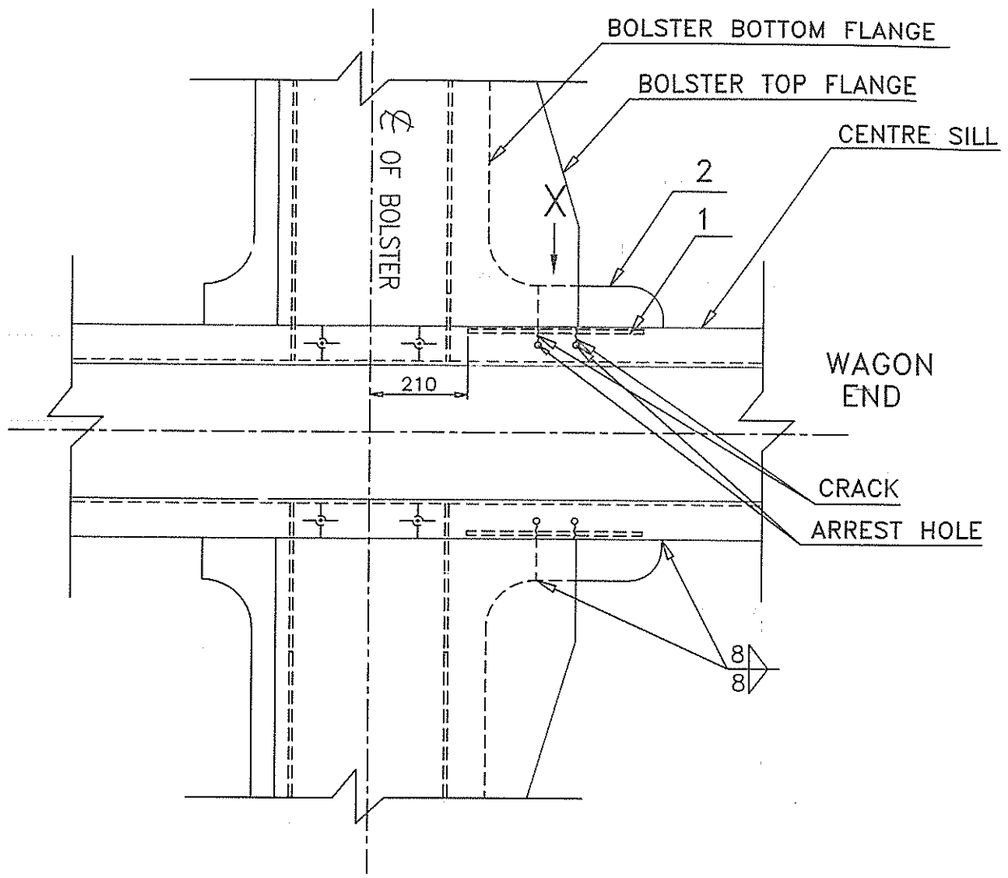
In other wagons, only stiffener plate is required as per item No. 4.

This procedure for repair of center sill is applicable for BTPN wagon manufactured prior to June'09.

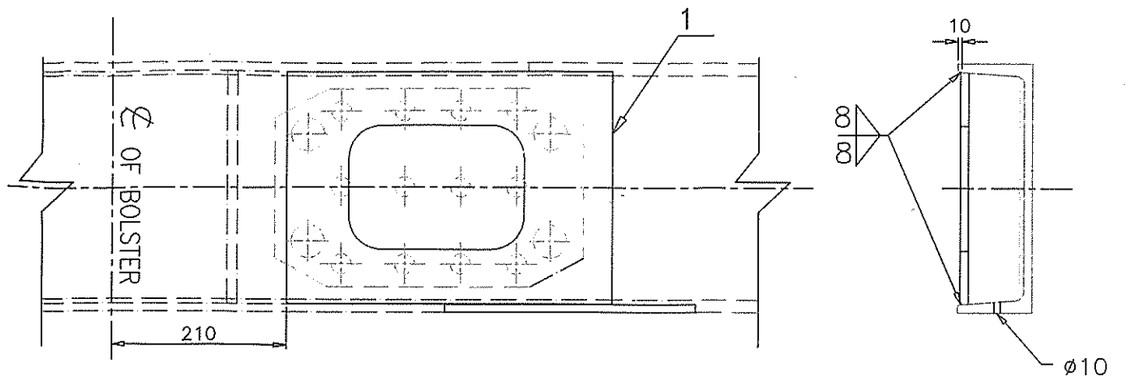
D. A. Drg No. WD-08097-S-01

(K. S. Jain)
Director/Wagon
For Director General/RDSO

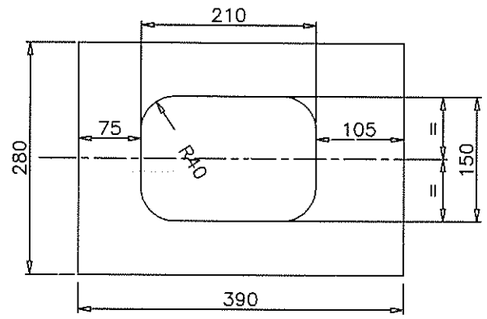
b/c



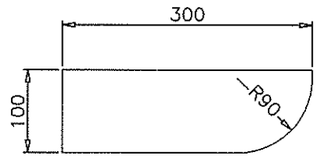
BOLSTER



DETAILS AT 'X'



1 (10 THICK)



2 (10 THICK)

NOTE:–

1. MAKE A HOLE OF 10mm DIA TO ARREST THE CRACK AT TOP/BOTTOM FLANGE OF CENTRE SILL AT CRACK LOCATION.
2. MAKE BEVEL FORMATION AT CRACK POSITION AND THEN PROPER WELDED WITH SUITABLE ELECTRODE AS PER SPEC. NO. G–72 (REV–3). AFTER THAT PLUG WELD THE ARREST HOLE.
3. EXTEND THE BOLSTER BOTTOM FLANGE WITH ITEM NO.2 AS SHOWN ABOVE.
4. PROVIDE ITEM NO.1 BETWEEN THE FLANGES OF CENTRE SILL AND WELDED PROPERLY.
5. BE ENSURE THAT WAGON MUST BE DEGASSED BEFORE COMMENCE THE REPAIRING WORKS.

ITEM	DESCRIPTIONS	NO. OFF	REF.DRG. IT. NO.	WT.OF ONE(Kg)	MATL.&SPEC.	REMARKS
2	STIFFENER	4			IS:2062 Fe 410	–
1	STIFFENER	4			IS:2062 Fe 410	–

SUPERSEDED BY			BOGIE POL TANK WAGON TYPE 'BTPN' 'BTPNHS'
SUPERSEDES		DATE	
SCALE	PASSED	11/08	PROCEDURE FOR REPAIRING OF CENTRE SILL OF BTPN WAGON
	CHECKED	11/08	
	DRAWN D.KUMAR	11/08	
	TRACED		
	J.S.NO. WD-08097	11/08	
B.G.	R.D.S.O. [W]	GROUP	WD–08097–S–01