

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

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

<p>Käesolev Eesti standard EVS-EN 14730-2:2006 sisaldab Euroopa standardi EN 14730-2:2006 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 20.09.2006 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 14730-2:2006 consists of the English text of the European standard EN 14730-2:2006.</p> <p>This document is endorsed on 20.09.2006 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p>Käsitlusala: This standard applies to aluminothermic welds made on Vignole rails of 46 kg/m and above as contained in EN 13674-1: This standard specifies: - the system for training, testing and maintaining the skills of aluminothermic welders. It applies to those aluminothermic welding processes compliant with the requirements of prEN 14730-1 "Railway applications – Track – Aluminothermic welding of rails – Part 1: Approval of welding processes". It requires that the system for training and testing of welders shall be approved by the relevant railway authority;</p>	<p>Scope: This standard applies to aluminothermic welds made on Vignole rails of 46 kg/m and above as contained in EN 13674-1: This standard specifies: - the system for training, testing and maintaining the skills of aluminothermic welders. It applies to those aluminothermic welding processes compliant with the requirements of prEN 14730-1 "Railway applications – Track – Aluminothermic welding of rails – Part 1: Approval of welding processes". It requires that the system for training and testing of welders shall be approved by the relevant railway authority;</p>
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ICS 25.160.10, 45.080

Võtmesõnad:

ICS 25.160.10; 45.080

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, agréments 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 12 June 2006.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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Foreword

This document (EN 14730-2:2006) 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 February 2007, and conflicting national standards shall be withdrawn at the latest by February 2007.

The purpose of this standard is to provide systems for successful delivery of aluminothermic welds in track.

This standard covers:

- qualifications of aluminothermic welders;
- approval of aluminothermic welding contractors;
- Acceptance of welds.

The minimum information requirements shown in Annex A and B are normative. The format is informative.

The standard contains "alternative requirements" in certain clauses, which enable a railway authority to select a position that will protect those principles which might be considered as "sovereign rights."

When installing aluminothermic welds in track across Europe, railway authorities, process suppliers and contractors shall comply with rules, regulations and codes of practice pertaining to the country where the work is executed.

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

1 Scope

This standard applies to aluminothermic welds made on Vignole rails of 46 kg/m and above as contained in EN 13674-1:

This standard specifies:

- the system for training, testing and maintaining the skills of aluminothermic welders. It applies to those aluminothermic welding processes compliant with the requirements of EN 14730-1 "Railway applications – Track – Aluminothermic welding of rails – Part 1: Approval of welding processes". It requires that the system for training and testing of welders shall be approved by the relevant railway authority;
- the systems and requirements for the approval of aluminothermic welding contractors. It applies to those contractors using aluminothermic welding processes compliant with the requirements of EN 14730-1 "Railway applications – Track – Aluminothermic welding of rails – Part 1: Approval of welding processes" and who employ welders who are in possession of a valid Permit to Weld as defined in Clause 4 of this standard;
- the acceptance requirements for aluminothermic welds. It requires that weld inspectors are competent in aluminothermic weld inspection and are approved by the relevant railway authority. It covers the final inspection of aluminothermic welds for acceptance in track. It does not cover any previous inspections by welders or others.

2 Normative references

The following referenced documents are indispensable for the application 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*

3 Terms and definitions

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

3.1 railway authority
either the railway regulator or the owner of a railway infrastructure or the custodian with a delegated responsibility for a railway infrastructure

3.2 aluminothermic welder
track operative trained and certified for the joining of rails by aluminothermic welding processes

3.3 welding contractor and welding subcontractor
company accepted in accordance with the requirements of a railway authority to execute the production of aluminothermic welds on that particular infrastructure

3.4 process supplier
company which provides an approved aluminothermic welding process accepted in accordance with EN 14730-1 and which is approved by the railway authority to supply consumables and tools for the execution of aluminothermic welds