**TAN-Nr.: TAN****Auftragsnummer:    /     /**

***TAN no.: Order code:***

**Checkliste B 255** **Schienen abbrennstumpfgeschweißt, Übergangsschienen, Neuschienenbearbeitung im Schweißwerk, Altschienenaufarbeitung/**

***Checklist B 255 Rails flash butt welded, transition rails, new rail processing in welding shop, disused rail reconditioning***

**Firma/ *Company:***

**Standort/ *Location:***

**Fertigung für Firma/ *Production for company:***

|  |  |
| --- | --- |
| **1** | **Welche Profile und Stahlgüten werden für die Deutsche Bahn AG verschweißt?/** ***What profiles and steel grades are welded for Deutsche Bahn AG?*** |
|  | **Schienenprofil/** ***Rail profile*** | **R 260** | **R 350** | **R 320** | **Sonder-güte/** ***Special grade*** | **Liefer-länge (m)/** ***Delivery length (m)*** | **Bemerkungen/** ***Comments*** |
| [ ]  | 49 E5/ *49 E5* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | 49 E1 (Hemmschuhbetrieb)/ *49 E1 (drag shoe operation)* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | 54 E4/ *54 E4* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | 54 E3 (Hemmschuhbetrieb)/ *54 E3 (drag shoe operation)* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | 60 E2/ *60 E2* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | 60 E2 A1 (60 E2 – 40)/ *60 E2 A1 (60 E2 – 40)* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | R 65/ *R 65* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  | Anschweißende Herzstück/ *Common crossing to be welded on* | [ ]  | [ ]  | [ ]  |       |       |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |       |       |

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| **2** | **Welche Tätigkeiten werden durchgeführt?/** ***What activities are performed?*** | **Bemerkungen/ *Comments*** |
| **[ ]**  | Abbrennstumpfschweißen von Schienen/ *Flash butt welding of rails* | weiter mit 4/ *continue with 4* |       |
| [ ]  | Übergangsschienen/ *Transition rails* | weiter mit 5/ *continue with 5* |       |
| [ ]  | Neuschienenschleifen/ *New railway track grinding* | weiter mit 6/ *continue with 6* |       |
| [ ]  | Altschienenbearbeitung/ *Disused rail machining* | weiter mit 8/ *continue with 8* |       |
| [ ]  |       |       |       |
| [ ]  |       |       |       |

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|  **3**  | **Welche Schienenlängen können hergestellt und geliefert werden?/** ***What rail lengths can be produced and supplied?*** |
| **Fertigungslänge in m/** ***Production length in m*** | **Schienengüte/** ***Rail grade*** | **Bemerkungen/ *Comments*** |
|     |       |       |
|     |       |       |

**Nicht zutreffende Punkte finden keine Betrachtung im Bewertungsfeld!/**

***Items that do not apply are not analysed in the assessment field!***

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| **4** | **Liegen die erforderlichen Normen und Bahnstandards in der aktuellen Ausgabe und in der Landessprache vor?/** ***Is the latest edition of the requisite standards and rail standards available in the national language?*** | **👍****☺** | **?****😐** | **👎☹** | **Bemerkungen/ *Comments*** |
| [ ]  | EN 14 587-1 Abbrennstumpfgeschweißte Schienen, Schweißwerk/ *EN 14 587-1 Flash welded rails, welding shop* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | EN 14 587-3 Abbrennstumpfgeschweißte Schienen, Konstruktionsschienen/ *EN 14 587-3 Flash welded rails, switch and crossing rails* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | DBS 918 255-1 Abbrennstumpfgeschw. Schienen, Schweißwerk/ *DBS 918 255-1 Flash welded rails, welding shop* | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
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| **5** | **Liegen die erforderlichen Zulassungen und Freigaben vor?/** ***Are the required approvals and releases available?*** | **Gültig bis/** ***Valid until*** | **👍****☺** | **?****😐** | **👎☹** | **Bemerkungen, Freigabe/** ***Comments, release*** |
| [ ]  | DB-Ril 826.2050/ *DB Guideline 826.2050* |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißmaschine/ *Welding machine* |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Fräse/ *Milling machine* |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  | UT-Prüfstand/ *UT test rig* |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Biegebruchprüfmaschine/ *Bending fracture testing machine* |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       |       | [ ]  | [ ]  | [ ]  |       |

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| **Fertigungsprozesse/ *Production processes*** |
| **6** | **Abbrennstumpfgeschweißte Schienen/** ***Flash welded rails*** | **👍** | **👍** | **👎** | **Bemerkungen/ *Comments*** |
| [ ]  | Trennen der Schienen/ *Separation of rails* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Umkennzeichnung der Schienen/ *Re-marking of rails* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißenden vorbereiten/ *Prepare welded ends* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Ausrichtung/ *Alignment* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißprozess/ *Welding process* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Weldanalyser/ *Weld analyser* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Abscheren/ *Shearing* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Prüfung (mit ausgeklinktem Lineal)/ *Test (with folded-out ruler)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Weitertransport/ *Further transport* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißnahtbearbeitung/ *Weld machining* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schleifen/ *Grinding* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißwulstdicke/ *Weld bead thickness* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißwulsübergang/ *Weld bead transition* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Transport/ *Transport* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Richten/ *Straightening* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Fertigschliff/ *Final sanding* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Prüfen (Abnahme)/ *Test (acceptance)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Kennzeichnung (gem. DBS, Fahrkante)/ *Marking (as per DBS, running edge)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Herstellerkennzeichen/ *Manufacturer's mark* | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |

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| **7** | **Übergangsschienen/** ***Transition rails*** | **👍****☺** | **?****😐** | **👎☹** | **Bemerkungen/ *Comments*** |
| [ ]  | Trennen der Schienen/ *Separation of rails* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Umkennzeichnung der Schienen/ *Re-marking of rails* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schweißenden vorbereiten/ *Prepare welded ends* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Erwärmung/ *Heating* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Schmieden (Profilanpassung)/ *Forging (profile adjustment)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Sägen/ *Sawing* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | weiter wie in 4/ *continue as in 4* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Prüfung nach Zeichnung (Abnahme)/ *Test according to drawing (acceptance)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
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| **8** | **Neuschienenbearbeitung/** ***New rail processing*** | **👍****☺** | **?****😐** | **👎☹** | **Bemerkungen/ *Comments*** |
| [ ]  | Festlegung Fahrkante/ *Specification of running edge* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Ggf. Wechsel Fräsrad/ *If necessary, change milling wheel* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Kontrolle Schleifrad/ *Check grinding wheel* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Kontrolle Voreinstellungen/ *Check default settings* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Kontrolle Fahrkante (Schliffbild, Maße)/ *Check running edge (microsection, dimensions)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |

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| **9** | **Altschienenaufarbeitung/** ***Disused rail reconditioning*** | **👍****☺** | **?****😐** | **👎☹** | **Bemerkungen/ *Comments*** |
| [ ]  | Kontrolle Altschienen/ *Check disused rails* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Sortierung/ *Sorting* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Bearbeitung/ *Processing* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | UT-Prüfung/ *Ultrasound test* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Kontrolle/ *Checking* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | weiter mit **4** oder **5/** *continue with* ***4*** *or* ***5*** | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |

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| **10** | **Prüfungen (gemäß DBS 918 255-1)/** ***Tests (as per DBS 918 255-1)*** | **👍****☺** | **?****😐** | **👎☹** | **Bemerkungen/ *Comments*** |
| [ ]  | Qualifizierungsprüfung alle 5 Jahre (durch DB Netz AG)/ *Qualification test every 5 years (by DB Netz AG)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Prüflabor (Name)/ *Testing laboratory (name)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Biegebruchprüfung (wöchentlich)/ *Bending fracture test (weekly)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | ggf. Bruchbildkontrolle (bei Bruch)/ *If required, check fracture pattern (in case of fracture)* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Fahrkante/ *Running edge* | [ ]  | [ ]  | [ ]  |       |
| [ ]  | Fahrfläche/ *Running surface* | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |
| [ ]  |       | [ ]  | [ ]  | [ ]  |       |

**Welches Herstellerzeichen/Schild verwendet die Firma?** (schwarz/weiß)/

***What manufacturer's mark/plate does the company use?*** *(black/white)*

Ggf. gesondert anfügen/

*Add separately if necessary*

**Weitere Bemerkungen:/**

***Additional comments:***

|  |  |  |
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| durchgeführt am/ *performed on**(dd.mm.yyyy)* | durchgeführt in/ *performed in* | durch QPI/ *by quality test engineer* |
|       |       |  |