

Addendum & Corrigendum Slip No.1 of 2012
To
Manual for Flash Butt Welding of Rails (Revised Jan 2012)

1. Clause 10.2.2.1: Existing clause shall be replaced with following:

“The test joint shall be supported on cylindrical or semi-cylindrical supports having a diameter of 30 to 50mm and distance of one metre between them. In case of 60kg 110 UTS/head hardened rail joints the test span shall be 1.25 metre. The mandrel diameter shall be between 30 to 50mm. The mandrel axis should be perpendicular to the horizontal axis of the rail section and it should be positioned at the centre of the weld. The weld shall be in the centre of the span and loaded in such a manner that the foot of the rail is in tension. The load shall be uniformly and gradually increased. The rate of application of the load should not exceed 2.5 tons/sec. The test joints shall withstand the minimum load and shall show minimum deflection as given in Table 1 without showing any signs of cracking or failure. Results shall be maintained as per proforma given in Annexure-VI ‘D’.”

2. A new para 10.2.2.1(a) shall be added as under:

“The test weld shall withstand minimum transverse breaking load as indicated in column 4 at table 1. The deflection at center at the actual transverse breaking load shall not be less than that specified in column 5 of table 1.”

3. Heading of column 5 of table 1 shall be replaced with following:

“Minimum deflection in mm at the center at the actual transverse breaking load.”