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NORTH EASTERN RAILWAY

CE CIRCULAR NO. 85 OF YEAR 2002

Sub : Execution of end cropping and welding of Rails.

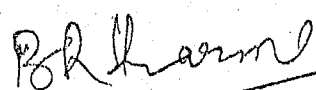
At various locations the work of end cropping and welding (ECW) of Through Weld Renewal (TWR) is carried out to rectify hogged and battered rail ends and also to remove fatigued welds. While executing the work of end cropping and welding or through weld renewal, no in-situ welding under running track should be carried out except where unavoidable. The work should be executed as follows :

- (i) One Km length of new rail (or less in case the lengths of cut pieces of the work is less than a Km) should be first brought to site.
- (ii) These are to be welded first at cess and all the welds tested by USFD.
- (iii) The existing rail with hogged rail/fatigued weld should be replaced with the new rails so welded.
- (iv) The released rails will be end cropped suitably and welded at cess and USFD tested.
- (v) Such released welded rails should be dragged ahead and rail renewal carried out in continuation of the new rails already changed.
- (vi) The released rails so obtained after rail changing will be repeated with same operations indicated above for completing the work for the stretch requiring ECW or TWR.

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- (vii) In case of ECW for fish plated 3 rail panels, end cropping of rail to half a metre on both sides should be done.
 - (viii) In case of TWR, wherever fish boltholes are existing cropping should be for half a metre and where no bold hole is existing cropping should be to the extent of 0.2 m.

All field engineers may be advised to follow the above sequence of operation for carrying out ECW and TWR.

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