

'Additional Policy Instructions on Ultrasonic testing of rails & welds, to be read in conjunction with Manual for Ultrasonic testing of rails & welds (Revised-2012)'

1. Frequency of testing of rails and AT welds has been prescribed in Para 6.6 and 8.15.2 respectively of Manual for Ultrasonic testing of rails & welds (Revised-2012). As a trial preventive measure to reduce the number of rail failures during reduced testing frequency period and weld failures in initial period, Ultrasonic testing of rails and welds shall be done at frequency prescribed below. This will be valid for a period of two years, i.e. upto 31.08.2020.
- 1.1 Frequency of USFD for all BG and MG routes shall be as under in place of table given in **Para 6.6.1.1 of Manual**. For other sections, Chief Engineer of the Railway may adopt a frequency at his discretion.

A	B	C	D
Route	Route having GMT	USFD Testing Frequency during the "Reduced frequency testing Period" (As defined in Para 6.6.1), once in	USFD Testing Frequency (Other than during reduced frequency testing period) once in
All MG routes	< 2.5	8years	5 years
	2.5 – 5.0	4years	3 years
	> 5	3years	2 years
All BG routes	≤ 5	4 years	2 years
	> 5 ≤ 8	30 Months	12 months
	> 8 ≤ 12	20 Months	9 months
	> 12 ≤ 16	15 Months	6 months
	> 16 ≤ 24	10 Months	4 months
	> 24 ≤ 40	6 Months	3 months
	> 40 ≤ 60	4 Months	2 months
	> 60 ≤ 80	3 Months	1½ months
	> 80	2 Months	1 month

1.2 Frequency of USFD testing during reduced frequency testing period is broadly based on the criteria of:-

- (a) Passage of every 20 GMT traffic during reduced frequency testing period; or
 (b) Eight (08) years, whichever is earlier

2. Frequency of testing of AT welds by hand probing with probes listed in Para 8.15.2 of Manual shall be as under:

S No	Type of Welds	Type of Testing	Testing Schedule	
1	Conventional AT weld	Periodic Tests	Every 40 GMT or 5 years whichever is earlier	
2	SKV Weld	Acceptance Test	Immediately after welding	
3		First Periodic Test	20 GMT or 1 year whichever is earlier	
4		Further tests based on route GMT	Routes having GMT	Frequency
5			> 80	1 years
6			>60 ≤ 80	1½ years
7			>45 ≤ 60	2 years
8			>30 ≤ 45	3 years
9		> 15 <30	4 years	
	0-15	5 years		

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