

**East Coast Railway
Engineering Department**

CE Circular No. 37

Sub.: Welding of stock rails and tongue rails of overriding switches with CMS crossings.

Para 237(m) of IRPWM stipulates that it is desirable to weld stock and lead joints on the Points and Crossings assembly, whereas RDSO drawing no. RDSO/T-4218 (ALT-5, dated 08.12.1997) for 1 in 12 Turn outs with 10125 mm over riding switches (curved) and CMS crossing BG (1673 mm) for 60 kg (UIC) on PSC sleepers mentions that all joints in the turn out shall be welded joints except for the tongue/stock rail and crossing joints which shall be machined joints.

Thus there appears to be lack of clarity with regard to the joints which are weldable in the turnouts as could be seen from different field practices being adopted.

In order to have uniform and proper field practices, the following clarifications are issued:

The latest RDSO drawing nos.:

1. RDSO/T-4218 (ALT-6, dated 02.11.2016) for 1 in 12 Turn outs with 10125 mm over riding switches (curved) and CMS crossing BG (1673 mm) for 60 kg (UIC) on PSC sleepers,
2. RDSO/T-4732 (ALT-4, dated 27.02.17) for 1 in 12 Turn outs with 10125 mm over riding switches (curved) and CMS crossing BG (1673 mm) for 52 kg (UIC) on PSC sleepers and
3. RDSO/T-4865 (ALT-6, dated 21.07.17) for 1 in 8.5 Turn outs with 6400 mm over riding switches (curved) and CMS crossing BG (1673 mm) for 52 kg (UIC) on PSC sleepers.

Mentions inter alia that:-

All the joints in the turn out shall be welded joints except for the tongue rail and crossing joints which shall be machined joints. The welded joints should preferably be flash butt welded. Care should be taken to ensure that the welded joints should remain suspended between the sleepers. Cut rails of suitable length should be used for the purpose.

In view of the above, it is hereby advised that all the joints in the turnouts shall be welded (preferably with flash butt welding) except the tongue rails joints (2nos) and crossing joints (4 nos) which shall be machined joints as per drawing no. RDSO/T/2594. The end faces of rails in those joints shall be machined true and square. The rails shall have two 26.5 mm dia holes located at 83 mm and 249 mm from ends.


(S. Nayak)

Chief Track Engineer

No.: W-4/374/CE/Circulars /Pt.I/3766

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