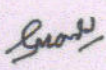
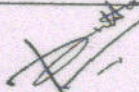

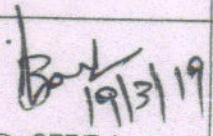


Annexure-D1

ANNEXURE-A to Routine inspection plan of Bogie Frame of WAG-9, WAG-9HC&WAP  
 No.ELDD/3751 dtd.29.08.09, Rev. Nil. ①  
 Guideline to manufacture bogie frame

SL. NO.	DESCRIPTION	GUIDELINE	REMARKS
1	Source of purchase item i.e.	From CLW approved source.	
	i) Pivot (1209-01.112-002)		
	ii) Spring guide (1209-01.212-003)		
	iii) Tube for head beam (1209-01.312-160) ②	DIN-2448 st-52 to be followed	Proposed Att ③
2	a) Welding process	a) G.M.A.W. (MIG) TOT documents of 72 pages.	
	b) Welding rod (Wire)	b) AWS A5.18, ER70S4/ER70S6	
	c) Shield Gas	c) ARGON (Argon Min. 80%)	
	d) Source of MIG wire & Shield Gas	d) RDSO Approved source	
	e) Welders qualification	e) Approved Welders	
3	Paint of Bogie Frame	PU Paints system (Two Packs) to RDSO Spec. No. M&C/PCN/100/09 or latest version. <u>Colour:</u> Green, Grey RAL7009 & RDSO Approved source.	

Prepared by	Checked by	Reviewed by	Specification for Fabricated Bogie Frame Complete for 3-Phase WAG-9, WAG-9H, WAG-9HC, WAP-7 & WAP-5 Locomotives. ①	Approved by	Spec. No.
 SSE/Drg.	 SSE/Drg.	 SEE/D&D		 Dy.CEE/D-I	CLW/MS/3/Bogie/003

Att ① ②