



1.5 INCH GAP WELD

THERMIT® WELDING PROCESS

The 1.5 inch gap THERMIT® welding process is used as a standard method for joining of steel rails for specifically heavy haul applications in some countries. The increased gap width from a 1 inch gap width allows for a reduced solidification rate for additional time for reaction gases and impurities to escape from the weld mass.

RELIABLE AND ROBUST

Customers have a choice of an increased gap width THERMIT® welding process which can be used with the degradable crucible system. The 1.5 inch gap weld has an improved fatigue life and near similar slow bend test properties than conventional one inch gap welds.

RAIL JOINING

RAIL SERVICES

MEASUREMENT

TOOLS & MACHINES

EQUIPMENT

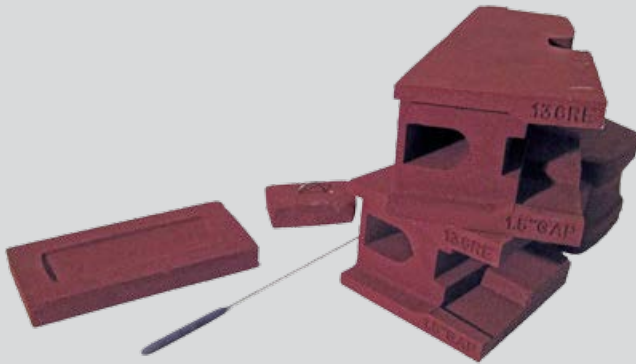
MEMBER OF



GOLDSCHMIDT
THERMIT GROUP

OVERVIEW OF 1.5 INCH GAP WELDING PROCESS

Feature	Function	Benefit
Designed for AREMA standard, intermediate strength and high strength steel rails	Reliable welding process with extremely stable weld metal chemistry	Reduced defects that are associated with fast weld metal solidification
Available in 2 piece or 3 piece mold configurations	The pouring of the liquid steel in the center of the gap area results in excellent heat exchange and metallurgical benefits	Improved life of the weld
Available for 1.5 inch gap welding process with the degradable crucible system	Additional tools include 1.5 inch gap mold shoes, 1.5 inch gap gauge and the 1.5 inch gap under base pan for the 3 piece mold application	Easier "forgiving" installation than the conventional 1 inch gap welds



RAIL JOINING

RAIL SERVICES

MEASUREMENT

TOOLS & MACHINES

EQUIPMENT

MEMBER OF



GOLDSCHMIDT
THERMIT GROUP

Orgo-Thermit, Inc.

3500 Colonial Drive North
Manchester, NJ 08759 USA

Phone: (732) 657-5781, Fax: (732) 657-5899

info@orgothermit.com, www.orgothermit.com