SLOVENSKI STANDARD
SIST EN 15085-3:2008/AC:2010

01-marec-2010

Železniške naprave - Varjenje železniških vozil in elementov - 3. del: Zahteve za projektiranje

Railway applications - Welding of railway vehicles and components - Part 3: Design requirements

Bahnanwendungen - Schweißen von Schienenfahrzeugen und -fahrzeugteilen - Teil 3: Konstruktionsvorgaben

Applications ferroviaires - Soudage des véhicules et des composants ferroviaires - Partie 3 : Exigences de conception

Ta slovenski standard je istoveten z: EN 15085-3:2007/AC:2009

ICS:

25.160.10	Varilni postopki in varjenje	Welding processes
45.060.01	Železniška vozila na splošno	Railway rolling stock in general

SIST EN 15085-3:2008/AC:2010 en

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 15085-3:2007/AC

December 2009
Décembre 2009
Dezember 2009

ICS 25.160.10; 45.060.01

English version
Version Française
Deutsche Fassung

Railway applications - Welding of railway vehicles and components - Part 3: Design requirements

Applications ferroviaires - Soudage des véhicules et des composants ferroviaires - Partie 3 : Exigences de conception

Bahnanwendungen - Schweißen von Schienenfahrzeugen und -fahrzeugteilen - Teil 3: Konstruktionsvorgaben

This corrigendum becomes effective on 16 December 2009 for incorporation in the official English version of the EN.

Ce corrigendum prendra effet le 16 décembre 2009 pour incorporation dans la version anglaise officielle de la EN.

Die Berichtigung tritt am 16.Dezember 2009 zur Einarbeitung in die offizielle Englische Fassung der EN in Kraft.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: Avenue Marnix 17, B-1000 Brussels

Ref. No.:EN 15085-3:2007/AC:2009 E

1 Modification to Annex B

Replace the last two pages of Table B.1 with the following ones (as the contents in the far right column are not entirely displayed in the English language version issued in 2007):

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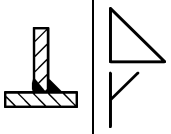
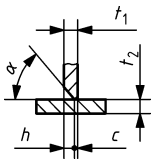
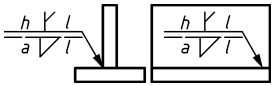
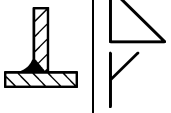
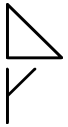
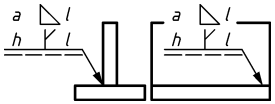
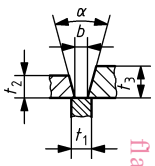
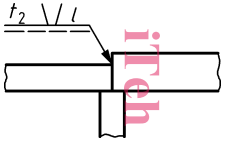
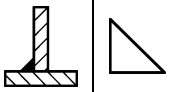
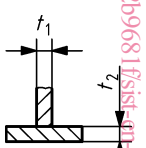
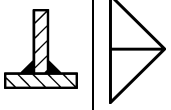
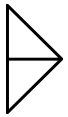
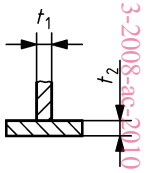
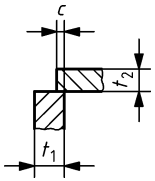
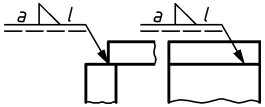
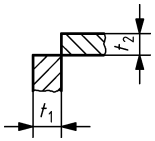
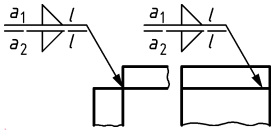
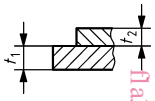
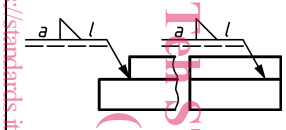
No.	Marking	Figure	Symbol	Joint preparation sectional view	Symbolic drawing	Material thickness t (mm)		Angle a		Gap b (mm)		Thickness of root face c (mm)		Depth of preparation h (mm)		Design throat thickness a_R (mm)
						Al [a]	Steel	Al [a]	Steel	Al [a]	Steel	Al [a]	Steel	Al [a]	Steel	
11b	HY weld with fillet weld as sealing run [e]					3 – 15	3 – 15	50 – 60	50 – 60	–	–	≤ 0,2 t	≤ 0,2 t	–	–	$a_R \le h + a \le t_1$
11c	HY weld with additional fillet weld					3 – 15	3 – 15	50 – 60	50 – 60	–	–	≤ 0,2 t	≤ 0,2 t	–	–	$a_R \le h \le t_1$ in special cases: $a_R \le h + a \le t_1$
12	Joint between three members					t_2 4 – 20	t_2 4 – 20	30 – 40	20 – 40	4 – 10	4 – 10	–	–	–	–	$a_R = b$ [f] $a_R = t_2$ [g]
13a	Fillet weld					Al: a_{min} 3 mm, a_{max} 12 mm Steel: a_{min} 2 mm, a_{max} 12 mm										$a_R = a \le 0{,}7 \times t_{min}$
13b	Double fillet weld					Al: a_{min} 3 mm, a_{max} 12 mm Steel: a_{min} 2 mm, a_{max} 12 mm										$a_R = a_1 + a_2 \le t_{min}$ $a_{max} \le 0{,}7 \times t_{min}$

No.	Marking	Figure	Symbol	Joint preparation sectional view	Symbolic drawing	Material thickness t (mm)		Angle a		Gap b (mm)		Thickness of root face c (mm)		Depth of preparation h (mm)		Design throat thickness a_R (mm)
						Al [a]	Steel	Al [a]	Steel	Al [a]	Steel	Al [a]	Steel	Al [a]	Steel	
13c	Corner seam weld					t_1 ≥ 1	t_1 ≥ 1	–	–	–	–	–	–	–	–	$a_R = a \leq 0{,}7 \times t_2$ $t_2 \leq t_1$
13d	Corner seam weld					t_2 ≥ 3	t_2 ≥ 3	–	–	–	–	–	–	–	–	$a_R = a_1 + a_2 \leq t_2$ $a_1 \leq 0{,}7 \times t_2$ $t_2 \leq t_1$
13e	Lap seam weld					t_2 ≥ 1,5 t_1 ≥ 3	t_2 ≥ 1,5 t_1 ≥ 2	–	–	–	–	–	–	–	–	$a_R = a \leq 0{,}7 \times t_2$ $t_2 \leq t_1$

It is possible to depart from this weld preparation, if special welding processes (for example mechanized welding processes) are used and the required throat thickness is proved by a work specimen.

a Aluminium and aluminium alloys.

b M or MR (see EN 22553).

c Before welding the sealing run the root shall be grooved out.

d For HV weld without a sealing run there shall be steps by design, production and testing for a safe root fusion (test specimens).

e The sealing run serves to prevent gap corrosion.

f Force transmission from t_1 to t_2 and t_3; the thicknesses t_2 and t_3 and the joint root opening b shall be additionally considered at the calculation.

g Force transmission from t_2 to t_3.

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