



## Technical data for Gantrail welding process of crane rails

Type of Rail	size of gap	alignment over the crown	burner height	duration of preheating	pressure oxygen / propane	Flowing pressures* at burnerhandle oxygen / propane	type of burner	time to shear off	Notice				
A 45	24-26 mm 1 inch	1,0- 1,5 mm 3/64 - 1/16 inch	100 ± 5 mm 4 inch	4 - 4,5 min.	4,5 bar / 1,0 bar	1,75 bar / 0,35 bar	21 / 22 holes	5 min					
A 55				4 - 5 min.									
A 65				7 - 8 min.									
A 75	8 - 9 min.												
A 100	10 min.												
A 120	13 min												
A 150	80 ± 5mm 3,149 inch		24 min After 10 min. oscillate burner.	4,5 bar / 1,0 bar				1,75 bar / 0,35 bar		21 / 22 holes	7,5 min.	to prevent burner overheating change burner after 16 min. preheating	
CR 164			25 min.								16 min.	After 10 min. oscillate burner	
CR 192			28 - 30 min.								12-14 min		
MRS 87 A			60 ± 5 mm 2,362 inch								18 -20 min	7 min.	
MRS 125			60 ± 5 mm 2,362 inch								20 - 22 min.	7,5 min.	
MRS 151			80± 5 mm 3,149 inch								20 - 22 min.	7,5 min.	
MRS 221	80 ± 5 mm 3,149 inch		28 - 30 min.								12- 14 min.	After 10 min. oscillate burner	
PRI 85	60 ± 5 mm 2,362 inch	16 min.	7 min.										
QU 120	60 ± 5 mm 2,362 inch	20 22 min	7,5 min.										

\* Rails class R 320cr preheat left and right 1 meter 50-70°C