


DIN EN 15085-3:2023-07 (E)

Railway applications - Welding of railway vehicles and components - Part 3: Design requirements (includes Amendment A1:2023)

Contents	Page
European foreword	4
Introduction	6
1 Scope.....	7
2 Normative references.....	7
3 Terms and definitions	9
4 Design requirements	9
4.1 General.....	9
4.2 Dimensioning of welded joints	10
4.3 Stress categories and stress factors	10
4.4 Safety categories	10
4.5 Weld performance classes.....	10
4.6 Weld inspection classes.....	11
5 Quality levels for imperfections	12
5.1 General.....	12
5.2 Quality levels for imperfections for fusion welded joints (beam welding excluded)	12
5.3 Quality levels for imperfections for beam welded joints	13
5.3.1 General.....	13
5.3.2 Quality levels for imperfection for friction stir welding.....	14
5.3.3 Quality levels for imperfections for stud welding related to the weld performance class.....	14
5.3.4 Quality requirements for resistance spot welding, projection welding and resistance seam welding related to the weld performance class	14
5.3.5 Quality requirements for flash welding.....	15
5.3.6 Defining quality requirements for other welding processes.....	15
6 Selection of parent metals and welding consumables	15
6.1 Selection of parent metals	15
6.2 Selection of welding consumables.....	15
7 Weld joint design	16
7.1 General.....	16
7.2 Design guidelines.....	16
7.2.1 Fabricated box sections.....	16
7.2.2 Butt welds on parts of dissimilar thickness	17
7.2.3 Plug welds and slot welds	18
7.2.4 Proximity of two joints.....	19
7.2.5 Stiffeners welded across a butt weld	19
7.2.6 Openings	20
7.2.7 Design guidelines for stiffeners and gussets ends	20
7.2.8 Gusset shape	20
7.2.9 Weld return.....	21
7.2.10 Fillet weld	22
7.2.11 Use of run-on and run-off plates.....	23
7.2.12 Highly restrained joints.....	23
7.2.13 Mixing of joining techniques.....	24

7.2.14	Prevention of corrosion problems	25
7.2.15	Intermittent welds.....	25
7.3	Joint preparation.....	26
7.4	Methods to improve the fatigue strength (Post weld improvement)	26
7.4.1	General.....	26
7.4.2	Improvement of shape of weld toe	27
7.4.3	Post Weld Heat Treatment (PWHT) — stress relief.....	27
7.4.4	Introduction of compressive stress.....	28
8	Design documentation related to welding.....	28
8.1	Information on design drawings or documentation linked to the drawings	28
8.2	Design review of welded components.....	29
8.3	Use of existing drawings not according to EN 15085.....	30
Annex A (informative)	List of welded joints (example)	31
Annex B (informative)	Joint preparation of welds	32
Annex C (informative)	Joint preparation for plug welds	40
Annex D (informative)	Types of joints in relation to stresses and inspection classes.....	41
Annex E (informative)	Flash welding.....	42
Annex F (normative)	Resistance spot, seam and projection welding	45
F.1	General.....	45
F.2	Minimum shear pull forces.....	50
Annex G (informative)	Determination of safety category for welded joints	52
Annex ZA (informative)	Relationship between this European Standard and the Essential requirements of Directive (EU) 2016/797 aimed to be covered 	53
Bibliography	55