

RAUDTEEALASED RAKENDUSED. RÖÖBASTEE.
RÖÖBASTE ALUMIINIUMTERMIIDIGA KEEVITAMINE.
OSA 2: ALUMIINIUMTERMIIDIGA KEEVITAJATE
PÄDEVUS, TÖÖVÕTJATE HEAKSKIITMINE JA
KEEVITUSTE VASTUVÕTMINE

Railway applications - Track - Aluminothermic welding
of rails - Part 2: Qualification of aluminothermic
welders, approval of contractors and acceptance of
welds

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 14730-2:2021 sisaldab Euroopa standardi EN 14730-2:2021 ingliskeelset teksti.	This Estonian standard EVS-EN 14730-2:2021 consists of the English text of the European standard EN 14730-2:2021.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 28.04.2021.	Date of Availability of the European standard is 28.04.2021.
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ICS 25.160.01, 25.160.10, 93.100

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EUROPEAN STANDARD

EN 14730-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2021

ICS 25.160.01; 25.160.10; 93.100

Supersedes EN 14730-2:2006

English Version

Railway applications - Track - Aluminothermic welding of rails - Part 2: Qualification of aluminothermic welders, approval of contractors and acceptance of welds

Applications ferroviaires - Voie - Soudage des rails par aluminothermie - Partie 2 : Qualification des soudeurs par aluminothermie, agrément des entreprises et réception des soudures

Bahnanwendungen - Oberbau - Aluminothermisches Schweißen von Schienen - Teil 2: Qualifizierung aluminothermischer Schweißer, Zertifizierung von Betrieben und Abnahme von Schweißungen

This European Standard was approved by CEN on 30 November 2020.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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European foreword

This document (EN 14730-2:2021) has been prepared by Technical Committee CEN/TC 256 "Railway applications", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2021, and conflicting national standards shall be withdrawn at the latest by October 2021.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 14730-2:2006.

This document is the second part of the EN 14730 series which provides systems for the successful delivery of aluminothermic welds in track.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Introduction

This document (EN 14730-2) has five main topics:

- a) approval of welding trainers;
- b) approval of welding training centres;
- c) qualifications of aluminothermic welders;
- d) approval of aluminothermic welding contractors;
- e) acceptance of welds.

This part of EN 14730 has been occasioned by a European Directive that will permit the freedom of an open European market. To enable this perception to become a reality, it is essential a standard is in place that satisfies the needs of the infrastructure owners or custodians and reflects the production capabilities of the manufacturers in technical and quality terms.

1 Scope

This document specifies requirements for the:

- approval of training facilities, testing and maintaining the skills of aluminothermic welders and welding trainers. It applies to those aluminothermic welding processes compliant with the requirements of EN 14730-1. It requires that the system for training and testing of welders be approved by the railway authority;
- approval of aluminothermic welding contractors. It applies to those contractors using aluminothermic welding processes compliant with the requirements of EN 14730-1 and who employ welders in the possession of a valid permit to weld as defined in Clause 4 of this document;
- acceptance of the final aluminothermic weld inspections and aluminothermic weld inspectors approved by the railway authority. It does not cover any previous weld inspections by the welder or others.

This document also applies to aluminothermic welds produced on railway rails as contained in EN 13674-1 to EN 13674-4 and EN 16771.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 14730-1, *Railway applications - Track - Aluminothermic welding of rails - Part 1: Approval of welding processes*

EN ISO 3834-2, *Quality requirements for fusion welding of metallic materials - Part 2: Comprehensive quality requirements (ISO 3834-2)*

EN ISO 14731, *Welding coordination - Tasks and responsibilities (ISO 14731)*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <https://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

3.1

aluminothermic welder

welder trained in an approved training centre in accordance with 3.7 and holding a permit to weld in accordance with 4.5

3.2

contractor

company approved by a railway authority to provide staff and equipment to execute the production of aluminothermic welds

Note 1 to entry: This may include staff and machinery from within the railway authority.