

**Enquiry items along with quantities:**

It. no	Size & Item description	Technical requirement	Quantity in kg
1	Structural Steel Rail Section- 45kg/ meter as per IS:3443 X 5000 mm – 6000 mm LG	Structural steel rail section- 45kg/meter as per IS:3443. Material shall be supplied in random length of 5-6 meter (total length-150 meter), material test certificate covering all chemical and mechanical properties shall be furnished along with the supply .	7035
TOTAL			7035 kg

Supplies quantity are to be restricted between 7035 kg & 6700 kg

Note- (a): Vendor to submit QAP based on reference document(s) as per their internal manufacturing process for approval from BHEL QA division. QAP shall be as per enclosed format QA/HT/INDENT/034 R-00 Dated-17.06.2020.

**Pre-qualification criteria:**

The bid is invited from manufacturers / authorized representative of the OEMs for supply of Rail section as per IS 3443 and in line with Item description in BHEL enquiry.

Sl. No.	Description of Technical Pre-Qualification Requirement	Vendor Response	
		Complied / Not Complied	Supporting Documents required to accept compliance
1	Manufacturers / OEM of agents should have experience of successfully supplying the above items during the last ten years.	YES / NO	1.Certificate of being a manufacturer (for manufacturer) / authorization (for authorized representative) with validity. 2. OEM's name and address (for authorized representative). 3. List of past supplies of Rail sections (copy at least two unpriced purchase orders along with their Invoice / Delivery challan supplied in last 10 years).
2	Manufacturers / OEM of agents (or subsidiaries) should have a strong and robust quality management system. Alternatively, ISO 9001-2015 / compliance with any other norms / standard should be existing.	YES / NO	Valid certificate / QMS of (Manufacturers / OEM of agents (or subsidiaries) with validity is required at the pre-qualification stage.
3	Vendor should furnish any 3 years' audited balance sheet of last 7 financial years. FY ending 2019 – 20.	YES / NO	Audited copy of balance sheets.

Note-(b):

1. BHEL has right to verify information / confirmation furnished, by asking additional documents, proofs etc.
2. The reference date for ten-year experience shall be the date of enquiry.
3. Authorized representative shall furnish relevant experience of their OEM for evaluation.

**ALL THE ABOVE POINT WISE PRE-QUALIFICATION REQUIREMENT ARE TO BE NECESSARILY ACCEPTED BY THE BIDDERS FOR THEIR OFFERS TO BE CONSIDERED FAILING WHICH OFFERS SHALL BE REJECTED.**

**MAKE IN INDIA format**

**BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL  
MATERIAL MANAGEMENT – STEEL DIVISION**

*For this Procurement, Government of India Public Procurement (Preference to Make in India), Order 2017 with its amendments and subsequent Orders issued by the respective nodal ministries shall be applicable even if issued after issue of this NIT but before finalization of contract/PO/WO against this NIT.*

*As per the Provisions of this order, please submit **a self-certification complying with the conditions below on company letterhead duly signed by competent authority.***

*I ..... hereby declare on behalf of M/s. .... that we are participating in the Enquiry No. .... floated by BHEL, Bhopal (MP), India and shall comply with following:*

1. *Public Procurement (Preference to Make in India), Order 2017 with its amendments and subsequent Orders issued by the respective nodal ministries shall be applicable even if issued after issue of this NIT but before finalization of contract/PO/WO against this NIT.*

(a) *A supplier will be treated as “**Class-I Local Suppliers**”, if the items quoted by bidder have local content equal to or more than 50%.*

(b) *‘**Local Content**’ means the amount of value added in India, which shall be total value of item quoted (excluding net domestic indirect taxes) minus the value of imported content in the item (including all custom duties) as a proportion of the total value, **in percent.***

2. *I hereby declare that our firm qualifies as “**Class-I Local Suppliers**”.*

**a. The Local Content in the items quoted under this Enquiry is ..... Percent**

**b. Details of location(s) in India where this value addition shall be done, is/are as follows:**

(a) .....

(b) .....

(c) .....

(.....)

For M/s. ....

*(Seal & Sign)*



## QUALITY ASSURANCE- HYDRO (QWT)

ITEM:	RAIL SECTION
REFERENCE DOCUMENT:	STANDARD: IS- 3443 (PROVIDED BY H.T.E.)
ENQUIRY / INDENT NO.	240214356
QAP NO, REVISION & DATE	QA/HT/INDENT/034 R-00 DATED-17.06.2020

1. Vendor to submit QAP based on reference document(s) as per their internal manufacturing process for approval from BHEL QA division.
2. QAP shall be as per enclosed format. Minor modifications in the format for adding rows & pages are allowed, however, basic format shall remain intact.

*Aadhar*  
आधार शर्मा / AADHAR SHARMA  
वरि. अभियंता (र्यूडक्वूटी.) / Sr. Engineer (QWT)  
गुणता नियंत्रण-जल दरबाईन / Quality Control-WTM  
बी.एच.ई.एल. भोपाल / BHEL, BHOPAL



MANUFACTURER'S NAME AND ADDRESS:

.....  
 .....  
 .....

## STANDARD MANUFACTURING QUALITY PLAN

ENQUIRY / INDENT NO.:  
240214356

ITEM : RAIL SECTION

QAP NO: QA/HT/INDENT/034 R-00  
DATED-17.06.2020

REFERENCE DOCUMENT(S): STANDARD:  
IS- 3443

SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOC.	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY		REMARKS
					M	B				D*	M	B	
1.	2.	3.	4.	5.	6.		7.	8.	9.	D*	** 10.	11.	
1.	Raw Material Inspection												
2.	In process Inspection												
3.	Final inspection												
QA-HYDRO			<p><b>LEGEND:</b> * RECORDS, IDENTIFIED WITH "TICK" (√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION.            ** M: MANUFACTURER/SUB-SUPPLIER B:BHEL/ BHEL APPOINTED INSPECTION AGENCY            P: PERFORM W: WITNESS AND V: VERIFICATION IR-INSPECTION REPORT            QCR-QC REPORT TC-TEST CERTIFICATE RR – REVIEW OF RECORD            COC: CERTIFICATE OF COMPLIANCE</p>									ACCEPTED BY (VENDOR'S QC REPRESENTATIVE)	

610129/2021/HEP-HTE40200

**IS : 3443 - 1980**  
**(Reaffirmed 1999)**  
**Edition 2.1**  
**(1983-10)**

*Indian Standard*  
**SPECIFICATION FOR  
CRANE RAIL SECTIONS**  
*( First Revision )*

(Incorporating Amendment No. 1)

UDC 669.14-424 : 621.873

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**BUREAU OF INDIAN STANDARDS**  
**MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG**  
**NEW DELHI 110002**

**Price Group 4**

*Indian Standard*  
**SPECIFICATION FOR  
 CRANE RAIL SECTIONS**  
*( First Revision )*

Structural Sections Sectional Committee, SMDC 6

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SHRI AMIT KUMAR BHATTACHARYA (*Alternate*)

(*Continued on page 2*)

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*Indian Standard*  
**SPECIFICATION FOR  
 CRANE RAIL SECTIONS**  
*( First Revision )*

**0. FOREWORD**

**0.1** This Indian Standard (First Revision) was adopted by the Indian Standards Institution on 4 June 1980, after the draft finalized by the Structural Sections Sectional Committee had been approved by the Structural and Metals Division Council.

**0.2** This standard was first published in 1966. In this revision the range of rail sizes has been enlarged to include some of the sections commonly used in the industry.

**0.3** A supplementary list of rail sections covering the 125 kg/m rail (earlier designated as CR 140) a few non-metric railway rails and some non-metric and metric crane rails which are in regular use is given in Appendix A.

**0.4** In the formulation of this standard assistance has been derived from:

IRS-T12-64 Flat bottom railway rails, Ministry of Railways,  
 Government of India.

GOST 4121-76 Crane rails gosudarstvennyj komitet standartov,  
 Meri Izmeritel'nyh Priborov SSSR (USSR).

**0.5** This edition 2.1 incorporates Amendment No. 1 (October 1983). Side bar indicates modification of the text as the result of incorporation of the amendment.

**0.6** For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960\*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

## **1. SCOPE**

**1.1** This standard lays down the dimensions, shape and other requirements of crane rail sections.

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\*Rules for rounding off numerical values (*revised*).

**610129/2021/HEP-HTE40200**

IS : 3443 - 1980

**2. GENERAL REQUIREMENTS FOR THE SUPPLY OF MATERIAL**

2.1 General requirements relating to supply of material shall be as laid down in IS : 1387-1967\*.

**3. DESIGNATION**

3.1 Crane rail sections conforming to this standard shall be designated by the letters ISCR followed by the head width of the rail section in millimetres. However, the crane rail sections covered in Appendix A shall be designated by the weight in kg/m.

3.2 For shop marking and drawing office purposes, abbreviated reference symbol CR instead of ISCR may be permitted provided specific understanding exists between the producer, drawing office and fabricator.

**4. CHEMICAL COMPOSITION**

4.1 The material when analysed in accordance with the appropriate part of IS : 228† and its relevant parts, shall have any of the chemical compositions on the finished product given in Table 1. The location of sample for chemical analysis shall be as shown in Fig. 1.

**TABLE 1 CHEMICAL COMPOSITION, PERCENT**

DESIGNATION ACCORDING TO IS : 1762 (Part I)-1974*		C	Mn	Si	S	P
					<i>Max</i>	<i>Max</i>
NEW	OLD					
55C11	C55Mn1	0.50-0.60	0.95-1.25	0.05-0.30	0.060	0.060
50C12	C50Mn1	0.40-0.60	0.90-1.45	0.03-0.30	0.060	0.060

\*Code of designation of steel: Part I Based on letter symbols (*first revision*).

**5. TENSILE PROPERTIES**

5.1 The tensile test specimen shall be located as shown in Fig. 1 when tested in accordance with IS : 1608-1972‡, the steel shall have a minimum tensile strength of 710 MPa (72 kgf/mm<sup>2</sup>), with a minimum elongation of 14 percent on a gauge length of  $5.65\sqrt{S_0}$  where  $S_0$  is the area of cross section of the specimen in the gauge length.

\*General requirements for the supply of metallurgical materials (*first revision*).

†Methods of chemical analysis of steels (second revision being issued in parts).

‡Methods for tensile testing of steel products (*first revision*).

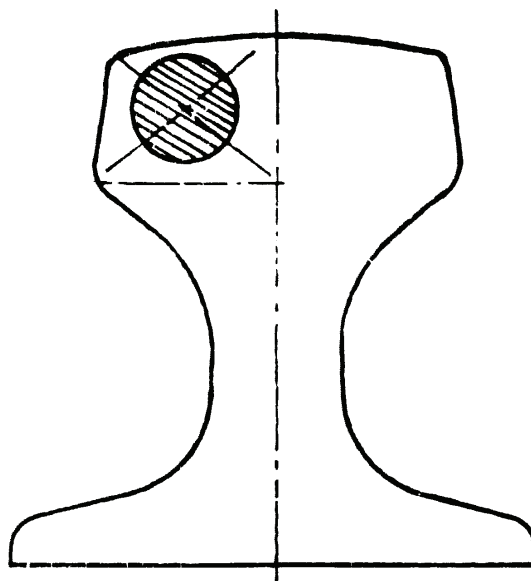


FIG. 1 LOCATION OF SAMPLE FOR CHEMICAL ANALYSIS AND TENSILE TESTING

## 6. HARDNESS

6.1 The hardness of the rail head when tested in accordance with IS : 1500-1968\* shall be not less than 200 *HB*.

## 7. SAMPLING

7.1 The number of samples to be tested for chemical analysis, tensile properties and hardness shall be one for every 100 tonnes or part thereof subject to a minimum of one specimen per cast.

## 8. DIMENSIONS, TOLERANCES AND SECTIONAL PROPERTIES

8.1 The dimensions of crane rail sections shall be as given in Table 2. Calculated sectional properties based on these dimensions are given in Table 3.

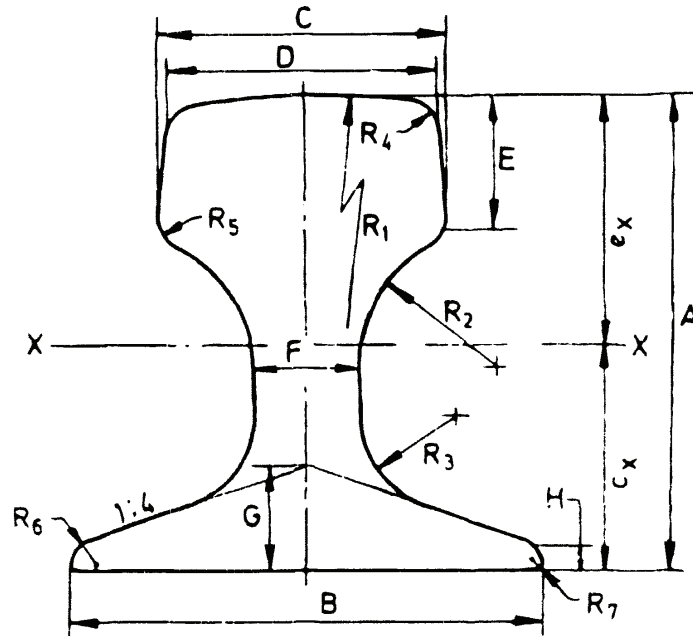
8.2 The tolerances on various dimensions of crane rail sections shall be as given in Table 4.

8.3 The dimensions of some of the rail sections commonly used in the country are covered in Appendix A along with relevant tolerances and sectional properties.

---

\*Method for Brinell hardness test for steel (*first revision*).

**TABLE 2 DIMENSIONS OF CRANE RAILS**  
( Clause 8.1 )



DESIG-  
NATION

DIMENSIONS, mm

	A	B	C	D	E	F	G	H	R <sub>1</sub>	R <sub>2</sub>	R <sub>3</sub>	R <sub>4</sub>	R <sub>5</sub>	R <sub>6</sub>	R <sub>7</sub>
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)	(14)	(15)	(16)
ISCR 50	90	90	55	50	25	20	20	9.70	300	26	18	6	6	5	1.5
ISCR 60	105	105	65.5	60	27.5	24	22	9.82	350	32	20	6	6	5	1.5
ISCR 80	130	130	87	80	35	32	26	9.75	400	44	26	8	8	6	1.5
ISCR 100	150	150	108	100	40	38	30	11.2	450	50	30	8	8	8	2
ISCR 120	170	170	129	120	45	44	35	15.3	500	56	34	8	8	8	2
ISCR 140	170	170	150	140	50	60	40	20.6	700	60	40	10	10	10	3

**9. FREEDOM FROM DEFECTS**

**9.1** The rails should be reasonably free from twist and the camber shall not exceed 0.2 percent of the length.

**9.2** The asymmetry of the rail cross section with respect to the vertical axis shall not exceed 2 mm and 0.6 mm in the rail flange and head respectively.

**TABLE 3 SECTIONAL PROPERTIES OF CRANE RAIL SECTIONS***( Clause 8.1 )*

DESIG- NATION	CROSS SECTIONAL AREA	WEIGHT*	POSITIONS OF CENTRE OF GRAVITY		MOMENTS OF INERTIA		SECTION MODULI		
			$c_x$	$e_x$	$I_x$	$I_y$	$Z_{x1}$ $=I_x/c_x$	$Z_{x2}$ $=I_x/e_x$	$Z_y$ $=I_y/b_2$
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)
	cm <sup>2</sup>	kg/m	cm	cm	cm <sup>4</sup>	cm <sup>4</sup>	cm <sup>3</sup>	cm <sup>3</sup>	cm <sup>3</sup>
CR 50	38.0	29.8	4.32	4.68	357.5	111.4	82.8	76.4	24.8
CR 60	51.0	40.0	4.83	5.67	654.6	195.9	136	116	37
CR 80	81.8	64.2	6.47	6.53	1 524	468.6	233	233	72.1
CR 100	113	89.0	7.63	7.37	2 806	920	368	381	123
CR 120	151	118	8.69	8.31	4 794	1 672	552	577	197
CR 140	187	147	8.75	8.25	5 528	2 609	632	670	307

\*On the basis of density of steel = 7.85 kg/dm<sup>3</sup>.**TABLE 4 TOLERANCES***( Clause 8.2 )*

All dimensions in millimetres.

DIMENSION	RAIL SECTION		
	ISCR 50, 60 and 80	ISCR 100	ISCR 120 and 140
Head width	± 2	± 2	+ 2 - 3
Thickness of head	± 1	± 1	± 1
Flange width	± 2	+ 2 - 3	+ 2 - 4
Web thickness	± 2	± 2	± 2
Height	± 1	± 1.5	± 2
Length	+ 100 0	+ 100 0	+ 100 0
Weight	+ 3 - 2 percent	+ 3 - 2 percent	+ 3 - 2 percent

**10. MARKING****10.1** Crane rail sections shall be marked with the following details:

- a) Manufacturer's identification mark, and
- b) Designation ( see 3.1 and Tables 2 and 3 ).

## 610129/2021/HEP-HTE40200

IS : 3443 - 1980

10.1.1 The material may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

## A P P E N D I X A

( Clauses 0.3 and 8.3 )

## SUPPLEMENTARY LIST OF CRANE RAIL SECTIONS

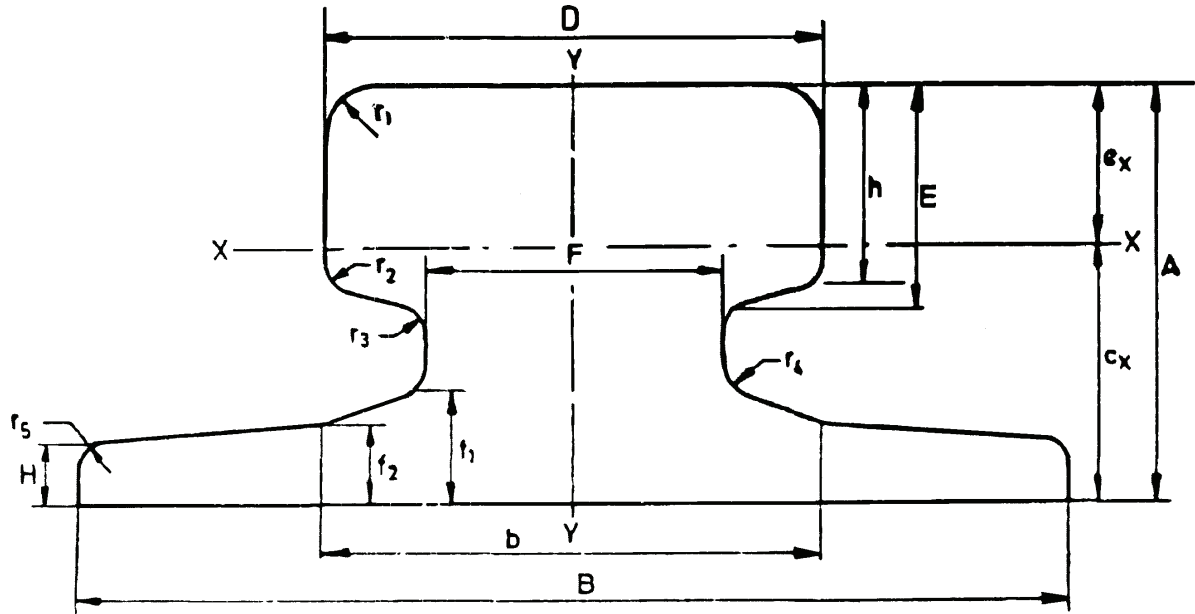
A-1. The dimensions of 22, 30, 32, 43, 45, 52A, 52B, 57, 67, 74, 75, 101 and 125 kg/m crane rail sections are given in Table 6 and Fig. 2 to 8. The sectional properties are given in Table 5.

TABLE 5 SECTIONAL PROPERTIES OF NON-METRIC CRANE RAIL SECTIONS

DESIGNATION	AREA	WEIGHT	MOMENT OF INERTIA	SECTION MODULUS	RADIUS OF GYRATION	DISTANCES OF NEUTRAL AXIS	REFERENCE TO FIG./TABLE
(1)	(2)	(3)	$I_{xx}$	$Z_{xx}$	$r_{xx}$	$e_x$	(8)
kg/m	cm <sup>2</sup>	kg/m	cm <sup>4</sup>	cm <sup>3</sup>	cm	cm	
22	28.3	22.2	91	27.5	1.79	3.31	Table 6
30	38.0	29.8	681	116	4.23	5.87	Fig. 2
32	40.7	32.0	182	46.9	2.11	3.88	Table 6
43	55.4	43.5	327	73.7	2.42	4.44	Table 6
45	56.7	44.5	1 584	212	5.30	7.48	Fig. 3
52.1	66.0	52.1	1 204	199	4.27	6.64	Fig. 4
52.2	66.5	52.2	1 270	198	4.37	6.43	Fig. 5
57	72.1	56.6	545	109	2.74	5.00	Table 6
67	85.4	67.0	2 705	311	5.63	8.70	Fig. 6
74	94.8	74.4	895	170	3.07	5.21	Fig. 7
75	95.6	75.2	888	170	3.05	5.21	Table 6
101	129	101	1 420	249	3.32	5.70	Table 6
125	158	122	3 745	492	4.87	7.60	Fig. 8

TABLE 6 DIMENSIONS OF 22, 32, 43, 57, 75 AND 101 KG/M  
CRANE RAIL SECTIONS

( Clause A-1 )



DESIG-  
NATION

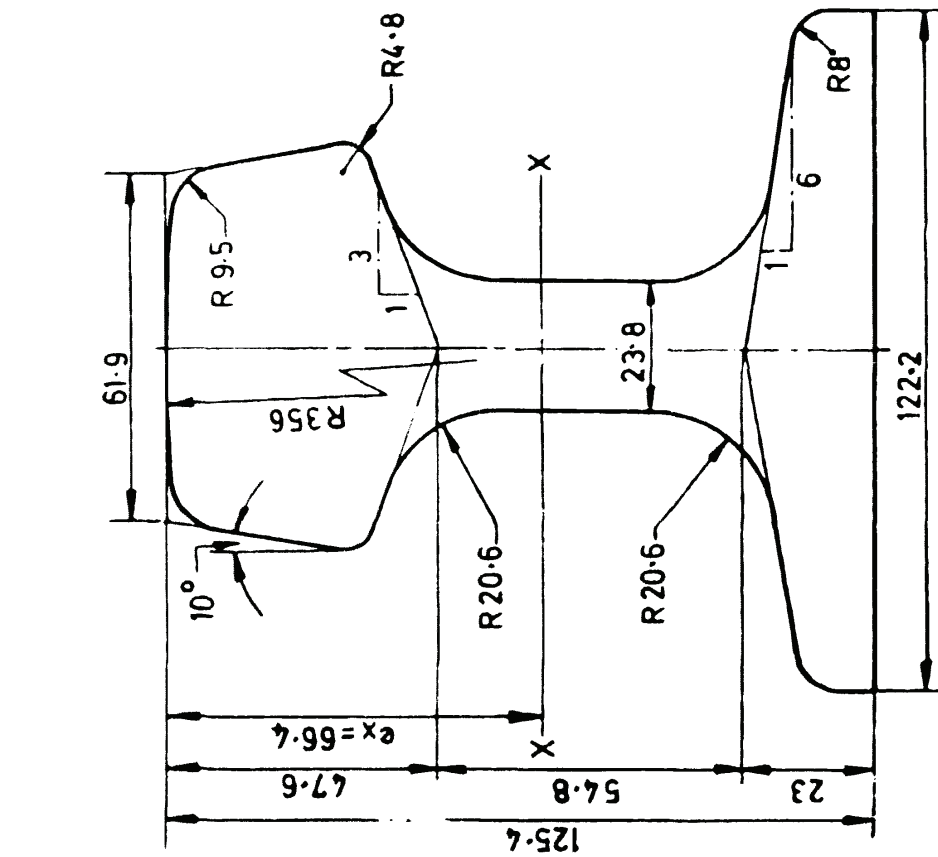
DIMENSIONS, mm

	$D$	$B$	$b$	$F$	$f_1$	$f_2$	$H$	$A$	$E$	$h$	$r_1$	$r_2$	$r_3$	$r_4$	$r_5$
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)	(14)	(15)	(16)
22	45	125	54	24	14.5	11	8	$55 \pm 1$	24	20	4	3	4	5	4
32	55	150	66	31	17.5	12.5	9	$65 \pm 1$	28.5	25	5	5	5	6	5
43	65	175	78	38	20	14	10	$75 \pm 1$	34	30	6	5	5	6	5
57	75	200	90	45	22	15.4	11	$85 \pm 1$	39.5	35	8	6	6	8	6
75	100	200	100	60	23	16.5	12	$95 \pm 1.5$	45.5	40	10	6	6	8	6
101	120	220	120	72	30	20	14	$105 \pm 1.5$	55.5	47.5	10	6	10	10	6

## A-2. TOLERANCES

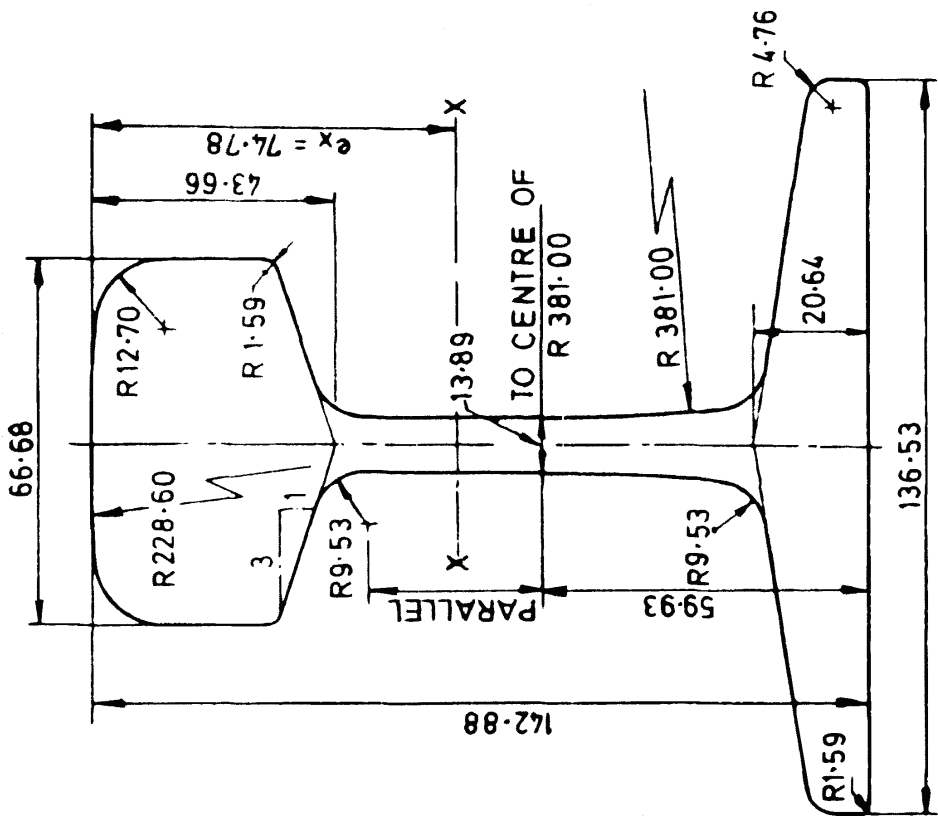
A-2.1 The tolerances on the dimensions and weight of crane rails covered in this appendix shall be as given in Table 7.





All dimensions in millimetres.

FIG. 4 52.1 kg/m CRANE RAIL SECTION

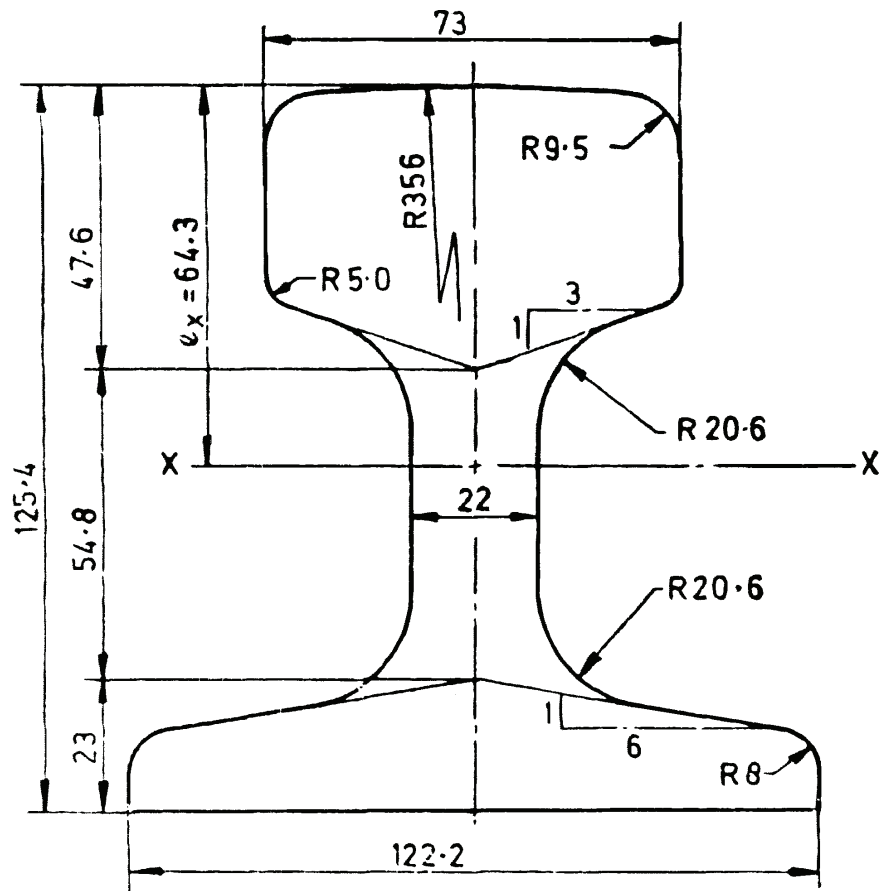


All dimensions in millimetres.

FIG. 3 45 kg/m CRANE RAIL SECTION

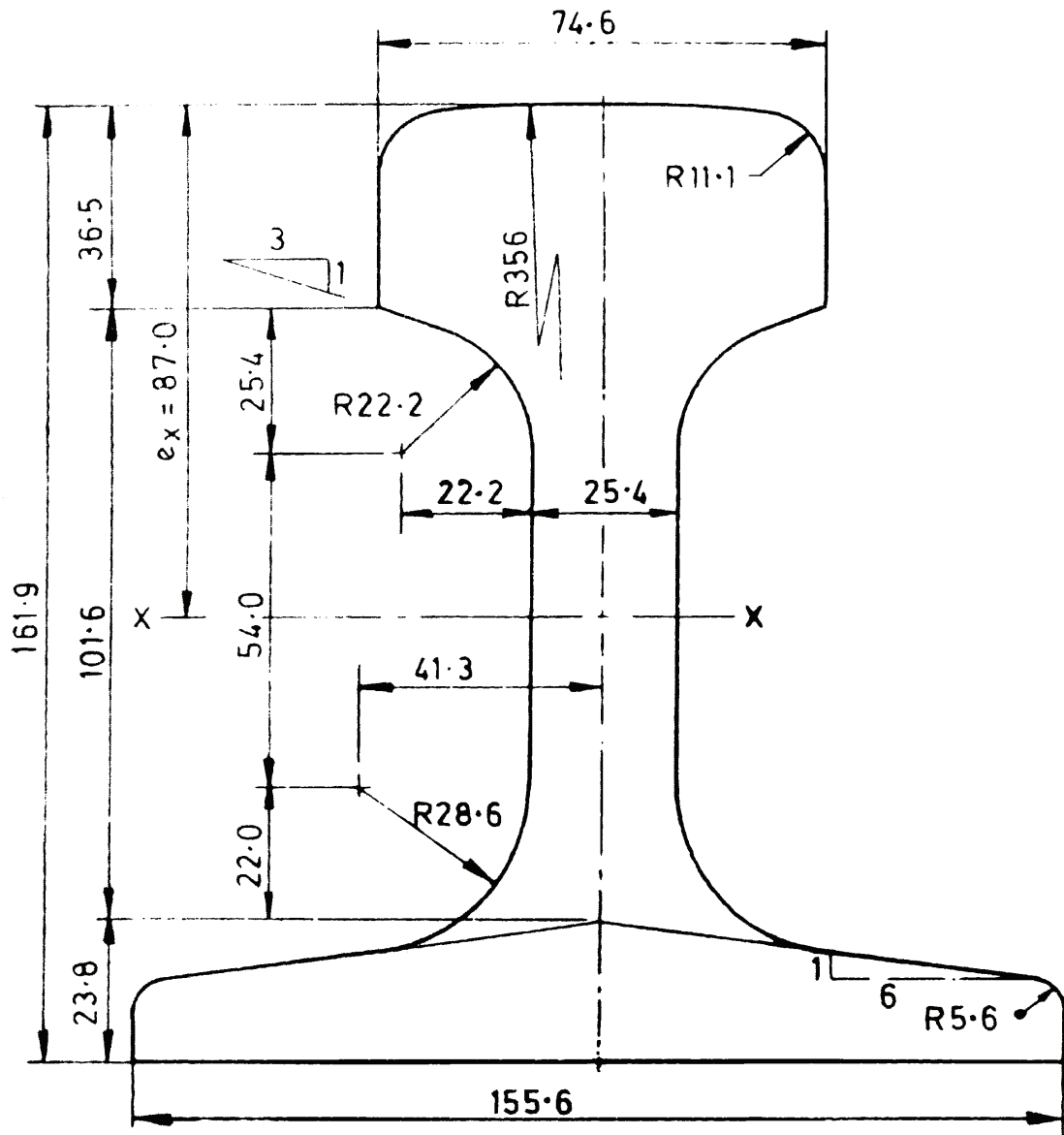
610129/2021/HEP-HTE40200

IS : 3443 - 1980



All dimensions in millimetres.

FIG. 5 52.2 kg/m CRANE RAIL SECTION

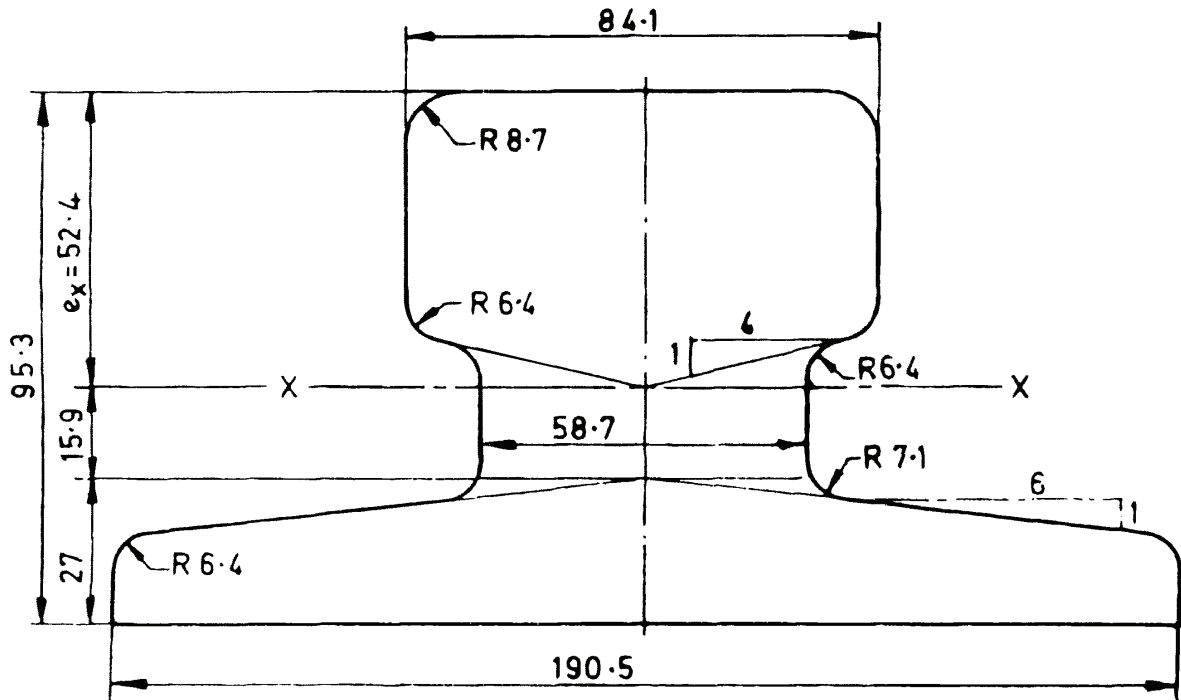


All dimensions in millimetres.

FIG. 6 67 kg/m CRANE RAIL SECTION

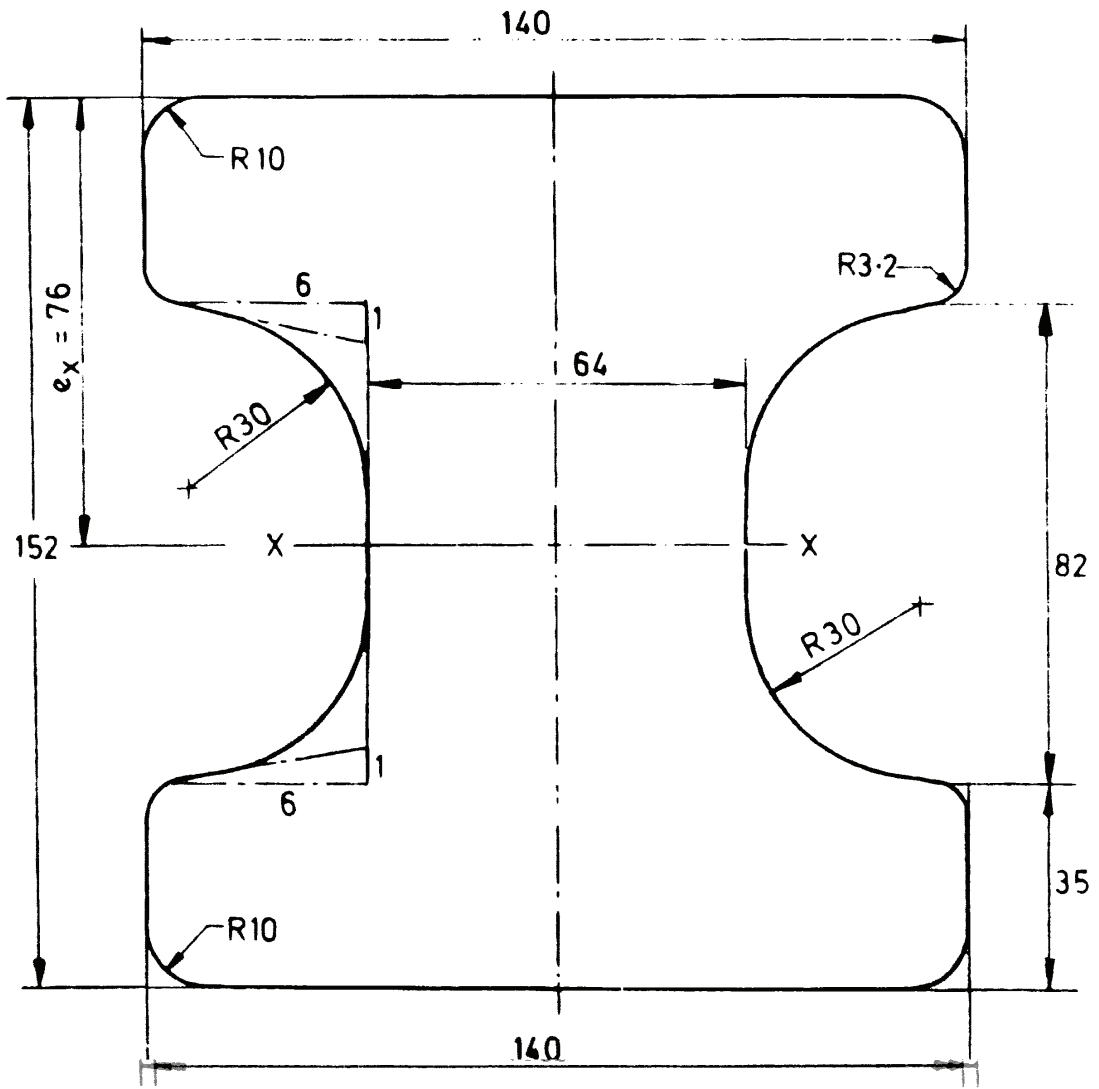
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All dimensions in millimetres.

FIG. 7 74 kg/m CRANE RAIL SECTION



All dimensions in millimetres.

FIG. 8 125 kg/m CRANE RAIL SECTION

**610129/2021/HEP-HTE40200****IS : 3443 - 1980***( Continued from page 2 )**Members*

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# 610129/2021/HEP-HTE40200

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This Indian Standard has been developed by Technical Committee : SMDC 6

### Amendments Issued Since Publication

Amend No.	Date of Issue
Amd. No. 1	October 1983

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Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 323 76 17 323 38 41
Eastern : 1/14 C. I. T. Scheme VII M, V. I. P. Road, Kankurgachi KOLKATA 700054	{ 337 84 99, 337 85 61 337 86 26, 337 91 20
Northern : SCO 335-336, Sector 34-A, CHANDIGARH 160022	{ 60 38 43 60 20 25
Southern : C. I. T. Campus, IV Cross Road, CHENNAI 600113	{ 235 02 16, 235 04 42 235 15 19, 235 23 15
Western : Manakalaya, E9 MIDC, Marol, Andheri (East) MUMBAI 400093	{ 832 92 95, 832 78 58 832 78 91, 832 78 92

Branches : AHMEDABAD. BANGALORE. BHOPAL. BHUBANESHWAR. COIMBATORE.  
FARIDABAD. GHAZIABAD. GUWAHATI. HYDERABAD. JAIPUR. KANPUR. LUCKNOW.  
NAGPUR. NALAGARH. PATNA. PUNE. RAJKOT. THIRUVANANTHAPURAM.  
VISHAKHAPATNAM