



## FULL HEAD REPAIR WELD

### FOR THE REPAIR OF RAILHEAD DEFECTS

This process allows for the quick and economical repair of localized defects in the head of the rail such as squats, shells, wheel burns, transverse defects, detail fractures or individual electrical welding defects. The rail neutral temperature is not affected. The fast and reliable process takes approximately 45 minutes versus 2 hours required to perform two THERMIT® welds when installing a plug rail.

### SAFE AND COST-EFFECTIVE

In this process the complete rail head is ground out to remove surface defects and internal defects. The rail fasteners remain in track and the lateral rail alignment is maintained. The result: Considerable savings in the cost of inserting a plug rail – and also significantly and sustainably reduces the life cycle costs of your rails. Our professional repair welding process, Full Head Repair, is available for most common rail profiles.

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## OVERVIEW OF FULL HEAD REPAIR

Feature	Function	Benefit
Grind out complete rail head	Suitable for removing locally limited rail defects, e.g. head checks, squats and shells	Reduction of maintenance costs
THERMIT® welding process	Minimal additional training for trained THERMIT® welders Uses mainly standard equipment	High process reliability High quality alternative to conventional electric contract welding
No separation of the rail cross section The neutral temperature of the rail is not affected	No change to rail tension during welding, a further destressing of the track is not required	Less work requirements considerably lowers repair costs No associated plug rail costs
Short preheating time of only 1–4 minutes	No change to preheating equipment	Time-saving

### Special equipment required

- » Rail notcher or switch grinder with 2" wide grinding stone
- » Head Repair mold shoes
- » Tube extender

### Consumables

- » Head Repair molds
- » Head Repair THERMIT® portions

### Maximal size of defect

- » 2 inch length and full-width of the rail head



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