

<b>STN</b>	<b>Železnice Infraštruktúra</b> <b>Stykové odtavovacie zváranie koľajníc</b> <b>Časť 1: Zváranie nových koľajníc ocele R220, R260, R260Mn, R320Cr, R350HT, R350LHT, R370CrHT a R400HT na pevných zariadeniach</b>	<b>STN EN 14587-1</b>  73 6375
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Railway applications - Infrastructure - Flash butt welding of new rails - Part 1: R220, R260, R260Mn, R320Cr, R350HT, R350LHT, R370CrHT and R400HT grade rails in a fixed plant

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 05/19

Obsahuje: EN 14587-1:2018

Oznámením tejto normy sa ruší  
STN EN 14587-1 (73 6375) z októbra 2007

**128816**

EUROPEAN STANDARD

**EN 14587-1**

NORME EUROPÉENNE

EUROPÄISCHE NORM

December 2018

ICS 25.160.10; 93.100

Supersedes EN 14587-1:2007

English Version

**Railway applications - Infrastructure - Flash butt welding  
of new rails - Part 1: R220, R260, R260Mn, R320Cr,  
R350HT, R350LHT, R370CrHT and R400HT grade rails in  
a fixed plant**

Applications ferroviaires - Infrastructure - Soudage des rails neufs par étincelage - Partie 1: Rails de nuances R220, R260, R260Mn, R320Cr, R350HT, R350LHT, R370CrHT et R400HT dans une installation fixe

Bahnanwendungen - Infrastruktur - Abbrennstumpfschweißen von Schienen - Teil 1: Schweißen neuer Schienen der Stahlsorte R220, R260, R260Mn, R320Cr, R350HT, R350LHT, R370CrHT und R400HT in einer stationären Anlage

This European Standard was approved by CEN on 17 September 2018.

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**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

**EN 14587-1:2018 (E)**

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**EN 14587-1:2018 (E)****European foreword**

This document (EN 14587-1:2018) has been prepared by Technical Committee CEN/TC 256 "Railway applications", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2019, and conflicting national standards shall be withdrawn at the latest by June 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 14587-1:2007.

This document is one of a series of three parts of the EN 14587 series:

- *Railway applications – Infrastructure - Flash butt welding of new rails – Part 1: R220, R260, R260Mn, R320Cr, R350HT, R350LHT, R370CrHT and R400HT grade rails in a fixed plant;*
- *Railway applications – Track - Flash butt welding of rails – Part 2: New R220, R260, R260Mn and R350HT grade rails by mobile welding machines at sites other than a fixed plant;*
- *Railway applications – Track - Flash butt welding of rails – Part 3: Welding in association with crossing construction.*

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## **Introduction**

This part of EN 14587 has five main topics:

- a) requirements of a welding process;
- b) procedure approval for a fixed plant;
- c) approval of other rail profiles or grades;
- d) approval of welding contractor;
- e) weld production following approval.

**EN 14587-1:2018 (E)****1 Scope**

This document specifies requirements for the approval of a welding process in a fixed plant, together with the requirements for subsequent welding production.

It applies to new Vignole railway rails R220, R260, R260Mn, R320Cr, R350HT, R350LHT, R370CrHT and R400HT grade rails of 46 kg/m and above, as contained in EN 13674-1, welded by a flash butt welding process in a fixed plant and intended for use on railway infrastructure.

This document applies to the welding of rails into welded strings.

**2 Normative references**

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 13674-1, *Railway applications — Track — Rail — Part 1: Vignole railway rails 46 kg/m and above*

EN ISO 3452-1, *Non-destructive testing — Penetrant testing — Part 1: General principles (ISO 3452-1)*

EN ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method (ISO 6507-1)*

EN ISO 7500-1:2018, *Metallic materials — Calibration and verification of static uniaxial testing machines — Part 1: Tension/compression testing machines — Calibration and verification of the force-measuring system (ISO 7500-1:2018)*

EN ISO 17638, *Non-destructive testing of welds — Magnetic particle testing (ISO 17638)*

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**