

Supplement Notice

Information for users

The attached standard:

RT/CE/S/015

Issue 1

has essential supplementary information

Instructions for use

It is essential that you first read and understand the supplement pertaining to the standard before proceeding to the standard. You must then apply the requirements of the supplement to the standard.

Proceed to supplement ►**I have read & understand the supplement.
Proceed to standard ►**

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Issue	1
Date	December 1995

Self-Shielding Flux-cored Wires for the Weld Repair of BS11 and "A" Grade Rails (formerly RT/CE/S/015)

This temporary front sheet facilitates change to the new Network Rail Standards referencing nomenclature.

The Ref above will be formally allocated to this standard when it is next changed in the meantime the contents, date and issue number of this Network Rail Standard are UNCHANGED and with immediate effect it should be referred to as "(new ref) formerly (old ref)".

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RAILTRACK LINE

SPECIFICATION

SELF-SHIELDING FLUX-CORED WIRES FOR THE WELD REPAIR OF BS 11 NORMAL AND 'A' GRADE RAILS

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Summary

This specification gives the requirements for the manufacture and acceptance of self-shielding flux-cored wires for use on BS11 Normal and "A" Grade rail steels.

Issue record

This specification will be updated when necessary by distribution of a complete replacement. Amended or additional parts of revised pages will be marked by a vertical black line in the margin.

Issue: 1 **Date:** December 1995 **Comments:** New specification

Responsibilities

This specification shall be complied with by all persons responsible for the purchasing or manufacture of flux-cored wire for rail weld repairs in the permanent way.

Users of this specification shall ensure that they use the latest available versions of any documents to which reference is made.

Implementation

The provisions of this specification are mandatory and apply from two months after the date shown at the top of this page, unless a temporary non-compliance has been agreed by Director Civil Engineering.

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Supply

Persons requiring controlled copies of this specification shall obtain them from their Directorate's Document Control Point.

**SELF-SHIELDING FLUX-CORED WIRE
FOR THE WELD REPAIR OF
BS11 NORMAL AND “A” GRADE RAIL STEELS**

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1 PURPOSE

This specification prescribes the manufacturing, approval testing and acceptance requirements for self-shielding flux-cored wires to be used for rail weld repairs.

2 SCOPE

This specification applies only to self-shielding flux-cored wires which are to be used for weld repairs of BS11 Normal and "A" Grade rail steels and which are compatible with current portable track welding equipment.

3 DEFINITION

The Engineer

The competent Engineer appointed by Railtrack to represent its technical interest.

4 MANUFACTURING REQUIREMENTS

4.1 Method of manufacture

The wire shall be made by any method that will yield a product conforming to the requirements of this specification.

4.2 Standard sizes and lengths

Wires of 1.2mm and 1.6mm diameter shall be available in continuous lengths wound onto spools. Tolerances on wire diameters are given in Table A.1.

4.3 Finish, temper, cast and helix

Finish The wires shall have a smooth finish except for seams and be free from slivers, depressions, scratches, scale or other foreign matter that would adversely affect the welding properties or the operation of the welding equipment.

Temper, cast and helix The wires shall be suitable for uniform uninterrupted feeding on semi-automatic welding equipment of a type approved by Railtrack.

4.4 Uniformity in core of wire

All wires shall have the core ingredients distributed throughout their length with sufficient uniformity that the performance of the wire and the analysis of the properties of the weld deposited thereby are not adversely affected.