We Claim,

1. A fully liquid multi-dose immunogenic composition, wherein 0.5 ml of the composition comprises:
    i) a diphtheria toxoid, (D) in an amount of 10 Lf to 25 Lf, adsorbed onto aluminium salt adjuvant having percentage adsorption of at least 50%;
    ii) a tetanus toxoid, (T)in an amount of 2 Lf to 10 Lf, adsorbed onto aluminium salt adjuvant having percentage adsorption of at least 40%;
    iii) an inactivated whole cell pertussis, (wP) containing inactivated Bordetella pertussis strains 134, 509, 25525 and 6229 in a ratio of 1:1:0.25:0.25, in an amount of 12 IOU to 16 IOU;
    iv) a hepatitis B virus surface antigen, (HBsAg) in the an amount of 7 µg to 15 µg, adsorbed onto aluminium salt adjuvant having percentage adsorption of at least 50%;
    v) a Haemophilus influenzae type b antigen, (Hib) in an amount of 7 µg to 13 µg;
    vi) an inactivated polio virus antigen, (IPV) containing IPV Type 1 in an amount of 1 - 25DU, IPV Type 2 in an amount of 1 – 10 DUand IPV Type 3 in an amount of 1 - 20DU; and
    vii) total aluminium content (Al3+) in the range of 0.1 mg to 0.6 mg; and
    viii) preservative comprising 2-phenoxyethanol in an amount of 1 - 6 mg (v/v); methylparaben in an amount of0.1 – 1.5 mg (w/v) and propylparaben in an amount of 0.05 – 0.2 mg (w/v);or
    2-phenoxyethanol in an amount of 1 - 6 mg (v/v) and methylparaben in an amount of 0.1 – 1.5 mg (w/v); or
    2-phenoxyethanol in an amount of 1 - 6 mg (v/v) and propylparaben in an amount of 0.05 – 0.2 mg (w/v).

2. The immunogenic composition as claimed in claim 1, wherein the Hib antigen is a Hib polyribosylribitol phosphate (PRP) polysaccharide conjugated to a carrier protein using a cyanylation conjugation chemistry or reductive animation conjugation chemistry, wherein said cyanylation reagent is selected from Cyanogen Bromide, l-cyano-4-dimethylaminopyridinium tetrafluoroborate (CDAP)l -cyano-4-pyrrolidinopyridinium

tetrafluorborate (CPPT), 1-cyanoimidazole namely (1 -Cl), 1 -cyanobenzotriazole(1-CBT) or 2-cyanopyridazine-3(2H)one (2-CPO); and carrier protein is selected from a group comprising of tetanus toxoid, CRM_{197}, Diphtheria toxoid, Neisseria meningitidis outer membrane complex, fragment C of tetanus toxoid, pertussis toxoid, protein D of H. influenzae, E.coli LT, E. coli ST, and exotoxin A from Pseudomonas aeruginosa, outer membrane complex c (OMPC), porins, transferrin binding proteins, pneumolysin, pneumococcal surface protein A (PspA), pneumococcal surface adhesin A (PsaA), pneumococcal PhtD, pneumococcal surface proteins BVH-3 and BVH-1 1 , protective antigen (PA) of Bacillus anthracis and detoxified edema factor (EF) and lethal factor (LF) of Bacillus anthracis, ovalbumin, keyhole limpet hemocyanin (KLH), human serum albumin, bovine serum albumin (BSA), purified protein derivative of tuberculin (PPD), synthetic peptides, heat shock proteins pertussis proteins, cytokines, lymphokines, hormones, growth factors, artificial proteins comprising multiple human CD4+ T cell epitopes from various pathogen- derived antigens such as N 19, iron-uptake proteins, toxin A or B from C. difficile and S.agalactiae proteins with or without linker.

3. The immunogenic composition as claimed in claim 1, wherein the IPV antigens are Salk strains selected from the group ofMahoney, MEF-1, Saukett, or Sabin strains selected from the group of Sabin Type 1, Sabin Type 2 and Sabin Type 3.

4. The immunogenic composition as claimed in claim 1, wherein the D, T and HBsAg are individually adsorbed onto an aluminium salt (Al 3+) adjuvant selected from aluminium hydroxide ($Al(OH)_3$) and aluminium phosphate ($A1PO_4$).

5. The immunogenic composition as claimed in claim 1 , wherein the IPV antigens are adsorbed onto aluminium salt of phosphate ($A1P0_4$) and percentage adsorption of IPV Type 1 is in range of 10 - 100 %, IPV Type 2 is in range of 60 - 100% and IPV Type 3 is in range of 10 - 100 %.

6. The immunogenic composition as claimed in claim 1, wherein the percentage of adsorption of Hib antigen on to the adjuvant is less than 20%.

7. The immunogenic composition as claimed in claim 1, wherein the composition further comprises a dilution medium or buffer selected from sodium chloride or phosphate buffer saline.

8. The immunogenic composition as claimed in claim 7, wherein the composition comprises sodium chloride as dilution medium or buffer in a concentration of 0.5% to 1.5%.

9. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

    a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

    b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

    c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v).

10. The immunogenic composition as claimed in claim,1 wherein 0.5 ml of the composition comprises either one of the following:

    a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, type 2 (MEF-1 strain) in an amount of 4 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

    b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, type 2 (MEF-1 strain) in an amount of 4 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

    c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, type 2 (MEF-1 strain) in an amount of 4 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v).

11. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen type 1 (Mahoney strain) in an amount of 20 DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content ($A1^{J+}$) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v).

12. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20DU, type 2 (MEF-l strain) in an amount of 4 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, type 2 (MEF-l strain) in an amount of 4 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al 3^{+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, type 2 (MEF-1 strain) in an amount of 4 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v).

13. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU, and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content

(Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 20 DU and type 3 (Saukett strain) in an amount of 16 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v).

14. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5DU, type 2 (MEF-1 strain) in an amount of 1.5DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (AL^{1}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5DU, type 2 (MEF-l strain) in an amount of 1.5DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain µ) in an amount of 7.5DU, type 2 (MEF-l strain) in an amount of 1.5DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v).

15. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in, an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content ($A1^{J+}$) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v).

16. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

    a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µpg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-1 strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

    b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-l strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); or

    c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-1 strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v).

17. The immunogenic composition as claimed in claim 1 wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);propylparaben in an amount of 0.1 mg (w/v).

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v).

18. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-1 strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU. type 2 (MEF-1 strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content ($Al^{3\ 1-}$) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 40 DU, type 2 (MEF-1 strain) in an amount of 8 DU and type 3 (Saukett strain) in an amount of 32 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); propylparaben in an amount of 0.1 mg (w/v).

19. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of 14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content

(Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of ; 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v); methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v).

20. The immunogenic composition as claimed in claim 1, wherein 0.5 ml of the composition comprises either one of the following:

a) D antigen in an amount of 10 Lf; T antigen in an amount of 2 Lf; wP antigen in an amount of 12 IOU; HBsAg in an amount of 8 µg; Hib antigen in an amount of 8 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-1 strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

b) D antigen in an amount of 20 Lf; T antigen in an amount of 4 Lf; wP antigen in an amount of14 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 10 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-l strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v); or

c) D antigen in an amount of 25 Lf; T antigen in an amount of 10 Lf; wP antigen in an amount of 16 IOU; HBsAg in an amount of 15 µg; Hib antigen in an amount of 13 µg; IPV antigen, type 1 (Mahoney strain) in an amount of 7.5 DU, type 2 (MEF-1 strain) in an amount of 1.5 DU and type 3 (Saukett strain) in an amount of 6 DU, respectively; total aluminium content (Al^{3+}) not more than 0.55 mg; 2-Phenoxyethanol in an amount of 2.5 mg (v/v);methylparaben in an amount of 0.9 mg (w/v); propylparaben in an amount of 0.1 mg (w/v).

21. A process of manufacturing a fully liquid multi-dose immunogenic composition, wherein 0.5 ml of the composition comprises:

i) a diphtheria toxoid, (D)in an amount of 10 Lf to 25 Lf, adsorbed onto aluminium salt having percentage adsorption of at least 50%;

ii) a tetanus toxoid, (T)in an amount of 2 Lf to 10 Lf, adsorbed onto aluminium salt having percentage adsorption of at least 40%;

iii) an inactivated whole cell pertussis, (wP) containing inactivated Bordetella pertussis strains 134, 509, 25525 and 6229 in a ratio of 1:1:0.25:0.25, in an amount of 12 IOU to 16 IOU;

iv) a hepatitis B virus surface antigen, (HBsAg)in the an amount of 7 µg to 15 µg, adsorbed onto aluminium salt having percentage adsorption of at least 50%;

v) a Haemophilus influenzae type b antigen, (Hib)in an amount of 7 µg to 13 µg;

vi) an inactivated polio virus antigen, (IPV) containing IPV Type 1 in an amount of 1-25 DU, IPV Type 2in an amount of 1-10 DU and IPV Type 3 in an amount of 1-20 DU;

vii) total aluminium adjuvant content (Al3+) in the range of 0.1 mg to 0.6 mg; and

viii) preservative as 2-phenoxyethanolin an amount of 1 - 6 mg (v/v); methylparabenin an amount of 0.1 – 1.5 mg (w/v) and propylparaben in an amount of 0.05 – 0.2 mg (w/v); or

2-phenoxyethanol in an amount of 1 - 6 mg (v/v) and methylparaben in an amount of 0.1 – 1.5 mg (w/v); or

2-phenoxyethanol in an amount of 1 - 6 mg (v/v) and propylparaben in an amount of 0.05 – 0.2 mg (w/v);

the process comprising the steps of:

a) Addition of 80 % of total Normal saline (NaCl) in a blending vessel / container;
b) Addition of Component - 1 comprising Diphtheria Toxoid in a blending vessel/ container;
c) Addition of Component - II comprising Tetanus Toxoid to Component – I of Step-(b) with agitation at room temperature;
d) Addition of Component - III comprising inactivated whole cellpertussis antigen to mixture obtained in Step-(c) with agitation at room temperature;
e) Addition of Component - IV comprising Hepatitis B surface Antigen to mixture obtained in Step-(d) at room temperature;
f) Addition of Component - V comprising Hib Antigen to the mixture obtained in Step-(e) at 6-16 °C;
g) Addition of Component - VI comprising IPV antigen to the mixture obtained in Step-(f) at 6-16 °C;;
h) Addition of a preservative combination to the mixture obtained in Step-(g) at 6-16 °C selected from:

    2-Phenoxyethanol in an amount of 1 to 6 mg per 0.5 ml (v/v) and methylparaben in an amount of 0.1 - 1.5 mg per 0.5 ml (w/v); or

    2-Phenoxyethanol in an amount of 1 to 6 mg per 0.5 ml(v/v)and propylparaben in an amount of 0.05 - 0.2 mg per 0.5 ml (w/v); or

    2-Phenoxyethanol in an amount of 1 to 6 mg per 0.5 ml(v/v), methylparaben in an amount of 0.1 - 1.5 mg per 0.5 ml (w/v) and propylparaben in an amount of 0.05 - 0.2 mg per 0.5 ml (w/v);
i) Adjusting pH of the mixture obtained in Step-(h) to 6.0 to 7.0 with Sodium Hydroxide / Sodium Carbonate; and
j) Adding remaining 20% of total normal saline (NaCl) to make up the volume with agitation.

22. The process as claimed in claim 21, wherein the preparation of the component I comprises the following steps:

a) Transfer of Aluminium phosphate in the container / vessel;
b) Addition of the Diphtheria Toxoid;
c) pH adjustment to 4.5 to 5.5 with Acetic Acid / Sodium Hydroxide;
d) stabilization;
e) pH adjustment to 5.5 to 6.5 with Sodium Hydroxide / Sodium Carbonate; and
f) stabilization with histidine buffer.

23. The process as claimed in claim 21, wherein the preparation of the component II comprises the following steps:

a) Transfer of Aluminium phosphate in the container / Vessel;
b) addition of the Tetanus Toxoid;
c) pH adjustment to 4.5 to 5.5 with Acetic Acid / Sodium Hydroxide;
d) stabilization;
e) pH adjustment to 5.5 to 6.5 with Sodium Hydroxide / Sodium Carbonate; and
f) stabilization with histidine buffer.

24. The process as claimed in claim 21, wherein the preparation of the component III comprises the following steps:

a) inactivation at 56°C for 10 - 15 minutes in presence of formaldehyde of Bordetella pertussis strain 134;
b) inactivation at 56°C for 10 - 15 minutes in presence of formaldehyde of Bordetella pertussis strain 509;
c) inactivation at 56°C for 10 - 15 minutes in presence of formaldehyde of Bordelella pertussis strain 25525;
d) inactivation at 56°C for 10 - 15 minutes in presence of formaldehyde of Bordetella pertussis strain 6229;
e) subsequently mixing inactivated Bordetella pertussis strains 134, 509, 25525 and6229 in a ratio of 1:1:0.25:0.25; and
f) optionally adsorbed onto aluminium based adjuvant;

wherein the process is devoid of thiomersal and inactivated whole cell pertussis antigen remains non-clumpy and homogeneous thereby leading to reduced reactogenicity and giving better potency for a longer duration.

25. The process as claimed in claim 21, wherein the preparation of the component IV comprises the following steps:

a) Transfer of aluminium phosphate in the container / Vessel;
b) addition of the Hepatitis B surface Antigen;
c) pH adjustment to 4.5 to 5.5 with Acetic Acid / Sodium Hydroxide;
d) stabilization;
e) pH adjustment to 5.8 to 6.8 with Sodium Hydroxide / Sodium Carbonate; and
f) stabilization.

26. The process as claimed in claim 21, wherein the preparation of Component - V comprises the following steps:

a) Fermentation of Haemophilus influenzae Type b;
b) Inactivation at 37 °C for 2 hours in presence of 0.1% formaldehyde;
c) Purification of Hib polyribosylribitol phosphate (PRP) polysaccharide;
d) Conjugation of purified product of step c to tetanus toxoid (TT) using a Cyanogen Bromide cyanylation conjugation chemistry in presence of adipic acid dihydrazide (ADH) linker;
e) purification of conjugate of step d; and
f) filtration of purified conjugate preferably through 0.22 pm filter;

wherein the percentage free PRP is no more than 5% in the total purified Hib bulk conjugate.