

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