

ICS 25.160.10; 45.060.01;

PN-EN 15085-3:2007/AC

maj 2010

Wprowadza
EN 15085-3:2007/AC:2009, IDT

Dotyczy
PN-EN 15085-3:2007

**Kolejnictwo -- Spawanie pojazdów szynowych i ich części składowych -- Część 3:
Wymagania konstrukcyjne**

Na wniosek Komitetu Technicznego nr 138
ds. Kolejnictwa

**Poprawka do Normy Europejskiej EN 15085-3:2007/AC:2009 Railway applications - Welding of railway
vehicles and components - Part 3: Design requirements**
ma status Poprawki do Polskiej Normy

EUROPEAN STANDARD

EN 15085-3:2007/AC

NORME EUROPÉENNE

December 2009

EUROPÄISCHE NORM

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

© 2009 CEN All rights of exploitation in any form and by any means reserved worldwide for CEN national Members.
Tous droits d'exploitation sous quelque forme et de quelque manière que ce soit réservés dans le monde entier aux membres nationaux du CEN.
Alle Rechte der Verwertung, gleich in welcher Form und in welchem Verfahren, sind weltweit den nationalen Mitgliedern von CEN vorbehalten.

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):

"

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	-	-	$\leq 0,2 t$	$\leq 0,2 t$	-	-	$a_R \leq h + a \leq t_1$
11c	HY weld with additional fillet weld					3 - 15	3 - 15	50 - 60	50 - 60	-	-	$\leq 0,2 t$	$\leq 0,2 t$	-	-	$a_R \leq h \leq t_1$ in special cases: $a_R \leq h + a \leq t_1$
12	Joint between three members					4 - 20	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										$a_R = a \leq 0,7 \times t_{\min}$
13b	Double fillet weld					Al: a_{\min} 3 mm, a_{\max} 12 mm Steel: a_{\min} 2 mm, a_{\max} 12 mm										$a_R = a_1 + a_2 \leq t_{\min}$ $a_{\max} \leq 0,7 \times t_{\min}$

EN 15085-3:2007/AC:2009 (E)

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					$t_1 \geq 1$	$t_1 \geq 1$	-	-	-	-	-	-	-	-	$a_R = a \leq 0,7 \times t_2$ $t_2 \leq t_1$
13d	Corner seam weld					$t_2 \geq 3$	$t_2 \geq 3$	-	-	-	-	-	-	-	-	$a_R = a_1 + a_2 \leq t_2$ $a_1 \leq 0,7 \times t_2$ $t_2 \leq t_1$
13e	Lap seam weld					$t_2 \geq 1,5$ $t_1 \geq 3$	$t_2 \geq 1,5$ $t_1 \geq 2$	-	-	-	-	-	-	-	-	$a_R = a \leq 0,7 \times t_2$ $t_2 \leq t_1$
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.																
<p>a Aluminium and aluminium alloys.</p> <p>b M or MR (see EN 22553).</p> <p>c Before welding the sealing run the root shall be grooved out.</p> <p>d For HV weld without a sealing run there shall be steps by design, production and testing for a safe root fusion (test specimens).</p> <p>e The sealing run serves to prevent gap corrosion.</p> <p>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.</p> <p>g Force transmission from t_2 to t_3.</p>																