

Grooved Rail

- Equipment for tramline welding.
- Consumables for tramline welding.
- Austenetic consumables are used because pre-heating is limited in cases where rails are embedded



Equipment



Tramtrac II welding tractor



The Idea

- Light weight 12 kg without wire
- Easy to use
- Quickly applied and removed from track
- Easy to store
- Picks up safe 42 Vac control power from Origo Mig 410 welding machine
- Used in daytime shift
- Only minute stoppages of tramway traffic
- Proven savings in total maintenance



Equipment

- Tramtrac II
- Welding power source OrigoMig 410
- Power Generator
- All fit easily into a small pick up truck for easy access to work area



Equipment

- Europower 15 kVA
3-phase power
generator with 9 hp
Honda petrol engine
- Electric start with
earth breaker and
spike



Equipment



- Welding Power Source
- OrigoMig 410 constant voltage characteristic
- 400 A and 34 volts at 50% duty cycle



Tramtrac II in Action



Consumables

- OK Tubrodur 14.71 Ø 1.6 mm
- OK Tubrodur 15.65 Ø 1.6 mm
- Work hardens
Hardness aw HB 200 wh HB 400
- 16 kg wire baskets
- The most suitable wires where preheating is impossible



Consumables

- Open arc flux core wire
- OK Tubrodur 15.65 1.6 mm Ø
- Excellent impact properties.
- Excellent corrosion properties
- Fantastic slag detachability
- Work hardens aw 200 HB wh 400 HB
- Grinding only (if needed)



Tramway Applications



Tramway Applications



Before welding

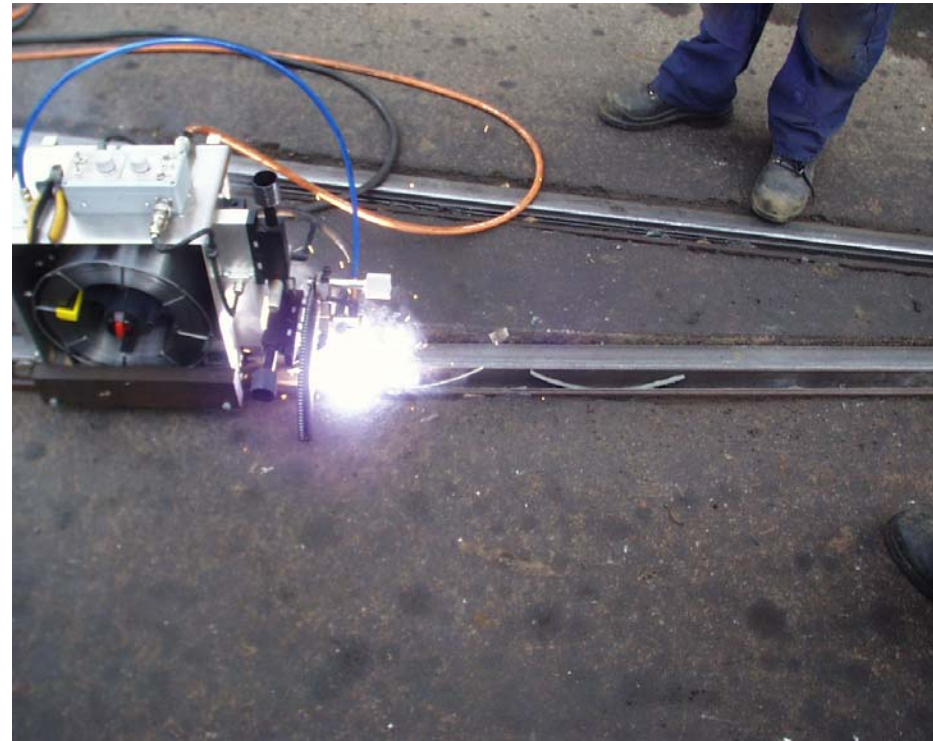


After welding



Tramway Applications

- Slag is self releasing
- No grinding before or after welding
- Nice bead appearance
- OK Tubrodur 15.65 on the running area
- OK Tubrodur 14.71 on the flange



Tramway Applications

- No preheating of embedded rails
- Little grinding necessary before welding
- Some or no grinding necessary after the welding is concluded

