



BSI Standards Publication

Railway applications — Track — Aluminothermic welding of rails

Part 2: Qualification of aluminothermic welders, approval
of contractors and acceptance of welds

National foreword

This British Standard is the UK implementation of [EN 14730-2:2021](#). It supersedes [BS EN 14730-2:2006](#), which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee RAE/2, Railway Applications - Track.

A list of organizations represented on this committee can be obtained on request to its committee manager.

The UK committee advises users that Table 1 is incomplete in this published version of the standard. The below table, from the draft version, includes all the acceptance criteria for vertical alignment.

Table 1 — Vertical alignment

Dimensions in millimetres

Category		A	B	C	D	E	F	G	H
Peaked weld	Peak Max	1,0	1,0	0,5	0,5	0,3	0,3	0,2	0,3
	Peak Min	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,1
	Flatness	−0,20	−0,20	−0,20	−0,20	−0,20	−0,15	−0,10	−0,15
Dipped weld	Dip Max	−1,0	−0,5	−0,5	0,0	−0,2	−0,15	−0,1	0,0
Maximum Grinding Length		900	900	900	900	600	600	600	600

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