

MANUFACTURING RAW MATERIAL SPECIFICATIONS

PROJECT-1

ANGLE TRANSMISSION TOWERS

1. Raw Material

A. Steel (Angles, Flats, Structure Plates, etc.)

- Material: Hot-Rolled mild steel or high tensile steel
- Common grades:

➤ IS 2062 Grade E250 / E350 / E410 (INDIA)

➤ ASTM A36 , A572 Grade 50 (USA)

➤ EN 10025 S235JR / S355JR (EUROPE)

- Shapes: Equal or unequal angles, channels, files

B. Fasteners

- Bolts/Nuts material: High-tensile steel
- Grades:

➤ ISO 898- Class 8.8 or 10.9

➤ ASTM A325 / A 490

C. Galvanizing

- Zinc coating thickness:
 - Minimum 610 g/m² (equivalent to 85 microns) for steel > 6 mm thickness
 - As per IS 4759 / ASTM A123 / ISO 1461

2. Fabrication standards

- CNC Automatic machine , cutting, punching, bending as per IS 802, IEC 60652 at CNC

3. Applicable Standards:

IS 2062, IS 802, IS 4759, ASTM, A123, IEC 60652, ISO 898-1