

DIN EN 14587-3:2013-01 (E)

Railway applications - Track - Flash butt welding of rails - Part 3: Welding in association with crossing construction

| Contents | | Page |
|--------------------|--|-------------|
| Foreword | | 4 |
| Introduction | | 5 |
| 1 | Scope | 6 |
| 2 | Normative references | 6 |
| 3 | Terms and definitions | 6 |
| 4 | Information to be supplied for approval of procedure | 8 |
| 4.1 | By the purchaser | 8 |
| 4.2 | By the manufacturer | 8 |
| 5 | Approval of the manufacturer | 8 |
| 5.1 | General | 8 |
| 5.2 | Welding procedure | 8 |
| 5.3 | Operators | 9 |
| 5.4 | Supervision | 9 |
| 5.5 | Weld Inspection | 9 |
| 5.6 | Equipment | 9 |
| 5.7 | Quality assurance | 9 |
| 6 | Requirements for the welding process | 9 |
| 6.1 | General | 9 |
| 6.2 | Workpiece preparation | 9 |
| 6.3 | Clamping force | 10 |
| 6.4 | Initial burn-off | 10 |
| 6.5 | Preheating | 10 |
| 6.6 | Final flashing | 10 |
| 6.7 | Upsetting | 10 |
| 6.8 | Post-weld treatment | 11 |
| 6.8.1 | Before unclamping | 11 |
| 6.8.2 | After removal from machine | 11 |
| 6.9 | Welding parameters | 11 |
| 6.10 | Removal of upset and correction of weld alignment | 11 |
| 7 | Profile finishing of the weld | 11 |
| 8 | Weld geometry and dimensions | 12 |
| 8.1 | General | 12 |
| 8.2 | Alignment and flatness across the weld | 12 |
| 8.3 | Foot dimensions | 13 |
| 9 | Weld identification | 13 |
| 10 | Procedure approval | 13 |
| 10.1 | General | 13 |
| 10.2 | Test weld specimen preparation | 14 |
| 10.3 | Number of specimens | 14 |
| 10.4 | Approval tests | 14 |

| | | |
|---|--|----|
| 10.4.1 | General | 14 |
| 10.4.2 | Weld geometry and dimensions | 14 |
| 10.4.3 | Visual inspection | 14 |
| 10.4.4 | Surface finish | 14 |
| 10.4.5 | Liquid penetrant testing and magnetic particle testing | 14 |
| 10.4.6 | Internal soundness | 15 |
| 10.4.7 | Bend testing | 15 |
| 10.4.8 | Fatigue testing | 15 |
| 10.4.9 | Macro-examination | 15 |
| 10.4.10 | Micro-examination | 16 |
| 10.4.11 | Hardness testing | 16 |
| 10.5 | Test result report | 17 |
| 10.6 | Validity of approval | 17 |
| 11 | Approval of other rail profiles or grades | 17 |
| 11.1 | General | 17 |
| 11.2 | Sample preparation | 17 |
| 11.3 | Approval tests | 17 |
| 11.4 | Test result report | 18 |
| 12 | Track trials | 18 |
| 12.1 | General | 18 |
| 12.2 | Track trial test result report | 18 |
| 13 | Weld production following procedure approval | 18 |
| 13.1 | Weld production | 18 |
| 13.2 | Weld parameter monitoring | 18 |
| 13.3 | Visual inspections | 18 |
| 13.4 | Weld geometry and dimensions | 19 |
| 13.5 | Liquid penetrant testing and magnetic particle testing | 19 |
| 13.6 | Internal soundness | 19 |
| 13.7 | Bend Testing | 19 |
| 13.7.1 | General | 19 |
| 13.7.2 | Additional test requirements | 19 |
| 13.7.3 | Bend test procedure | 19 |
| 13.7.4 | Interpretation of results | 20 |
| 13.7.5 | Retesting | 20 |
| 13.7.6 | Documentation | 20 |
| Annex A (informative) Example of Flat spot and Bright spot | | 21 |
| Annex B (normative) Bend test requirements | | 22 |
| Annex C (normative) Test weld fracture faces - Recording of defects | | 24 |
| Annex D (normative) Fatigue test method for flash butt welds | | 26 |
| D.1 | Scope | 26 |
| D.2 | Test equipment | 26 |
| D.3 | Calibration procedure | 28 |
| D.3.1 | General | 28 |
| D.3.2 | Test piece | 28 |
| D.3.3 | Test piece preparation | 28 |
| D.3.4 | Instrumentation | 28 |
| D.3.5 | Procedure | 28 |
| D.4 | Fatigue test method | 32 |
| D.4.1 | General | 32 |
| D.4.2 | Staircase testing method | 32 |
| D.4.3 | Example of the data analysis of a fatigue strength determination by the staircase method | 35 |
| D.4.4 | Past-the-post testing method | 35 |

| | |
|--|-----------|
| Annex E (normative) Macro-examination and micro-examination | 37 |
| E.1 Macro examination | 37 |
| E.2 Micro examination | 37 |
| Annex F (normative) Hardness testing | 39 |
| Annex G (normative) Ultrasonic testing non-austenitic materials | 40 |
| G.1 Reference line (DAC) generation - Reference block | 40 |
| G.2 Reference line (DAC) generation and acceptance criteria | 40 |
| Bibliography | 42 |