



# ANSF

*Agenzia Nazionale  
per la Sicurezza  
delle Ferrovie*

ANSF Agenzia Nazionale  
per la Sicurezza delle Ferrovie

prot. n° 003072/2015  
16/04/2015

## IMPRESE FERROVIARIE

Loro sedi

## SOGGETTI RESPONSABILI DELLA MANUTENZIONE

Loro sedi

## DETENTORI

Loro sedi

## ASSOFERR

c/o ASSTRA Piazza Cola di Rienzo, 80/a  
00192 Roma

## RETE FERROVIARIA ITALIANA S.p.A.

- Amministratore Delegato
- Sicurezza di Rete
- Direzione Tecnica

Piazza della Croce Rossa, 1

00161 Roma

**Oggetto:** Integrazione Safety Alert NSA Polonia – Difetto di fabbricazione di ruote cerchiate per  
sulle montate costruite dal 2/01/2012 al 26/09/2014.

**Riferimento:** Nota ANSF protocollo n° 001844/2015 del 5/03/2015.

**Allegati:** Nota Huta Bankowa Sp. z o. o. prot. HB/BR/31/2015 del 04/03/2015;  
Nota Huta Bankowa Sp. z o. o. ad ANSF del 09/03/2015;  
Modifica Safety Alert NSA Polonia.

Ad integrazione di quanto segnalato con la nota a riferimento, si trasmettono in allegato le note inviate dal costruttore delle ruote cerchiate interessato dal "Safety Alert" in oggetto e la modifica del Safety Alert stesso, fatta dalla NSA Polonia, con le quali vengono forniti chiarimenti in merito alla produzione delle ruote nel periodo dal 2/01/2012 al 26/09/2014.

IL DIRETTORE  
ing. Amedeo Gargiulo

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HUTA  
**BANKOWA**  
Grupa  
alchemia

ALLEGATO 1 Og. sit. 4/3 h 1615

Prof. Cierniak  
Prof. Rorban

ANSF Agenzia Nazionale  
per la Sicurezza delle Ferrovie  
001952/2015  
09/03/2015

**TO WHOM IT MAY CONCERN**

HB/BR/ 31 /2015

2015-03-04

Concerns.: UTK's Safety Alert

Dear Sirs,

In connection with issuing "Safety Alert" by Urząd Transportu Kolejowego from Warsaw – UTK (Railway Transport Office) concerning production of railway wheel tires in Huta Bankowa in period of 02.01.2012 to 09.26.2014 we would like to inform that **UTK's objects concern only railway tires of steel grades P54, P55A and P60 which haven't been cooled in cooling pits under covers, what is required to do by Polish standard PN-H-84027/06.**

Cooling the tires in cooling pits stopped being needed from the moment when for the manufacture of railway tires, Huta has started using only raw material which was produced on modern technological lines of steel melting and finishing, with full infrastructure of off-furnace and continuous casting technology. For the above mentioned chemical analysis looks as follows: H2≤2 ppm, O2≤20 ppm, N2≤70 ppm and P max 0.015% and 0.015% S max.

**UTK's objections do not apply to the railway tires which were used outside the Polish territory because international standards, such as Code of UIC 810-1 V edition of 2003 and GOST 398-2010, allow to skip the slow cooling process of the tires manufactured from vacuum degassed steel and steel with a hydrogen content of 2 ppm.**

On 4<sup>th</sup> of March 2015 Huta Bankowa appealed to UTK Warsaw demanding correction of above mentioned objections.

Sincerely  
PREZES ZARZADU  
DYREKTOR/NACZELNY

Jaruz Siemieniec

Huta Bankowa Spółka z o.o.

ul. Sobieskiego 25, 41-300 Dąbrowa Górnicza

T. (+48) 32 295 74 00, F. (+48) 32 262 37 88/262 35 28

e-mail: info@huta-bankowa.com.pl

Temat: HB/BR a/a;

REC 02/03 11/15



HUTA BANKOWA  
atchemia

ANSF per la Sicurezza delle Fer  
prot n° 002018/2015  
11/03/2015

Margante PP  
Sciell's Distribution

ALLEGATO 2

Il Direttore  
Ing. Amedeo Gargiulo  
ANSF

09.03.2015

Quality guarantee

Subject: Safety alert issued by Polish Office of Rail Transport

Dear Sirs,

With reference to the safety alert issued by Polish Office of Rail Transport on 02.03.15 we would like to inform that it concerns only tyres made according to Polish Standard. We hereby guarantee and assure that all tyres manufactured by Huta Bankowa in the period from 02.01.2012 to 26.09.2014, meet all requirements of UIC 810-1 edition V – January 2003 without any deviation and were produced from steel with hydrogen content below 2 ppm (certificates for steel available upon request). All stages of production and fulfilment of UIC 810 standard requirements are recorded in our files and we can make it available to you upon request at any time. We also assure that mechanical and exploitation properties for all tyres meet UIC 810-1 standard requirements and they were tested as it was required by particular orders.

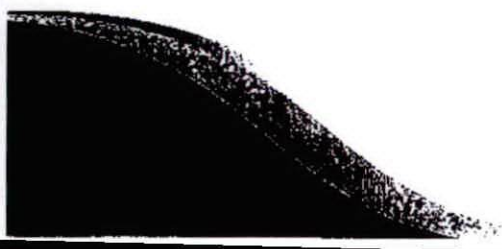
By this letter we also confirm that we are ready and able to be a subject for any quality audit in terms of product quality or conformity of particular production stages to UIC 810 standard at any time.

As enclosure, please find our production line scheme for tyres which clarifies the difference between requirements of Polish and UIC standards.

Yours faithfully,

WICEPREZES ZARZADU )  
Jacek Boruchowski

Huta Bankowa Spółka z o.o.  
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KRS 0000000000, NIP 142-200-0000, REGON 142200000  
www.hutabankowa.com.pl



## PRODUCTION LINE FOR TYRES

Steel in grades P54, P55A, P60  
acc. to PN-H-84027/06:1984  
with hydrogen contents above 2 ppm  
(used at Huta Bankowa till 2.01.2004)



hot rolling process



Slow cooling in covered  
unheated cooling pits

OBLIGATORY PROCESS  
EXCESS OF HYDROGEN MAY  
CAUSE INTERNAL CRACKS!

Steel for railway acc. to UIC 810-1 edition V vacuum  
degassed with hydrogen contents up to 2 ppm  
(used at Huta Bankowa from 2.01.2004)

hot rolling process



Normal air-cooling in  
production hall

Slow cooling in covered  
unheated cooling pits in order  
hydrogen contents is  
removed until 2 ppm level.

UNNECESSARY PROCESS  
BECAUSE EXCESS OF  
HYDROGEN WAS REMOVED  
DURING STEEL MELTING  
PROCESS!

### Note!

Polish Office of Railway Transport requires the tyres to be cooled in unheated cooling pits for steel grades P54, P55A, P60 acc. to PN-H-84027/06:1984 in spite of the fact that beginning from 2.01.2014 Huta Bankowa has been using only vacuum degassed steel with hydrogen contents up to 2 ppm.



WYKONANIE  
*[Signature]*  
Kierownik

WICEPREZES ZARZĄDU

*[Signature]*  
Jacek Boruciński

# ALLEGATO 3

SAFETY ALERT		
<b>SYSTEM/ EQUIPMENT</b>	The wheel tyres of wheelsets of railway vehicles.	
<b>SAFETY ISSUE DESCRIPTION</b>	During the control carried out by the President of the Office of Rail Transport (NSA Poland) in the framework of supervision activities of products used in railway, the non-conformity with Polish standard PN-84H-84027/06 has been found in the field of cooling after the rolling process of wheel tyres of wheelsets in grades P54, P55A and P60, produced by Huta Bankowa Sp. z o.o. This process was carried out without using the slow cooling in unheated pits under cover. The wheel tyres produced between 2.01.2012 and 26.09.2014 could be produced outside the conditions determined in Polish standard PN-84 H-84027/06 which requires to do the cooling process of railway wheel tyres in unheated pits under cover.	
<b>CIRCUMSTANCES</b>  <i>(e.g. special weather conditions)</i>	-	
<b>REASON FOR ISSUE</b>	The wheelsets with wheel tyres produced between 2.01.2012 and 26.09.2014 by Huta Bankowa Sp. z o.o., could be produced outside of the conditions determined in Polish standard PN-84 H-84027/06 which requires to do the cooling process of wheel tyres in grades P54, P55A and P60 in unheated pits under cover.	
<b>LIST OF SUPPORTING DOCUMENTS</b>  <i>(e.g. PHOTOS, LINKS)</i>	-	
<b>LINKED WITH OCCURRENCE NOTIFIED TO ERA DATABASE?</b>	no	<b>LINK TO ERA NOTIFICATION</b>
<b>OCCURRENCE DATE</b>	-	

ISSUER			
<b>ORGANISATION</b>	Office of Rail Transportation – National Safety Authority in Poland		
<b>CONTACT DATA</b>		-	 pawel.michalczyk@utk.gov.pl
<b>ISSUE DATE</b>	20/03/2015		