

2.1.6 BRANDING AND STAMPING (2003) *As Written in the 2010 AREMA Manual*

a. Branding shall be rolled in raised characters on the side of the web of each rail at a minimum of every 16 feet in accordance with the following requirements:

(1) The data and order of arrangement of the branding shall be as shown in the following typical brand.

136	RE	Manufacturer	2003	III or 3
(Weight)	(Section)	(Mill Brand)	(Year Rolled)	(Month Rolled)

(2) The method of Hydrogen Elimination shall be located in the brand as section 2.1.7.b when a Hydrogen Elimination method other than Vacuum Treated (VT) is used. – *NEW Addition*

(3) The design of letters and numerals are determined by the manufacturer.

b. The web of each rail shall be hot stamped a minimum of 3 times per rail (short rails must contain a minimum of one full stamp) on the side opposite the brand, and shall not occur within 2 feet of either end of rails, and in accordance with the following requirements:

(1) The data shall be shown in the following typical stamping. The height of the letters and numerals shall be e inch.

SS, HH, LA, IH, or LH	297165	PSTU	12	BC
(Rail Type)	(Heat Number)	(Rail Letter)	(Strand and Bloom Number)	(Method of Hydrogen Elimination, if indicated in stamping)
SS = Standard Strength				
HH = Head Hardened				
LA = Low Alloy Standard Strength				
IH = Low Alloy Intermediate				
LH = Low Alloy Head Hardened				

(2) Rails from continuous cast blooms shall be identified by a designation for heat number, strand number, and bloom number. The rail shall be identified by an alphabetical designation beginning with “P”, and succeeding “S”, “T”, “U”, etc., consecutively, or any other identification of the position of the rail within the cast, as agreed between the purchaser and manufacturer.

NOTE: Strand and bloom numbers may be joined or may be coded at the manufacturer’s option.

(3) The e inch stamped characters shall have a flat or radius face (0.040 inch to 0.060 inch wide) with bevels on each side so as not to produce metallurgical stress risers. The letters and numbers shall be on a 10 degree angle from vertical and shall have rounded corners. The stamping shall be between 0.020 inch and 0.060 inch in depth along the center of the web. The design shall be as shown in [Figure 4-2-2](#).

(4) High-strength rail shall be identified in accordance with [Paragraph 2.1.154-a](#).