
International Standard



6305 / 2

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Railway components — Technical delivery requirements — Part 2 : Unalloyed carbon steel baseplates

Éléments constitutifs de la voie ferrée — Spécifications techniques de livraison — Partie 2 : Selles en acier au carbone non allié

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been authorized has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6305/2 was developed by Technical Committee ISO/TC 17, *Steel*, and was circulated to the member bodies in August 1982.

It has been approved by the member bodies of the following countries :

Australia	Hungary	South Africa, Rep. of
Austria	India	Spain
Belgium	Iran	Sweden
Brazil	Italy	Switzerland
Canada	Japan	Tanzania
China	Korea, Dem. P. Rep. of	Turkey
Czechoslovakia	Korea, Rep. of	United Kingdom
Egypt, Arab Rep. of	Netherlands	USSR
France	New Zealand	
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No member body expressed disapproval of the document.

Railway components — Technical delivery requirements — Part 2 : Unalloyed carbon steel baseplates

1 Scope and field of application

This part of ISO 6305 specifies the quality requirements of the product and the conditions of acceptance testing for rolled non-alloy carbon steel baseplates.

2 References

ISO 82, *Steel — Tensile testing*.

ISO 2859, *Sampling procedures and tables for inspection by attributes*.

3 Conditions of manufacture

3.1 Steelmaking process

The steelmaking process shall be at the manufacturer's option. If requested by the purchaser, the manufacturer shall state in his tender the type and the principal characteristics of the steelmaking process; he may not alter them without advising the purchaser's representative.

The steel used shall be of one of the grades defined in table 1 and as selected by the purchaser.

Table 1

Tensile strength, R_m	Minimum elongation
N/mm ²	%
380 to 480	24
480 to 620	18

Other steel grades may be used subject to agreement in the order between the purchaser and the manufacturer.

3.2 Manufacture

The baseplates shall be manufactured by cutting to length a rolled section and finished in accordance with drawings supplied by the purchaser.

Throughout the production process, the manufacturer shall use the best techniques so that the baseplates satisfy the requirements of this part of ISO 6305. Continuously cast blooms may be used in addition to blooms made from ingots.

3.3 Drawings and working gauges

A copy of the final drawings shall be supplied to the manufacturer by the purchaser together with the notification of approval of the order.

If stated in the order, the manufacturer before starting production shall make up two sets of maximum and minimum working gauges, incorporating the specified dimensional tolerances. If required by the purchaser, the working gauges shall be stamped after approval by the purchaser's representative.

Only these working gauges shall be valid for checking purposes.

One set of working gauges shall be made available to the receiving inspector for the period of acceptance testing.

The working gauges shall be provided at the manufacturer's expense. New working gauges need not be provided for items ordered in quantities of less than 10 000 at any one time.

When the working gauges have been approved by a purchaser, or by an outside testing agency, these shall be used for other purchasers wherever possible.

3.4 Marking

The baseplates shall carry in bold characters at the position shown on the drawings compatible with the rolling requirements :

- the identification mark of the manufacturer's works;
- the last two figures of the year of manufacture;
- if required a symbol indicating the section of the baseplates.

3.5 Freedom from defects

The baseplates shall be free from defects adversely affecting their behaviour in service.

Slight defects outside the rail seating surface may be accepted by the receiving inspector if considered negligible.

Any operation carried out either in the cold or hot state with the object of concealing a defect is not permitted.