



West Central Railway

General Managers' Office
Engineering Branch
Jabalpur

No. W-HQ/W-4/Track-II/Policy/Circulars/7

Date : 21.06.2019

CAO(C)/WCR/JBP

CPM/ED - IRCON/Katni

CPM/ED - RVNL/BPL-I & II & KOTA

CTE PROCEDURE ORDER NO. 07/2019-20

- Sub : (i) Permitted locations for AT Welding.
(ii) No AT Welding in Turnout.
(iii) USFD of AT Welding by outsourced agency fixed by executive agency other than AT Welding agency.**

Ref : (i) This office letter No. W-HQ/W-4/Track/AT Welding/9-V dt. 18.06.18
(ii) Railway Board letter No. Track-I/21/2005/0110/AT Welding
dtd. 23.05.2019 circular vide this office letter dt. 3.6.19
(iii) Railway Board letter No. 2018/Track-I/11/1/At Welding Vol-I
dtd. 03.06.2019.

(A) AT welds is very critical from safety consideration. Necessary guidelines for restricted use of AT welding have been issued by Bd from time to time and these were circulated vide letter under reference (i) above. It is once again clarified that AT welding is permitted only at the following locations:-

- (i) For joining of 20 Rail panels, AT welds permitted.
- (ii) During Destressing of LWR, AT welds permitted.
- (iii) All SEJ shall be FB welds as far as possible. However, a maximum of 2 AT welds are permitted for laying of each SEJ for closing the gap at the time of destressing.
- (iv) All Glued joints shall be in-situ Glued joints. Wherever prefabricated GJs are used in pre NI/NI, it shall be only FB welds. No AT welds is permitted.
- (v) All joints in Turnouts, portion shall be either Flash Butt welds or long panels cut as per the site requirement. No AT welds permitted as per Bd's letter under reference to above.

(vi) AT welding of joints at cut and connection location during pre-NI/NI shall be permitted.

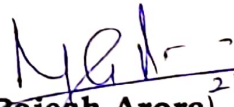
- (B) Vide Board letter under reference (ii) above, AT welding on Turnouts is prohibited. For any Doubling/New line/Tripling line projects use of single rail is prohibited. Rails of different lengths required to be used in T/o should be obtained by cutting long rail panels. Once again it is reiterated that **no AT welding on Turnout portion is permitted.**
- (C) Vide Board letter under reference (iii) above, USFD of AT Welds (being executed by Construction/RVNL/IRCON) has to be done by outsourced agency (to be fixed by executing agency) which is different from AT welding agency. Instruction has already been issued in this regard long back but are not being followed at present by the executing agencies. All executing agencies are requested to follow the Board letter under reference (iii) above, which clearly state that "while awarding the AT Welding contract, USFD agency should also be fixed by executing agency & it has to be different from the AT welding agency." The result of USFD agency should also be shared with Open line.

However, ~~for cross checking of USFD result~~ (outsourcing USFD agency fixed by the executing agency) by Open line, Departmental team ~~as per the~~ need would be deployed. Therefore, processing of the CRS papers should not get held-up/delayed ~~on account of non USFD testing~~ of AT welding by Open line.

Before AT welding is ~~started~~ by executing agencies, SrDEN/DEN to ensure that, different Agency for USFD testing is fixed/must be available with executing Agency.

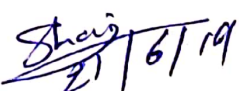
Defective weld failure rate for the AT welds executed by Construction, RVNL, IRCON should not be more than 1% as per Bd's instruction.

Sr.DEN/Co and Sectional DEN/Sr.DEN to ensure the implementation of this circular.


(Rajesh Arora) 21/6/19
Chief Track Engineer

Copy :

1. **DRM/JBP, BPL & KOTA** : for information.
2. **CE/C-I, CE/C-II & CPM/KOTA** : for information and n/a.
3. **SrDEN/Co/JBP, BPL & KOTA** : : for information. and n/a.

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