

2003.1.4 Cast Steel

Cast steel shall be in accordance with Clause 1009.1 of these Specifications.

For the purpose of checking the soundness, castings shall be ultrasonically examined following procedures as per IS:7666, with acceptance standard as per IS:9565. The castings may also be checked by any other accepted method of non-destructive testing as specified in IS:1030.

Quality level of castings shall be Level 3 as per IS:9565.

2003.1.5 Stainless Steel

Stainless steel shall be in accordance with Clause 1009.7 of these Specifications.

2003.1.6 Welds

Welding of steel conforming to IS:2062 shall be as per IS:1024 using electrodes as per IS:814.

2003.1.7 Grease

The grease for bearings shall conform to the requirements of IS:503 (Grade 4).

2003.2 Construction Operations

- a) All work of steel bearings shall conform strictly to the drawings and shall be in accordance with the provisions of this Section. Care shall be taken to ensure that all parts of an assembly fit accurately together. The workmanship shall satisfy all relevant provisions laid down in Section 1900 of these Specifications.
- b) Knuckle pins, rolling surfaces of the rollers and bearing surface of the bearing plates shall be machined and all bolt holes shall be drilled. The whole bearing shall be fitted and finished as required for good quality machined work to the satisfaction of the Engineer. However, in case of bearings which are to be grouted or bedded on a suitable yielding material, any surface which is to be in permanent contact with the grout or the yielding material, may be left unmachined.
- c) In prestressed concrete construction involving launching of girders, slipping or jumping of rollers due to vibration or jolts, shall be avoided and adequate measures shall be taken to ensure that the roller assembly is not disturbed. It is normal practice to provide rocker bearings at the

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