

No. RW/NH-34059/1/2004-S&R (B) Pt-II(5)

Dated, the 28th March 2007

To

The Chairman, National Highway Authority of India; The Director General (Border Roads); All Chief Engineers of States/UTs/PWDs (dealing with National Highways and other Centrally sponsored schemes).

Subject : Empanelment of Suppliers/Manufacturers of Expansion Joints–Approval for Renewal for Local Manufacturing of the Edge Beam of Single Strip Seal Expansion Joint for the already empanelled section and also for the New Section RS A 80 Type-2, as well as approval for Local Manufacturing of the Rubber Seal.

Ref: (i) This Ministry's letter No. RW/NH-34059/1/96-S&R dated 30.11.2000 its corrigendum dated 25.1.01.
(ii) This Ministry's letter No. RW/NH-34059/1/96-S&R dated 20.2.2001.
(iii) This Ministry's letter No. RW/NH-34059(1)/1/2003/S&R(B) dated 28.06.04.

Ministry has empanelled M/s Metal Engineering & Treatment Co. Pvt. Ltd. (METCO), Kolkata vide letter under reference (ii) above for supply of expansion joints in collaboration with their foreign principal M/s Mageba Sa, Switzerland Subsequently, Ministry vide its letter under reference (iii) above permitted M/s Metal Engineering & Treatment Co. Pvt. Ltd. (METCO), Kolkata for local manufacturing of the edge beam for single strip seal expansion joints having the similar sectional profile as indicated in page 3/7 of **Annex-I** of Ministry's letter under reference (ii) (copy enclosed).

1.1 Now, M/s Metal Engineering & Treatment Co. Pvt. Ltd. (METCO), Kolkata has requested for:

- (i) Renewal for local manufacturing of edge beam already empanelled with the Ministry vide letter under reference (ii).
- (ii) Approval for local manufacturing of the edge beam of alternative section RSA 80 Type 2 for single strip seal expansion joint.
- (iii) Local manufacture of the rubber seal.

1.2 The aforementioned request of M/s Metal Engineering & Treatment Co. Pvt. Ltd. (METCO), Kolkata, has been examined as per Revised Interim Specification (RIS) for expansion joints issued vide Ministry's letters under reference (i). Accordingly, the local manufacturing of edge beam of single strip seal expansion joints for the section empanelled by Ministry vide letter under reference (ii), and alternative section RSA 80 Type 2 are being approved. The request for local manufacturing of the rubber seal is also being approved. This approval for local manufacturing of edge beams as well as local manufacturing of the rubber seal is subjected to following conditions:

- (a) The sectional profile of the existing edge beam shall be as indicated in page 3/7 of **Annex-I** of Ministry's letter No. RW/NH-34059/1/96-S&R dated 20.02.2001 (copy enclosed). The sectional profile of the alternative edge beam section RS A80 Type 2 shall be as indicated in **Annex-II**. Some of the details of this RS A Type 2 section are as follows: height of the section is 80 mm, width of flange is 45 mm, thickness of flange is 20 mm, thickness of web is 12 mm, thickness of lip is 6 mm.
- (b) The finished joints including anchorage as well as rubber seal shall conform to the specifications given in the Ministry's RIS issued vide letter under reference (i) above. The rubber seal shall satisfy all the properties as mentioned for strip seal element in Table 2 of Ministry's RIS.

1.3 M/s Metal Engineering & Treatment Co. Pvt. Ltd. (METCO), Kolkata, shall maintain proper record for supply of sealing element and shall produce the same to the clients on their demand for verification.

1.4 The firm shall conduct all the tests as specified in the relevant clauses of RIS. In addition to that, following tests shall also be carried out by the firm:-

- a) Debris expulsion test
- b) Dye penetration test for all critical welds.
- c) Random checking of paint film thickness by elachometer.
- d) Dimensional check of the finished joints as per approved drawing.

1.5 Standard procedure of sampling shall be adopted for all the above tests. The client before procurement/ installation may ensure and satisfy themselves that the firm has conducted all the tests on expansion joints as specified above and the joints fulfill the acceptance criteria as per para 6 on page 11 of the RIS.

1.6 While arranging the supply of the expansion joints with these locally manufactured edge beams as well as locally manufactured rubber seal, a warranty of trouble free performance for atleast ten years should be obtained from M/s METCO, Kolkatta. The joint showing any defect during this period shall be got repaired/replaced by M/s METCO, Kolkata at their own cost, failing which, they may be debarred from the list of the empanelled suppliers.

1.7 M/s Metal Engineering & Treatment Co. Pvt. Ltd. (METCO), Kolkata shall maintain record of all single strip seal expansion joints supplied with locally manufactured edge beams as well as locally manufactured rubber seal. Besides the firms shall get their joints tested once in a year for all the tests including dynamic test through an Independent body like CRRI, IITs or similar organizations or laboratory accredited by NABL. An annual report in this regard containing installation details and performance of the joints along with the test certificate shall be submitted to the Ministry in the month of January for the every preceding year. Further M/s Metco will continue to have quality checks by M/s TUV South Asia and send their samples of neoprene sealing element to M/s Mageba Switzerland twice in a year for their inspection similar to that provided in their licence agreement with the parent firm for the export of the product.

2. This approval shall be valid up to 31.03.2009 subject to the condition that there will be no structural change in the collaboration of the firm with their respective foreign principal. The firm is requested to submit the supporting document showing collaboration with their respective foreign principal upto the period for which the approval is granted. Any change in collaboration may be intimated to the Ministry for further necessary action. For further renewal, the firm may request along with the submission of following documents three months prior to the expiry date of this approval:

- i) Test report for the material being used for edge beam from a laboratory having accreditation from National Accreditation Board for Testing and Calibration Laboratories (NABL) or a CSIR/ISO recognized laboratory, satisfying the requirements as per Ministry's/IRC Specifications.
- ii) Test report for rubber seal from NABL laboratory or a CSIR laboratory satisfying the requirements as per Ministry's/IRC Specifications.
- iii) Details of joints supplied with locally manufactured edge beam their performance report.

3. This letter supersedes the Ministry's letters, No. RW/NH/34059(1)/2003/S&R(B) dated 28.06.04 and RW/NH-34059/1/2004-S&R(B) dated 05.07.2006.

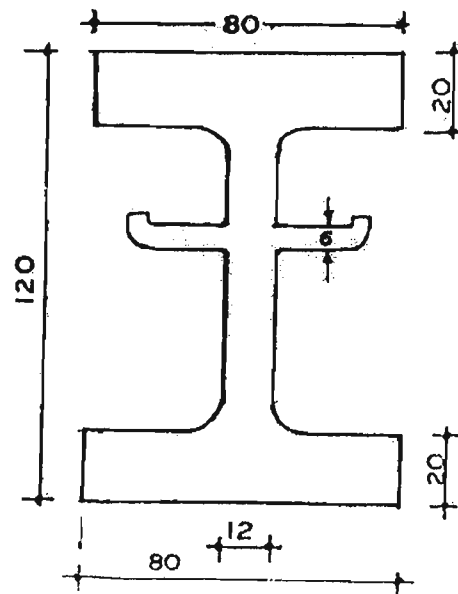
4. The Ministry reserves the right to revoke the permission at any time, in case of any deficiency due to non adherence of the specifications given in the RIS, as well as Ministry's circulars/guidelines issued from time to time. This stands applicable also, in case, if any defect in the performance/quality of the joints is noticed.

5. The contents of the circular may please be brought to the notice of all the officers in your department concerned with bridges on National Highways and other centrally sponsored schemes.

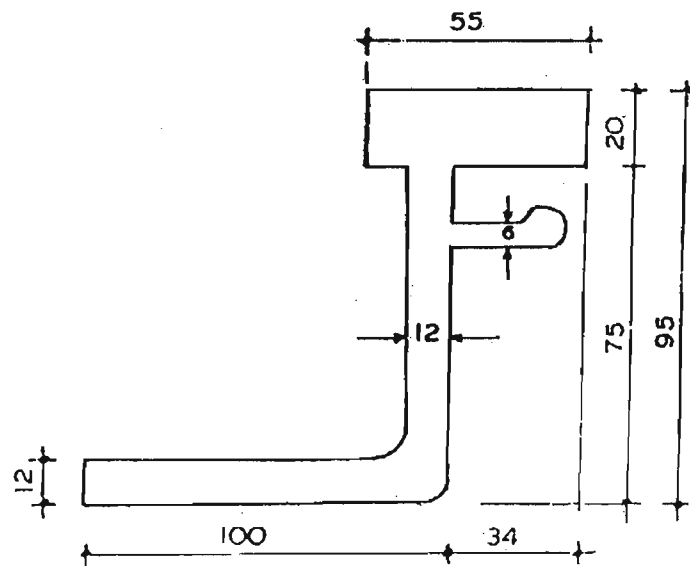
(Enclosure to Ministry of Shipping, Road Transport & Highways, (Department of Road Transport & Highways),
letter No. RW/NH-34059/1/96/S&R dated 20.2.2001)

Annex-I

**MAGEBA SA
EDGE BEAMS & CENTRAL BEAMS FOR EXPANSION JOINTS**



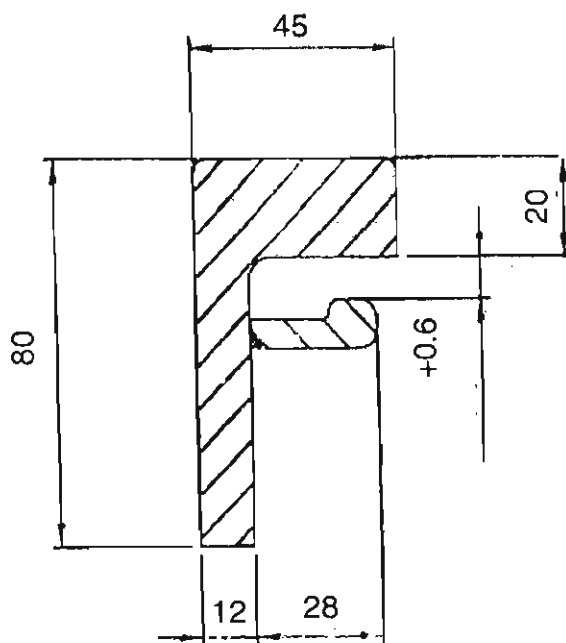
CENTRE BEAM/LAMCLLA OF MAGEBA MODULAR EXPANSION JOINT



**EDGE BEAM OF MAGEBA STRIP SEAL
UNITARY & MODULAR JOINT**

METCO PVT. LTD.
Name of Supplier

mageba	Edge-Beam RS-A/7 Type 2	Object
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mageba

Material: 2062 GR:A/S235 JR G2 of EN 10025
Area: 1820 mm²

Edge Beam (Type-2)
For mageba-India RS A80 Type Single
Strip Seal Joint
All Dimensions are in mm