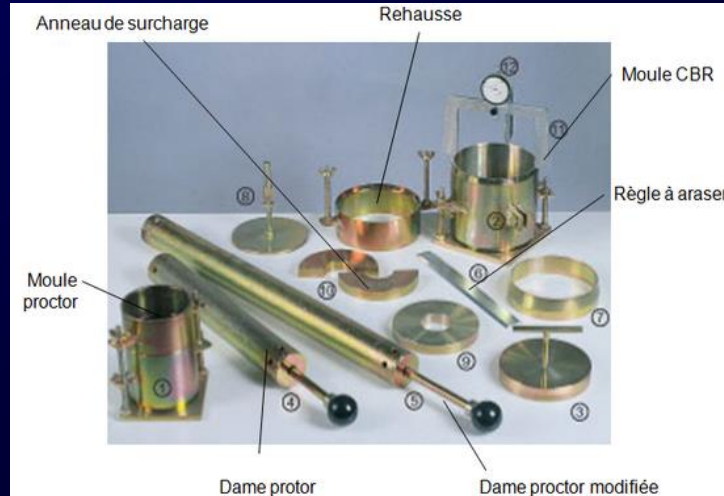


1ST RALPH PROCTOR LECTURE OF ISSMGE - 2016

Railroad Performance with Special Reference to Ballast and Substructure Characteristics



Ralph Roscoe Proctor
1894-1962



Prof. Buddhima Indraratna

*Distinguished Professor of Civil Engineering & Research Director,
Centre for Geomechanics & Railway engineering*

(c/o ARC Centre of Excellence in Geotechnical Sciences and Engineering)

Faculty of Engineering, University of Wollongong, NSW, Australia

Rail Geotechnics in a Nutshell – Key Themes

1

Basics of track substructures and rail embankments

Indraratna et al., 2011b; Iwnicki, 2006; Li et al., 2015; Miura et al., 1998; Mundrey, 2009; Selig & Waters, 1994

3

Experimental studies on ballast: deformation and degradation

Aursudkij et al., 2009; Brown et al., 2007; Chen et al., 2014b; Correia et al., 2007b; Indraratna et al., 1998, 2005, 2014f; Ishikawa et al., 1997, 2011, 2014a; Kennedy et al., 2012; Lackenby et al., 2007; Le Pen & Powrie, 2011; Li & Selig, 1996; McDowell et al., 2003, 2004, 2005; Selig & Sluz, 1978; Suiker et al., 2005; Sun et al., 2016; Tutumluer et al., 2008; Woodward et al., 2014

5

Track drainage and effects of ballast fouling

Budiono et al., 2004; Darell, 2003; Dombrow et al., 2009; Ebrahimi et al., 2012, 2014; Feldman & Nissen, 2002; Giannakos, 2010; Hesse et al., 2014; Huang et al., 2009a; Indraratna et al., 2011a, 2013b; Trinh et al., 2012; Tutumluer et al., 2008

7

Use of impact-attenuating synthetic mats

Alves Ribeiro et al., 2015; Auersch, 2006; Dahlberg, 2010; Hanson & Singleton Jr, 2006; Indraratna et al., 2014c, 2014e; Insa et al., 2014; Johansson et al., 2008; Kaewunruen & Remennikov, 2015; Markine et al., 2011; Marschnig & Veit, 2011; Nimbalkar et al., 2012; Paixão et al., 2015; Schneider et al., 2011; Sol-Sánchez et al., 2014, 2015b, 2015a; Wan et al., 2016

9

Subgrade performance, instability and implications on track response; Stabilisation of subgrade for railways

Alves Costa et al., 2010; Cardoso et al., 2012; Correia & Cunha, 2014; Duong et al., 2013; Farris, 1970; Fatahi et al., 2015; Indraratna et al., 2010b; Li & Selig, 1996; Liu & Xiao, 2010; Miller et al., 2000; Potter & Cameron, 2005; Preteseille et al., 2013; Read et al., 1994; Selig & Sluz, 1978

11

Numerical modelling of track and DEM simulation

Ahmed et al., 2015; Alves Costa et al., 2010, 2012; Chen et al., 2012; Correia & Cunha, 2014; D'Aguiar et al., 2012; Ferelec & McDowell, 2012; Huang et al., 2009b, 2010; Huang & Tutumluer, 2011; Indraratna et al., 2012a, 2014a; Lu & McDowell, 2006, 2010; McDowell et al., 2006; Ngo et al., 2014, 2015; Quinn et al., 2010; Suiker & de Borst, 2003; Tutumluer et al., 2007, 2012

13

Specific design functions including transition zones

Coelho et al., 2011; Fernandes et al., 2012; Giner & López-Pita, 2009; Huang & Brennecke, 2013; Le Pen et al., 2014b; Li & Davis, 2005; Mishra et al., 2014a; Raymond, 1986; Varandas et al., 2014

15

Track assessment using Image analysis

Abadi et al., 2015; Ajayi et al., 2015; Fernlund, 2005; Le Pen et al., 2014a; Sun et al., 2014; Tutumluer et al., 2006, 2012

17

Selected Practice Guides and Technical Specifications for ballasted tracks

AREMA, 2003, 2015; British Standards Institution, 2003; Canadian National Railway, 2015; German Institute for Standardisation, 2008, 2013; Indian Railway Specification, 2004; International Union of Railways, 2008; IRPWM, 2004; Japanese Standards Association, 2014; Railtrack, 2000; Standards Australia, 2015

2

Load distribution in track, moving loads and dynamic track analysis

Choi, 2013; Correia et al., 2007a; Esveld, 2001; Ishikawa et al., 2011, 2014b; Kaewunruen & Remennikov, 2008; Momoya et al., 2005; Powrie et al., 2007; Remennikov & Kaewunruen, 2008; Yang et al., 2009

4

Theoretical aspects and constitutive modelling of ballast and sub-ballast

Cui et al., 2013; Desai & Janardhanam, 1983; Einav, 2007a, 2007b; Indraratna et al., 2011b, 2012b, 2014b, 2014f; Knothe & Grassie, 1993; Rowe, 1962; Suiker & de Borst, 2003; Tennakoon et al., 2015; Yang et al., 2008; Zhai et al., 2004, 2009

6

Use of geosynthetics including geogrids, geotextiles and geocells

Brown et al., 2007; Chen et al., 2014a; Dash & Shivadas, 2012; Fernandes et al., 2008; Indraratna & Nimbalkar, 2013; Indraratna et al., 2010a; 2013a; 2014e; 2015; Leshchinsky & Ling, 2013; McDowell & Stickley, 2006; Mishra et al., 2014b; Qian et al., 2015; Raymond, 1986, 2002; Tatsuoka et al., 1992, 1996, 2008; Tutumluer et al., 2012

8

Role of sub-ballast including capping layer and structural fills

Chrismer & Davis, 2000; Fatahi et al., 2011; Fortunato et al., 2012; Haque et al., 2008; Indraratna et al., 2015; Radampola et al., 2008; Trani & Indraratna, 2010

10

Ballast bonding (polyurethane) for improved track resiliency

Dersch et al., 2010; Jubin, 2012; Keene et al., 2012, 2014; Kennedy et al., 2013; Woodward et al., 2007, 2014

12

Field Instrumentation and performance verification

Alves Costa et al., 2012; Choi, 2013; Indraratna et al., 2010a, 2010b, 2014d; Kaewunruen & Remennikov, 2015; Le Pen et al., 2014b; Read et al., 1994; Sánchez et al., 2014; Schneider et al., 2011; Woodward et al., 2007

14

Aspects of track maintenance and scheduling

Ebrahimi & Keene, 2011; Ferreira & Higgins, 1998; Higgins et al., 1999; Kaewunruen et al., 2015; Marschnig & Veit, 2011; Peng et al., 2011; Quiroga & Schnieder, 2012; Thom, 2007; Woodward et al., 2007; Zhang et al., 2013

16

Energy geotechnics and carbon footprint for track engineering

Åkerman, 2011; Chang & Kendall, 2011; Federici et al., 2008; Kaewunruen et al., 2015; Kiani et al., 2008; Schwarz, 2008; UIC, 2013, 2015; Westin & Kågeson, 2012

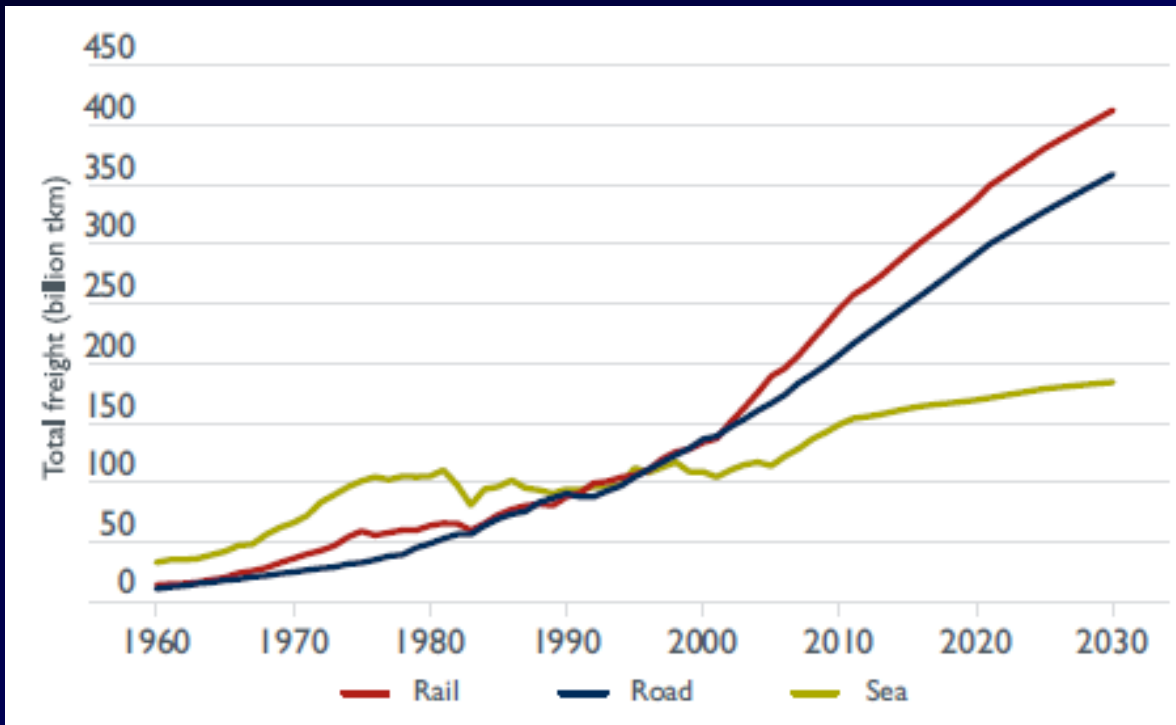
Ref: Table 1 - Indraratna (2016), 1st Proctor Lecture of ISSMGE, Transportation Geotechnics, Vol. 7: 74–114.

Presentation Outline

- Ground Problems and Railroad Challenges
- Track Capacity for Fast Heavy Haul Demands
- Fundamental and Applied Research
- Field Applications and Performance Verification
- Industry Impact and Design Innovation

Introduction

- Demand for **freight and passenger transport** has increased in the past decade.
- Large repetitive loads from traffic cause **rapid degradation and deformation** of tracks.
- Inclusion of **resilient materials** (geosynthetics & shock mats) helps to enhance track response.



Figures from “Road and rail freight: competitors or complements?” Bureau of Infrastructure, Transport and Regional Economics, Australian Government Canberra.

Problems in Rail Track Substructure



Ballast Crushing



Subgrade Clay Pumping



Coal fouling



Void Clogging



Differential settlement (Courtesy, Prof AK Suiker)



Poor Drainage

Track Buckling due to Insufficient Lateral (confining) pressure



Requirements for Heavy Haul Fast Tracks

1. Ballast: Reduced **Degradation** and **lateral Movement** for greater longevity.
2. Sub-ballast: Improved **filtration** and **drainage** under large cyclic loads.
3. Foundation soil (subgrade): Increased **shear strength** and reduced **settlement**.
4. Rail and Sleepers – Minimise **Impact Damage** at high speeds and axle loads

OUTCOME: New Standards, Design Innovation and Construction Alternatives.

Use of geosynthetics in track for improved resiliency, better drainage and reduced deformation.



Placing of synthetic energy absorbing mats (SEAM)



Geotextile



Bonded Geogrid



PVD



Large-scale Cyclic Triaxial Rigs Built at UoW



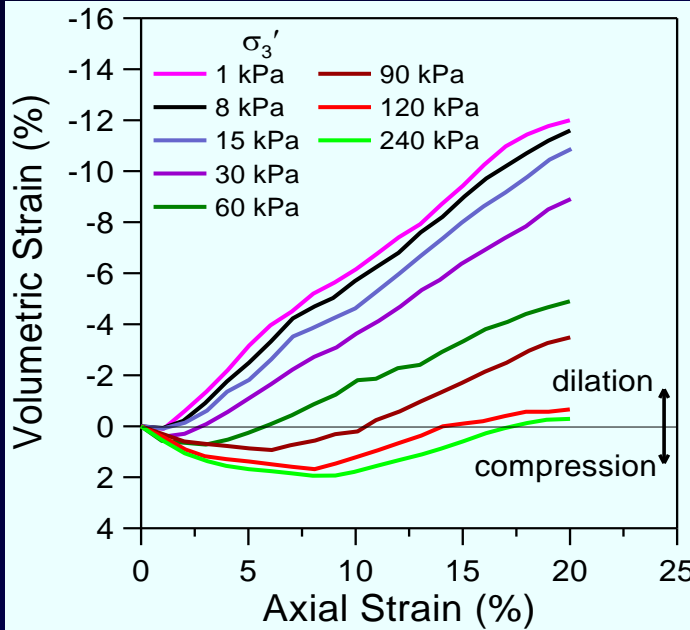
Prismoidal Triaxial Rig to Simulate a Track Section
(Specimen: 800x600x600 mm)

Cylindrical Triaxial Equipment
(Specimen: 300 mm dia.x600 mm high)

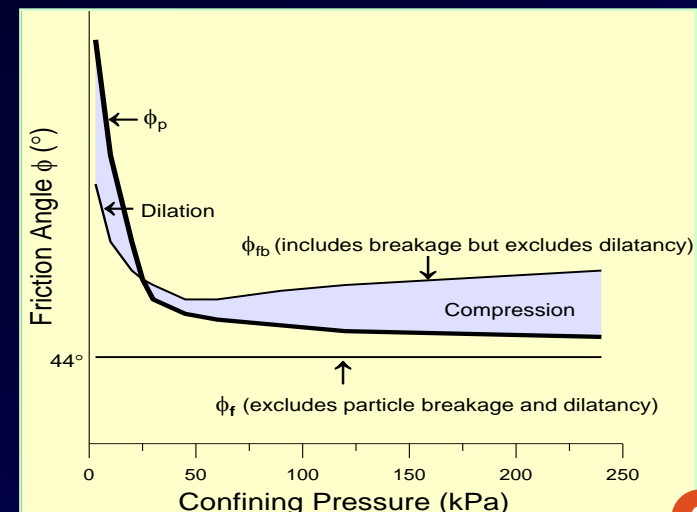
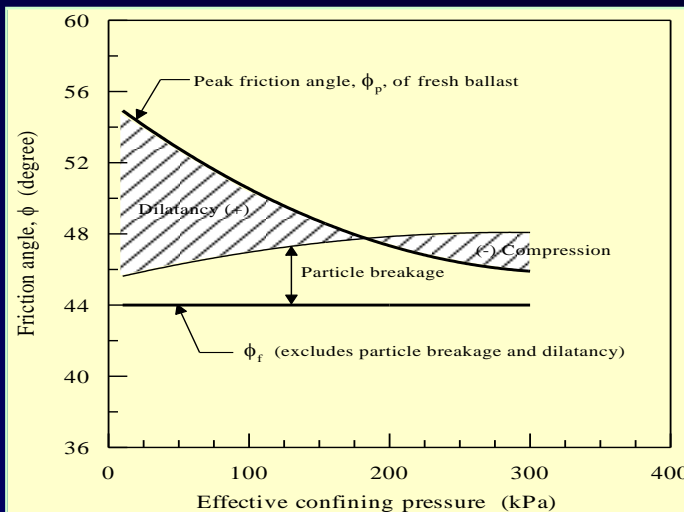
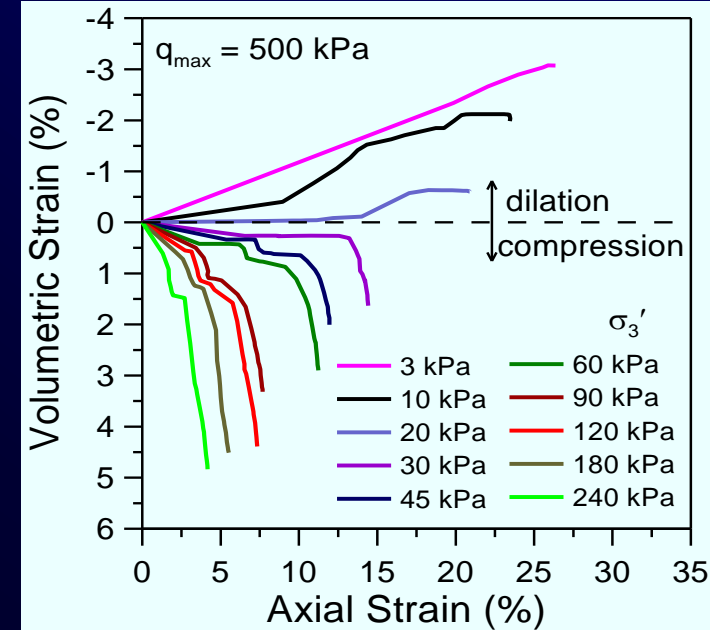
Effect of Confining Pressure on Strain Behaviour of Ballast

Indraratna, Lackenby and Christie (2005), Geotechnique

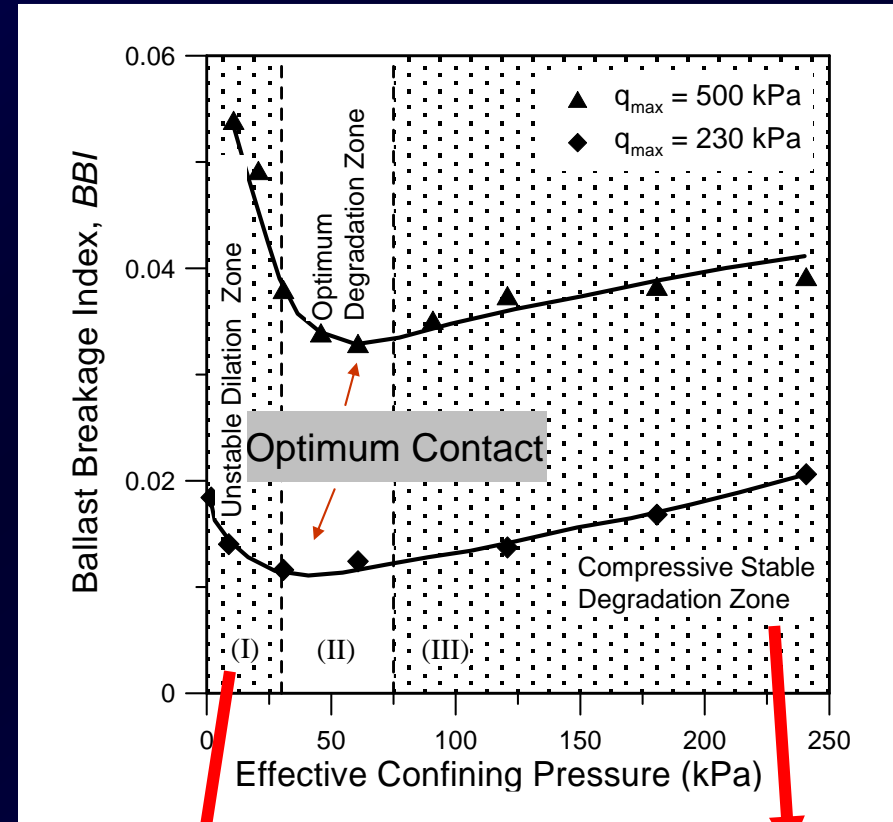
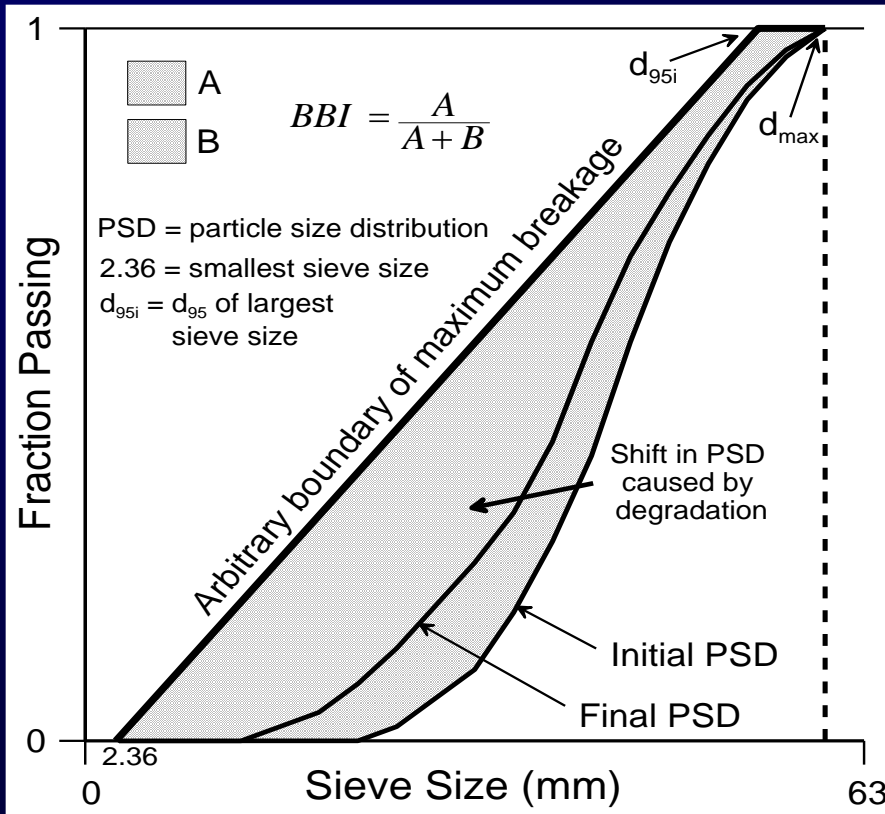
Monotonic Loading



Cyclic Loading



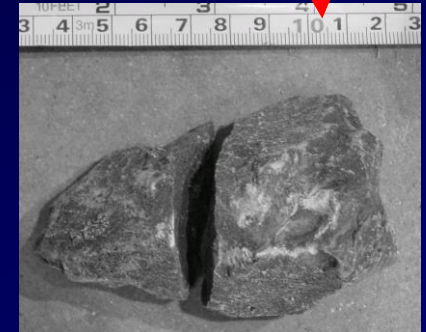
Effect of Confining Pressure on Particle Degradation (Cyclic Loading)



Ballast Breakage Index (BBI)

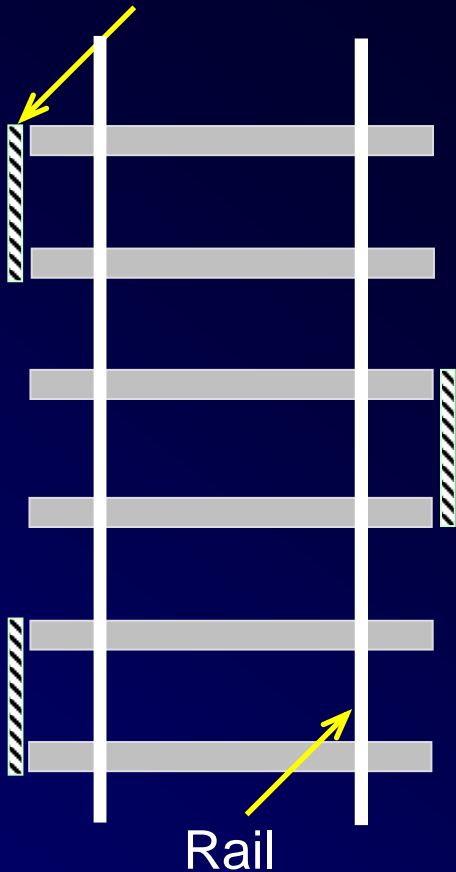
Indraratna, Lackenby and Christie (2005)

Vol. 55(4), Geotechnique, ICE, UK.



Increasing Confining Pressure using: Intermittent Lateral Restraints or Embedded Winged Sleepers

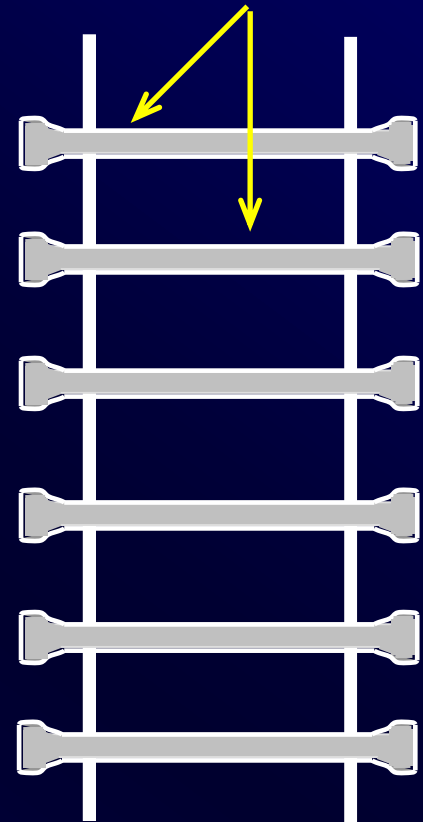
Intermittent lateral restraints



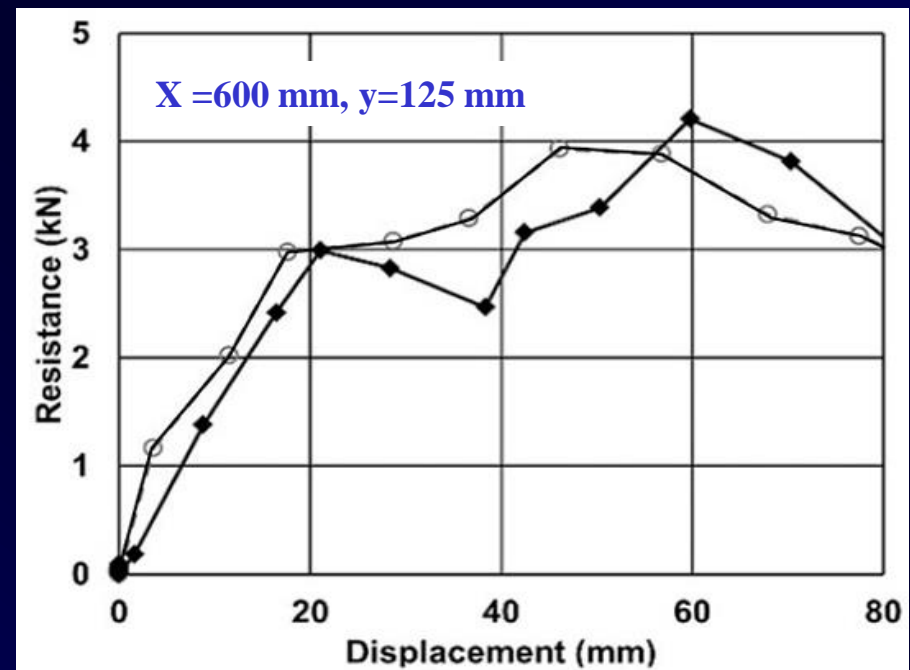
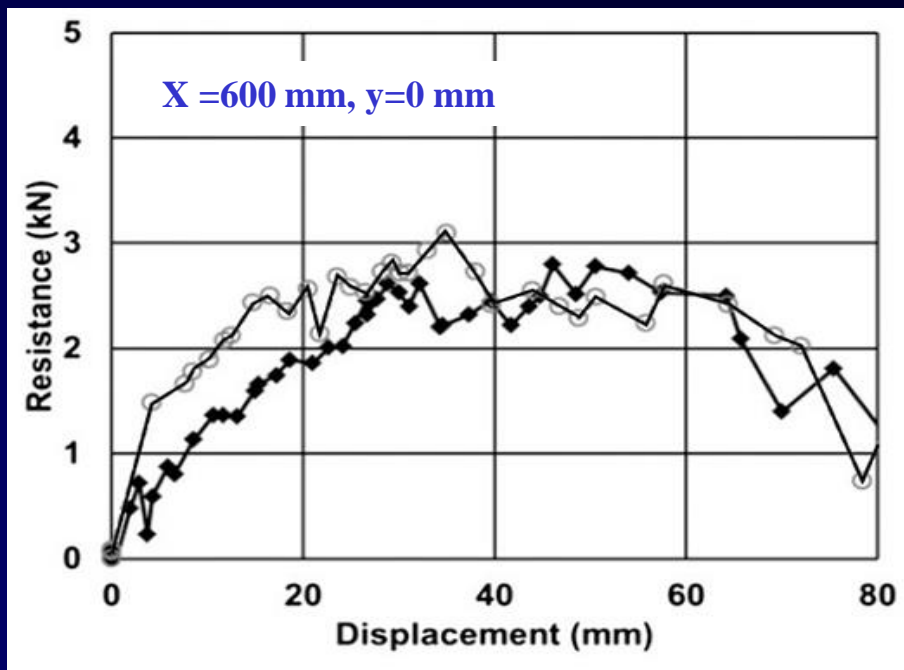
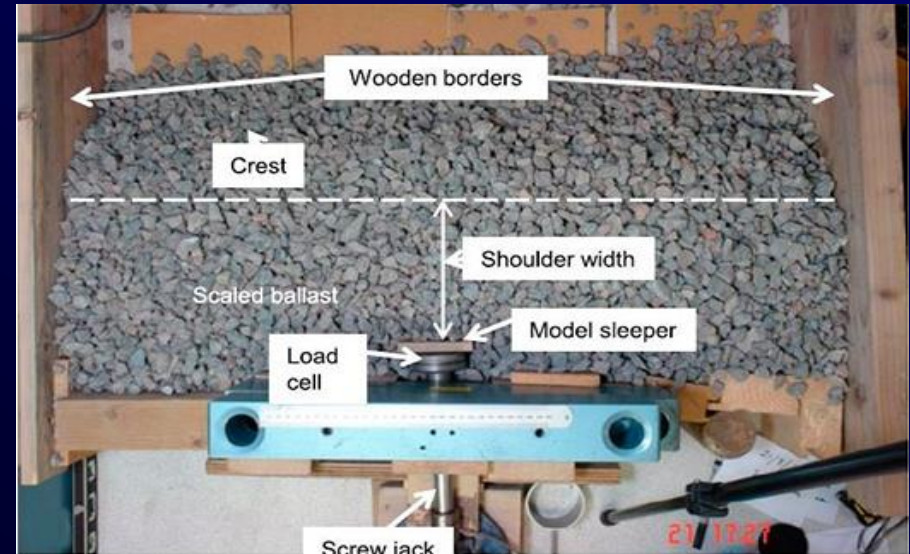
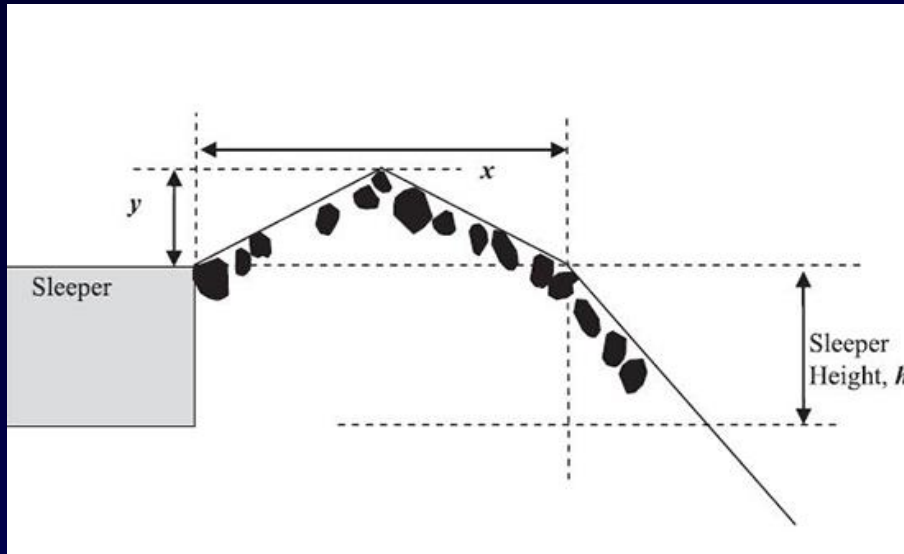
Lateral restraints



Winged sleepers



Lateral Resistance Offered by Shoulder Ballast



Le Pen, Bhandari, and Powrie (2014). JGGE, ASCE, 140(5).

Preventing Particle Breakage – Computational Modelling

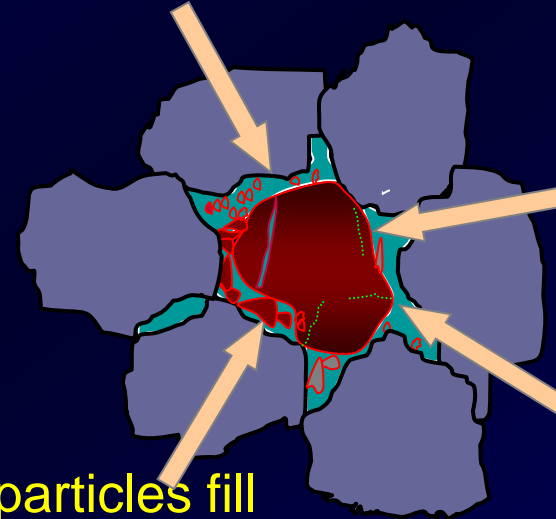
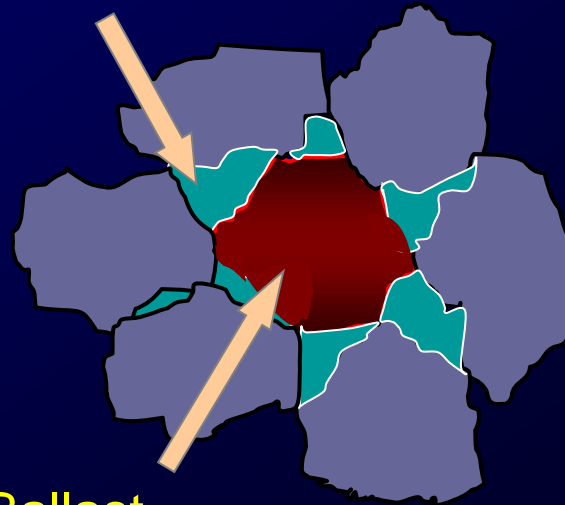
(Salim and Indraratna, 2000; Canadian Geotechnical Journal)

Before Loading

After Loading

Voids

Asperity wear



New hairline micro-cracks

Sharp corners broken off

Ballast

Broken particles fill voids (fouling)

$$d\varepsilon_s^p = \frac{2\alpha\kappa \left(\frac{p}{p_{cs}} \right) \left(1 - \frac{p_{o(i)}}{p_{cs(i)}} \right) (9 + 3M - 2\eta^* M) \eta d\eta}{M^2 (1 + e_i) \left(\frac{2p_o}{p} - 1 \right) \left[9(M - \eta^*) + \frac{B}{p} \{ \chi + \mu(M - \eta^*) \} \right]}$$

$$\frac{d\varepsilon_v^p}{d\varepsilon_s^p} = \frac{9(M - \eta)}{9 + 3M - 2\eta^* M} + \left(\frac{B}{p} \right) \left[\frac{\chi + \mu(M - \eta^*)}{9 + 3M - 2\eta^* M} \right]$$

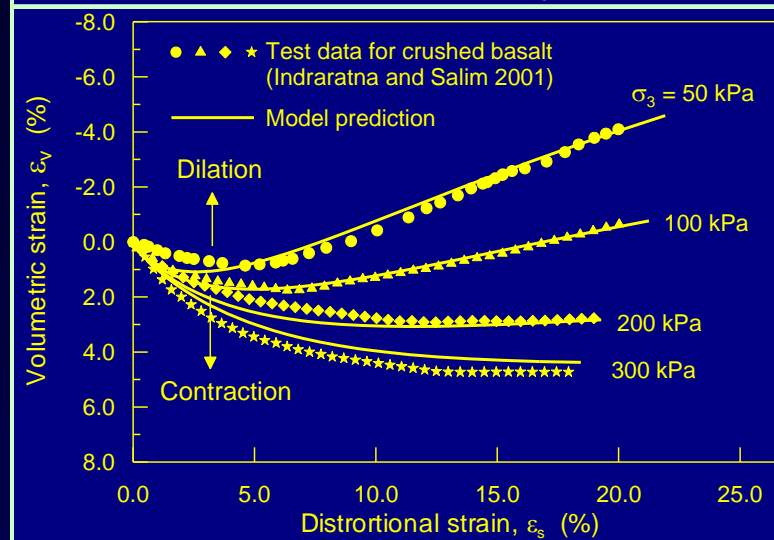
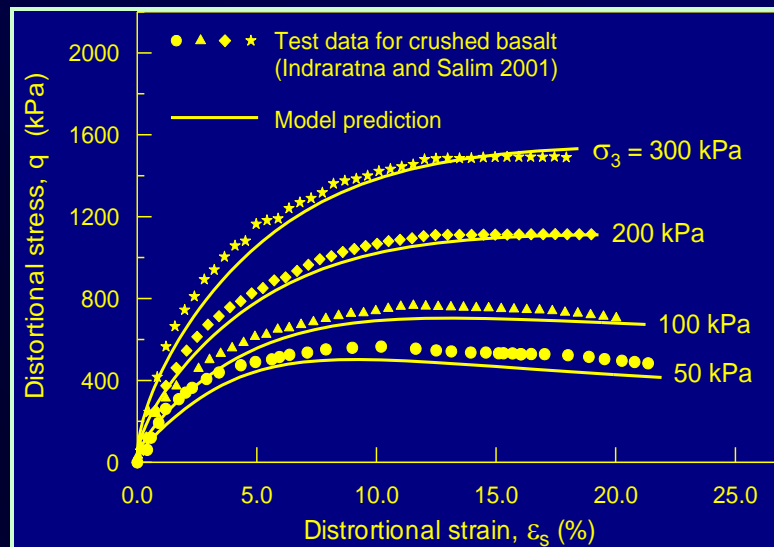
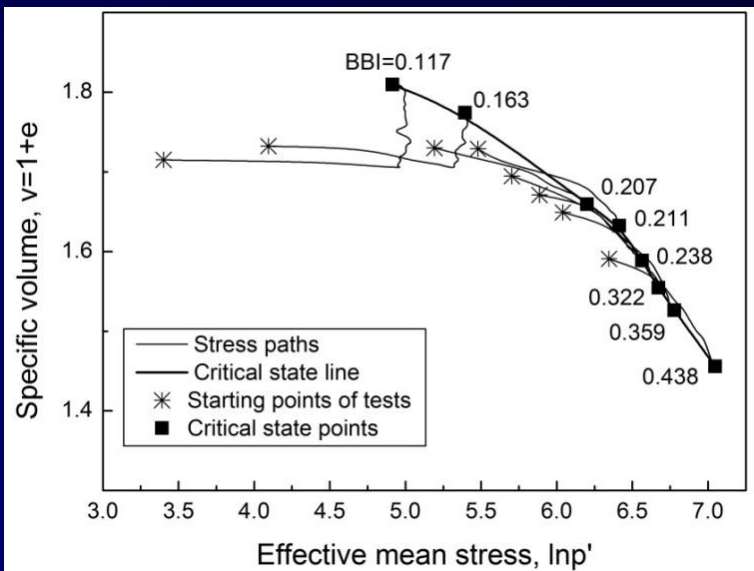
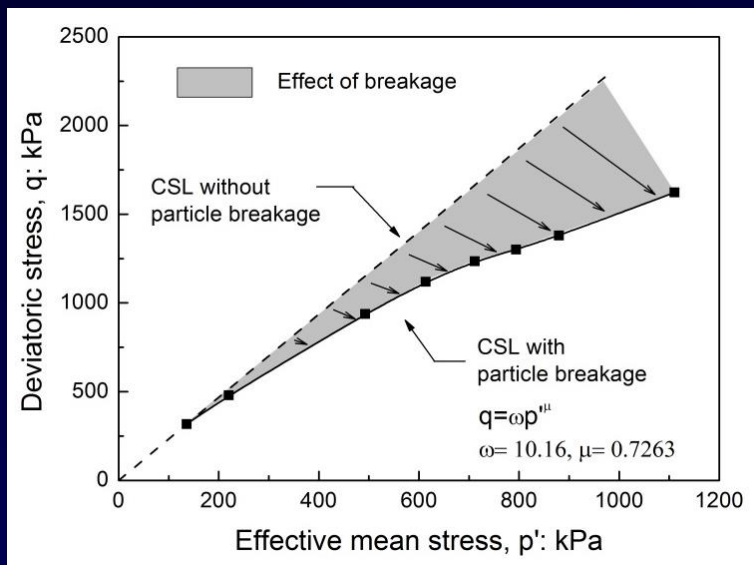


Constitutive model: Critical State capturing particle breakage

Indraratna, Sun & Nimbalkar (2014), Canadian Geotechnical Journal, Vol. 52(1), 73-86

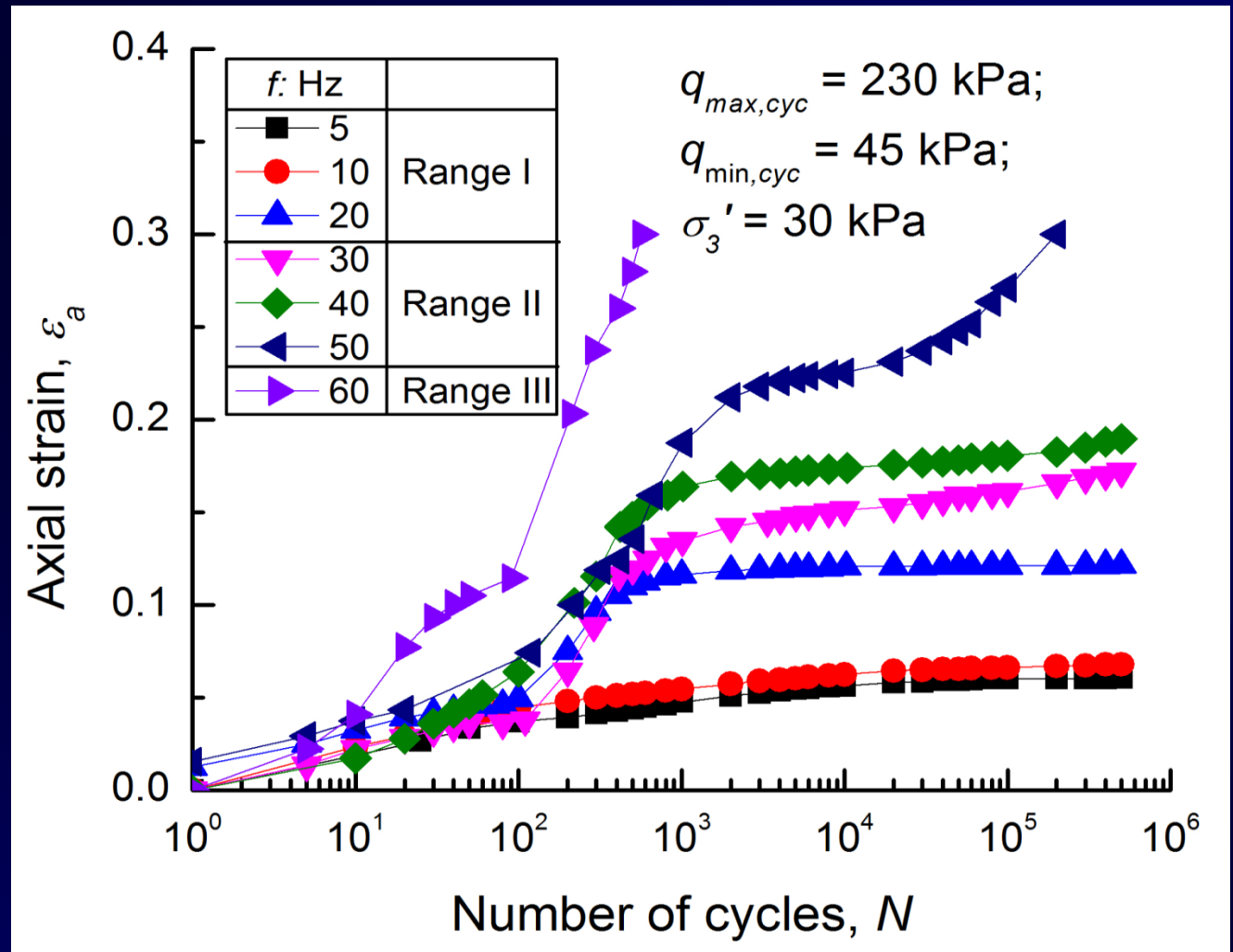
$$M_c = M_{c0} - [1 - \exp(-\alpha \cdot BBI)]$$

M_{c0} is critical state stress ratio for $BBI = 0$



Effect of frequency on the axial strain of ballast

Sun, Q., Indraratna, B. & Nimbalkar, S. (2014). Géotechnique, Vol. 64(9), 746-751.



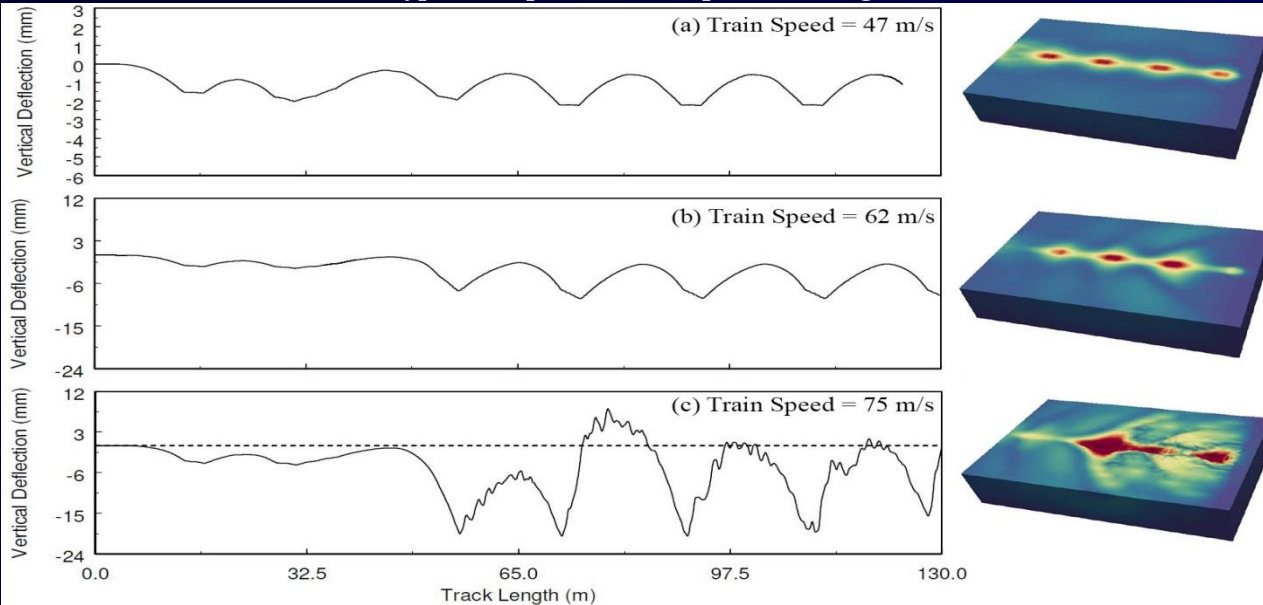
Range I: Plastic shakedown ($5\text{Hz} \leq f \leq 20 \text{ Hz}$)

Range II: Plastic shakedown followed by Ratcheting ($30 \text{ Hz} \leq f \leq 50 \text{ Hz}$)

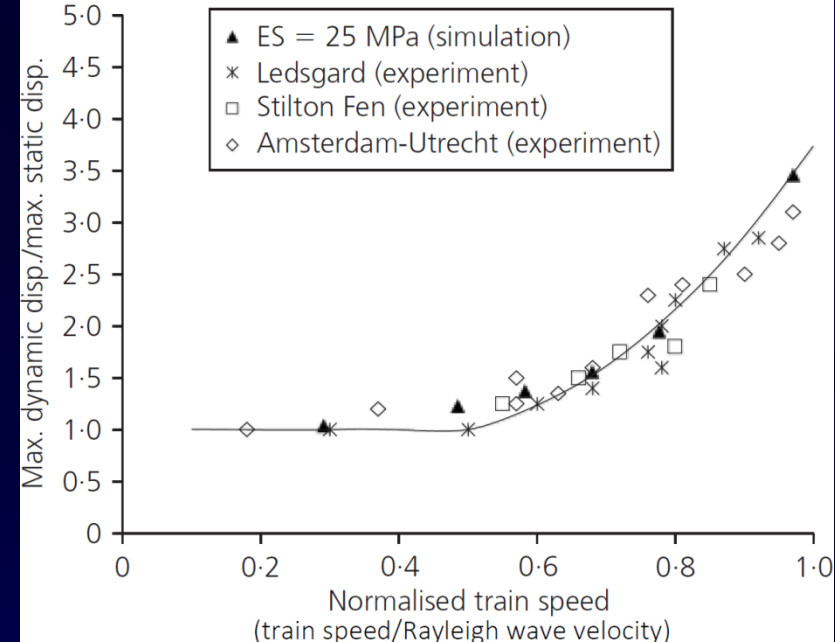
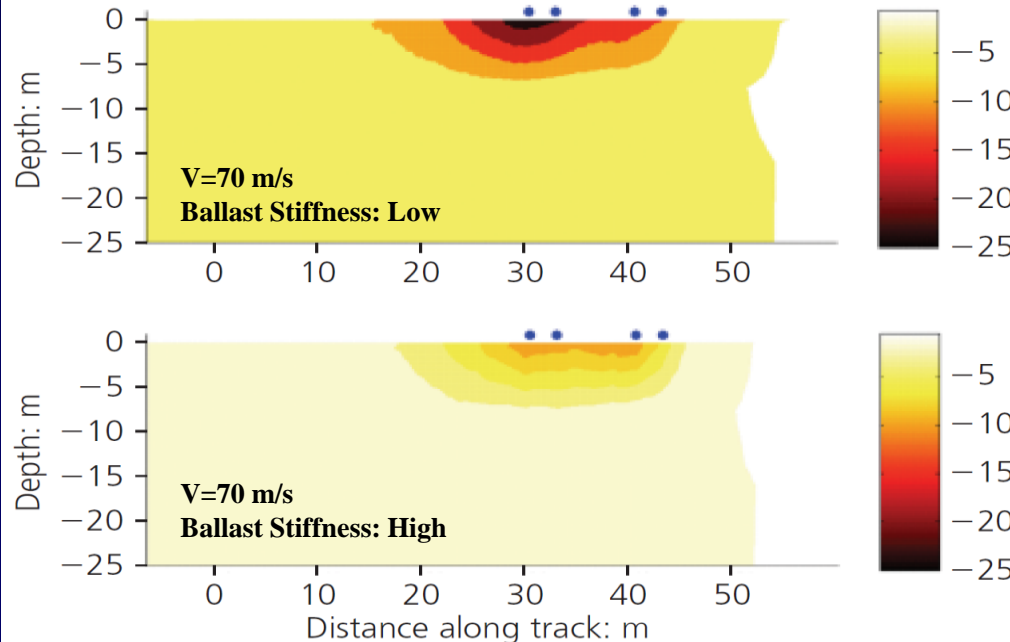
Range III: Plastic collapse ($f = 60 \text{ Hz}$)

Dynamic Track Analysis and Substructure Response

Transient vertical deflection of typical sleeper and development of the ground Mach Cone



Woodward, Laghrouche, and El-Kacimi (2013). *11th International Conference on Vibration Problems*, Lisbon, Portugal.



Impact loading that leads to track damage

Different wheel and rail irregularities contribute to Impact loading

Worn wheel surface



Worn rail surface



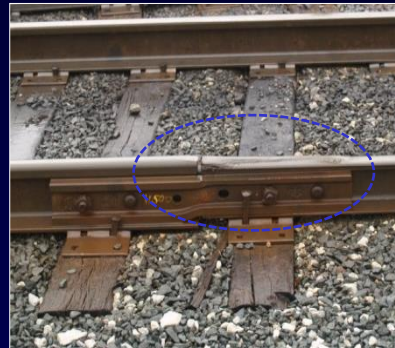
Wheel flats



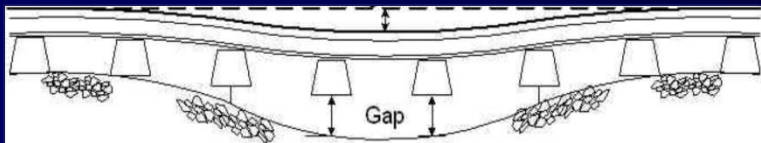
Rail corrugation



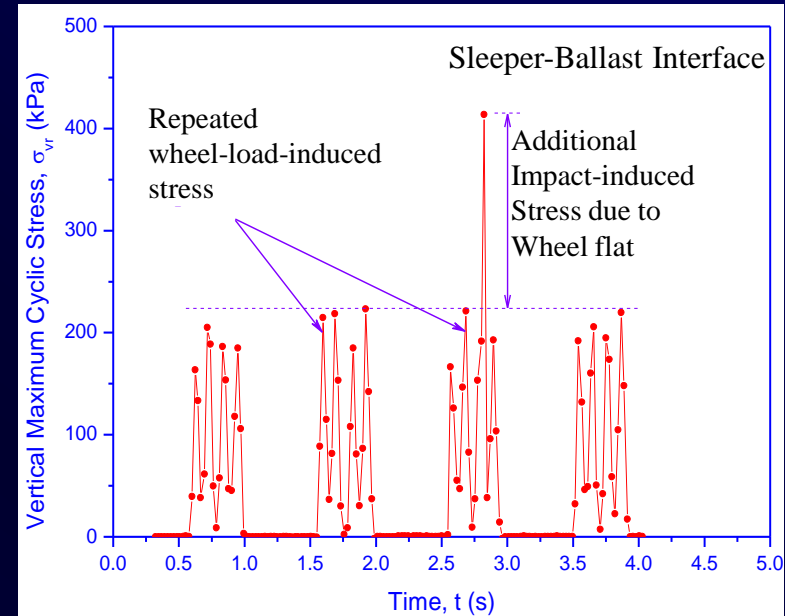
Bad welds, joints and switches



Unsupported sleepers



Field Measurements



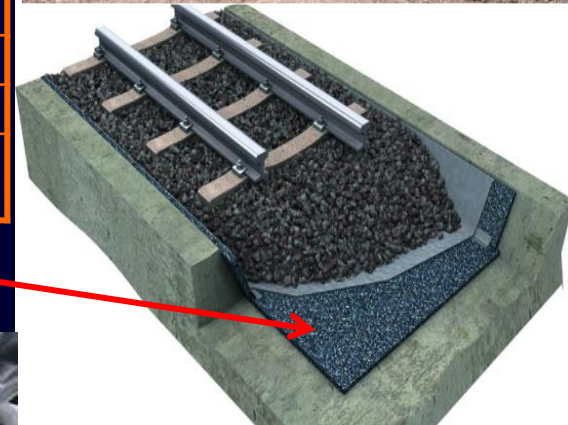
Cyclic stresses transmitted to the ballast by coal train with 100 ton wagons having wheel irregularities

Indraratna et al. (2010). JGGE, ASCE

Use of Energy Absorbing Rubber Mats to Prevent Impact Damage



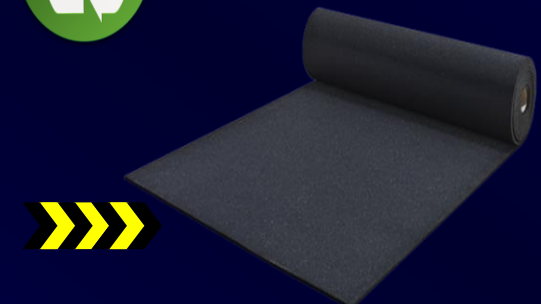
Subgrade type	Location of shock mat	Ballast Breakage Index (BBI)
Without shock mat		
Stiff	-	0.170
Soft	-	0.080
With Shock mat		
Stiff	Above ballast	0.145
Stiff	Below ballast	0.129
Stiff	Above & below ballast	0.091
Soft	Above ballast	0.055
Soft	Below ballast	0.056
Soft	Above & below ballast	0.028



Shock Mat

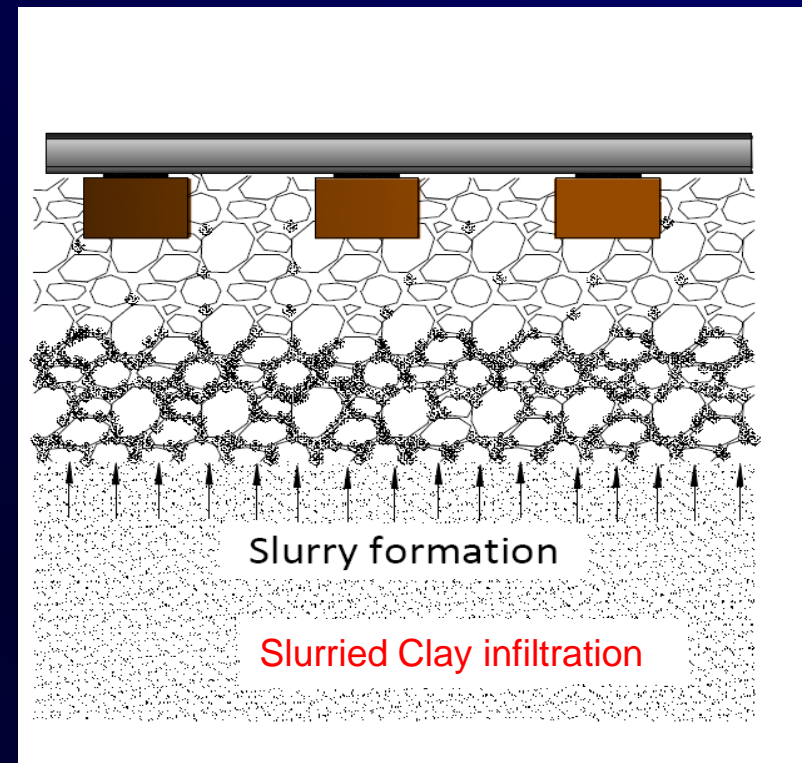
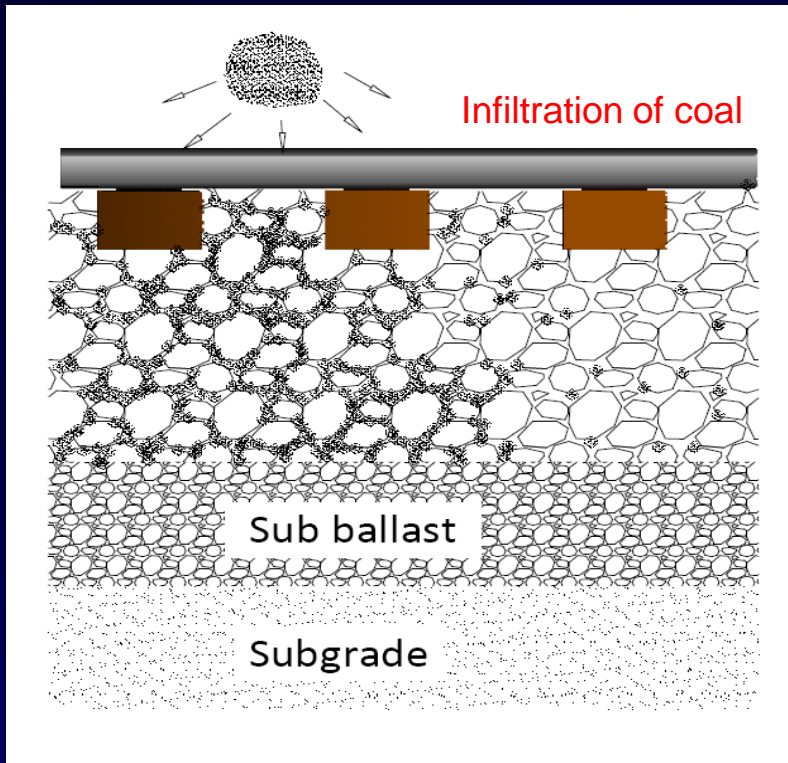


WASTE TURNS INTO VALUE



Nimbalkar, Indraratna, Dash & Christie (2012). JGGE, ASCE, 138(3): 281-294.

Role of Ballast Fouling on Track Performance



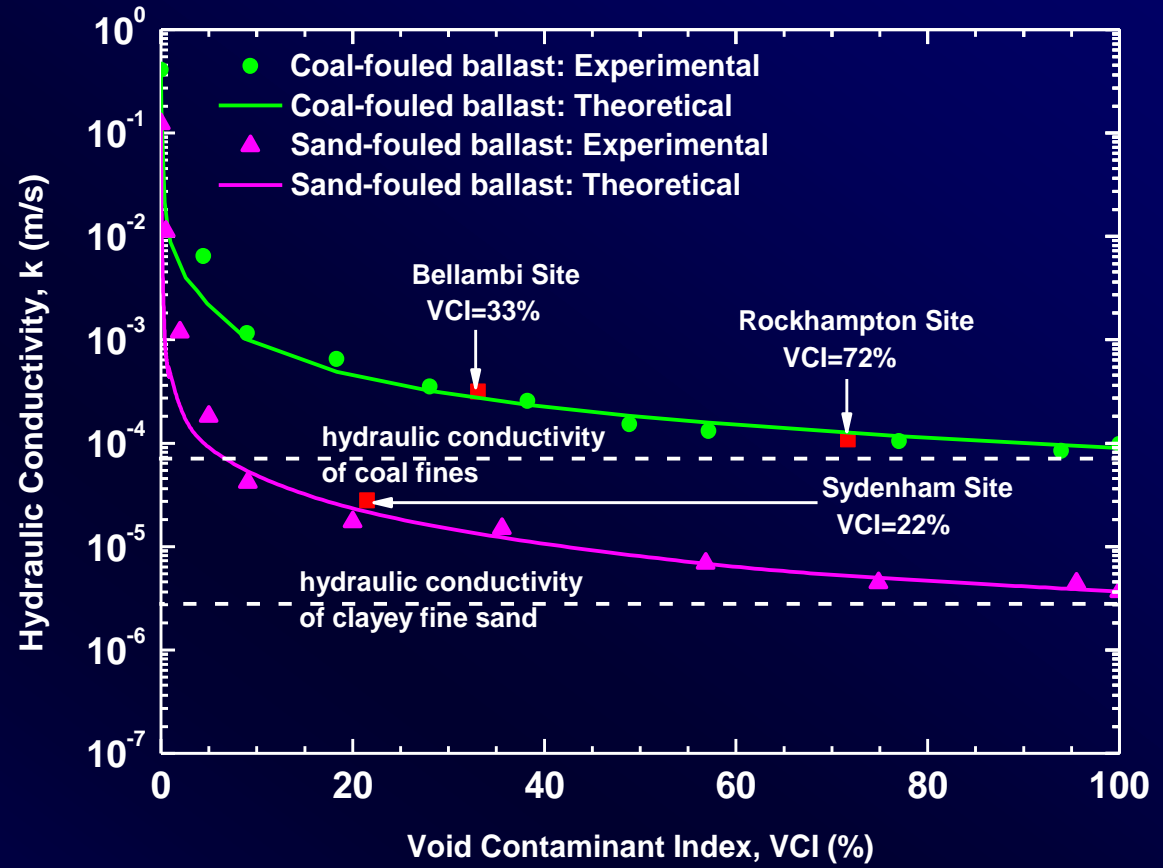
Void Contaminant Index (VCI) proposed by UOW

$$VCI = \frac{(1+e_f)}{e_b} \times \frac{G_{s,b}}{G_{s,f}} \times \frac{M_f}{M_b} \times 100$$

- e_b = Void ratio of clean ballast
- e_f = Void ratio of fouling material
- $G_{s,b}$ = Specific gravity of clean ballast
- $G_{s,f}$ = Specific gravity of fouling material
- M_b = Dry mass of clean ballast
- M_f = Dry mass of fouling material

Tennakoon, Indraratna, Cholachat, Nimbalkar and Neville
(2012) ASTM Geotechnical Testing Journal, 35(4): 1-12

Impeded Track Drainage due to Ballast Contamination



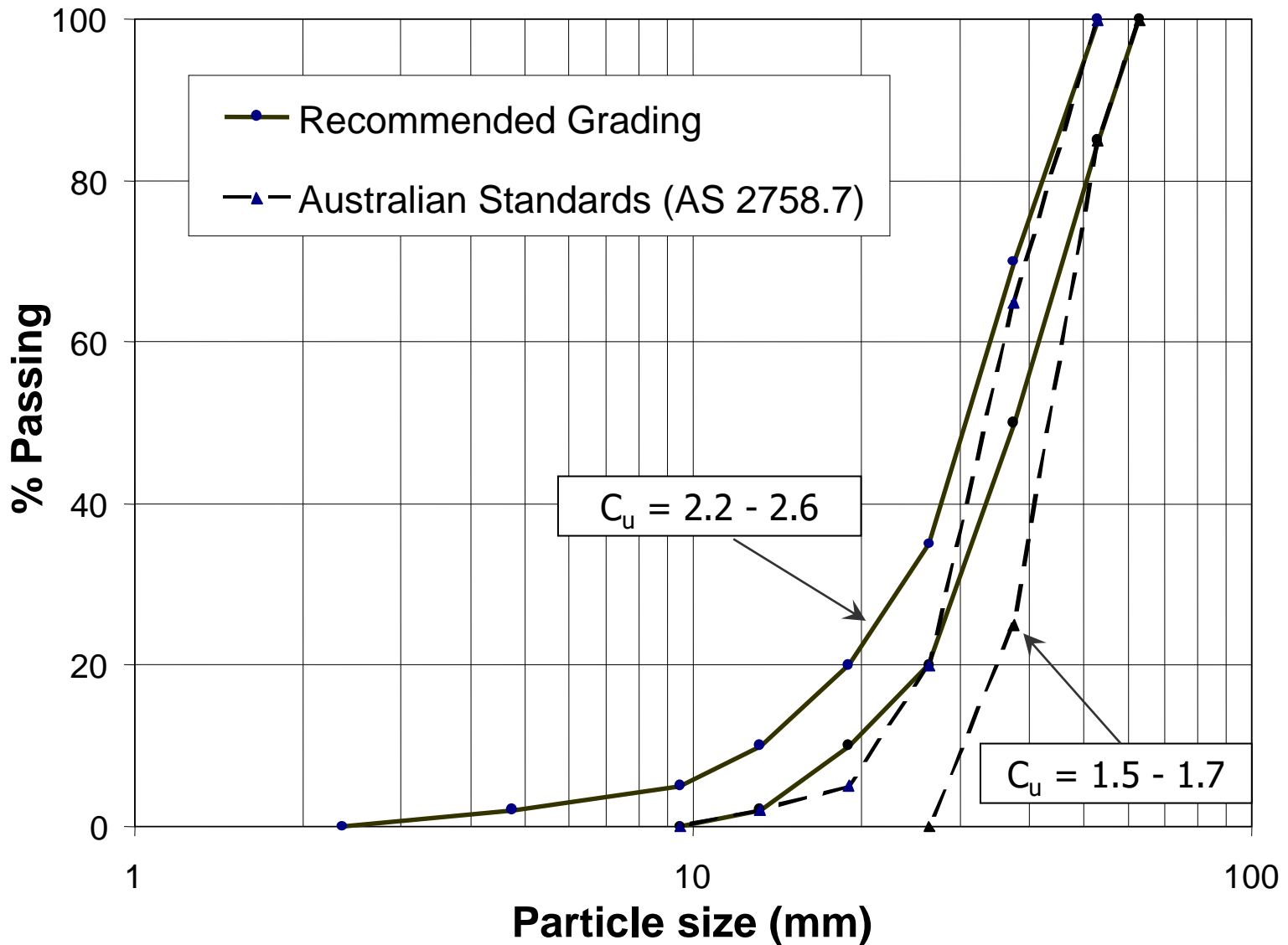
Large-scale permeability test apparatus
Hydraulic Conductivity (k) of fouled ballast

Variation of hydraulic conductivity vs. Void Contaminant Index

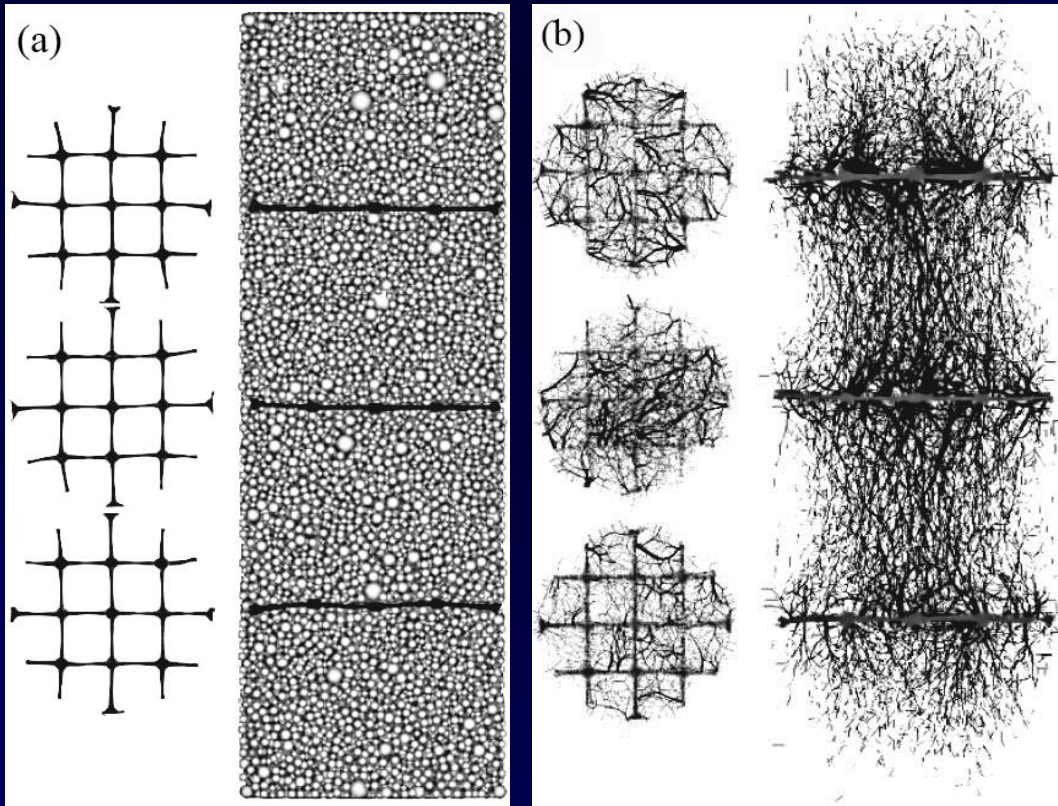
$$k = \frac{k_b \times k_f}{k_f + \frac{VCI}{100} \times (k_b - k_f)}$$

k_b = Hydraulic conductivity of clean ballast
 k_f = Hydraulic conductivity of fouling material

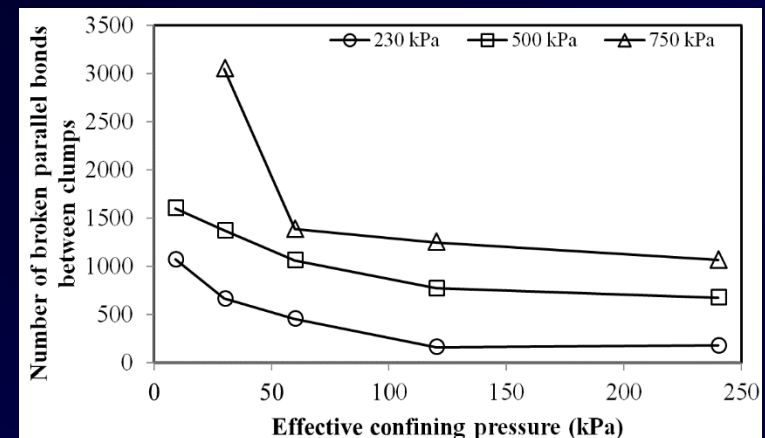
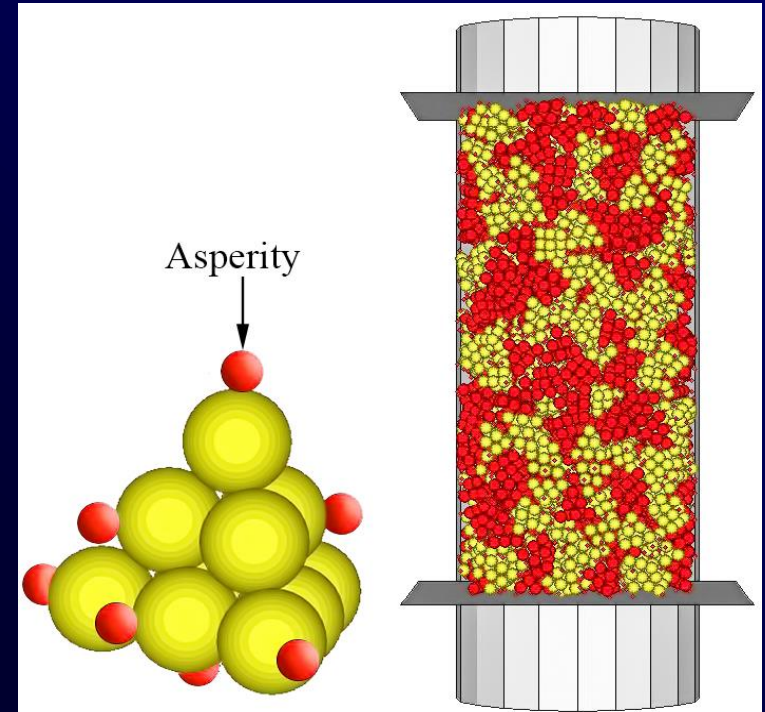
Recommended New Railway Ballast Grading



DEM Modelling of Railway Ballast under Monotonic and Cyclic Triaxial Loading

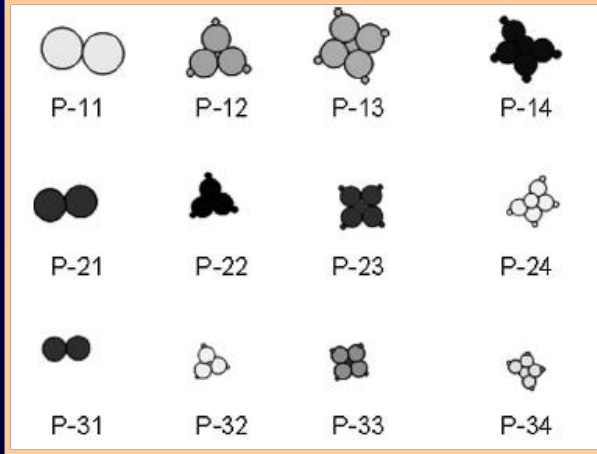
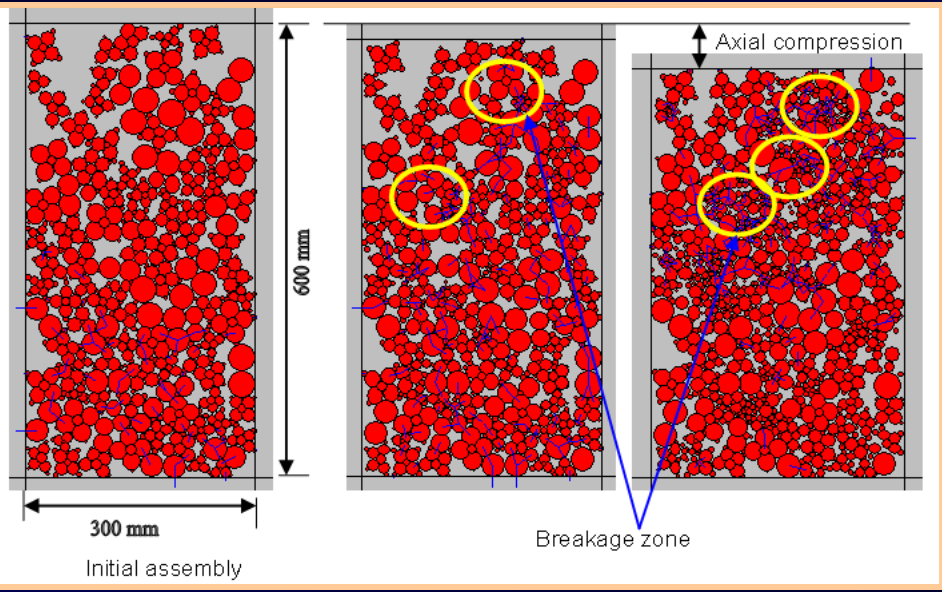


McDowell, Harireche, Konietzky, Brown, and Thom (2006), Proc. ICE-Geotechnical Engineering, 159(1): 35-48.

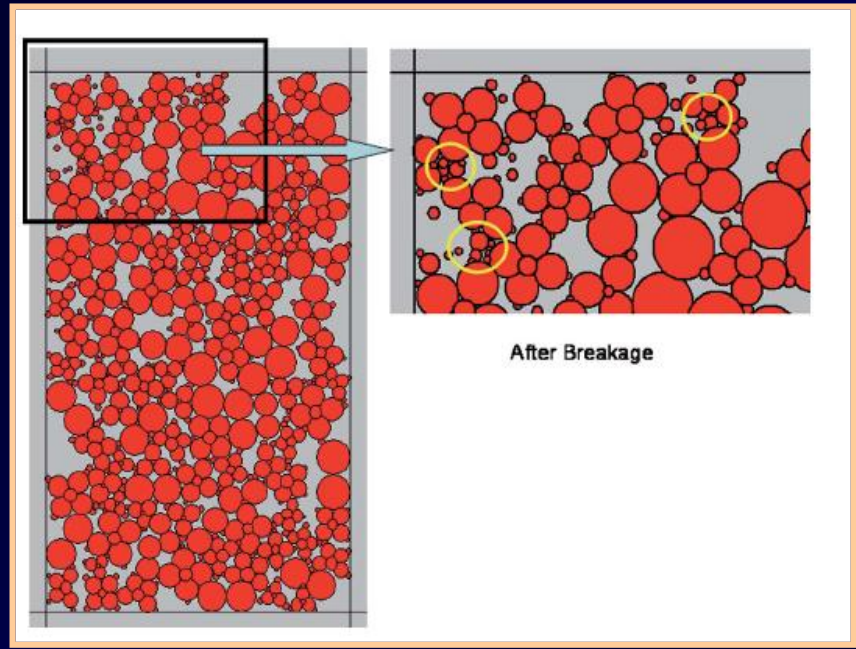
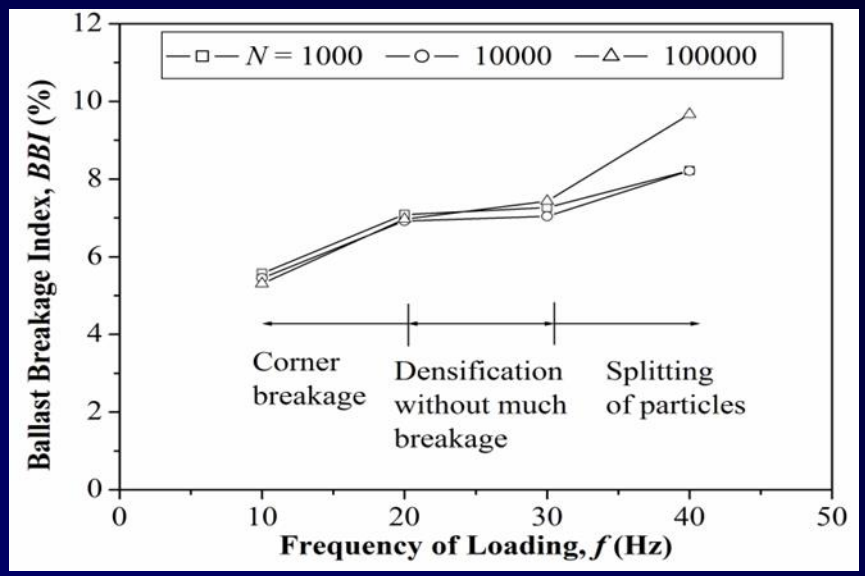


Lu & McDowell (2010), Géotechnique, 60(6): 459-467.

Practical Implications: Train Speed vs Particle Breakage

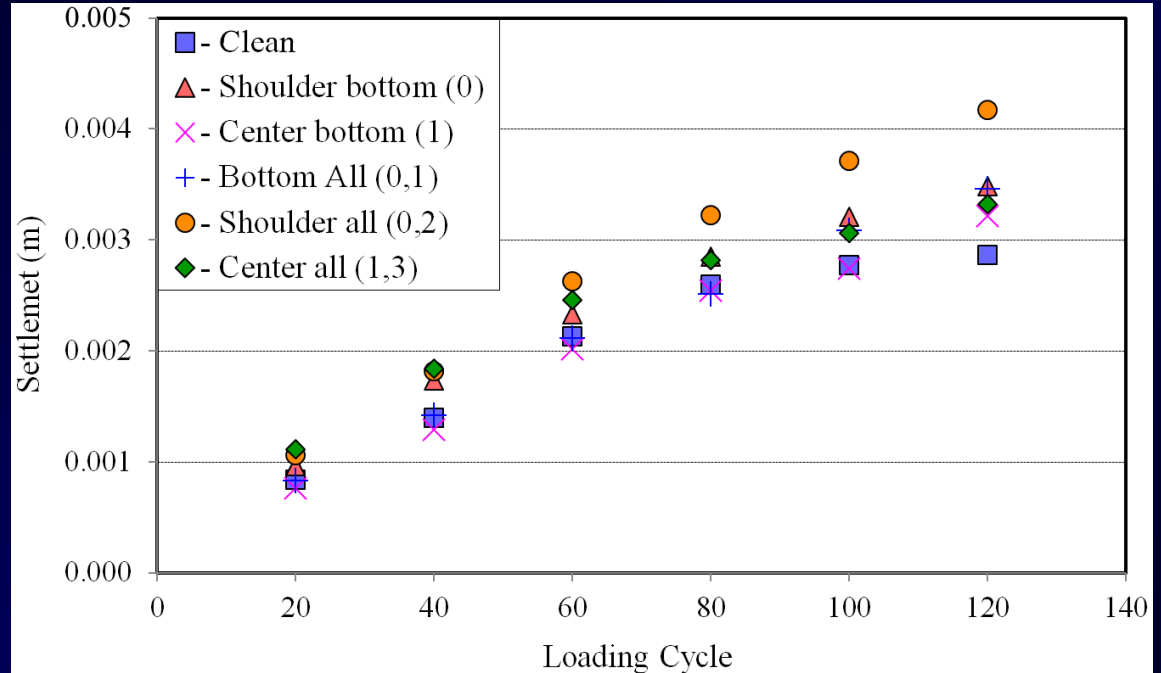
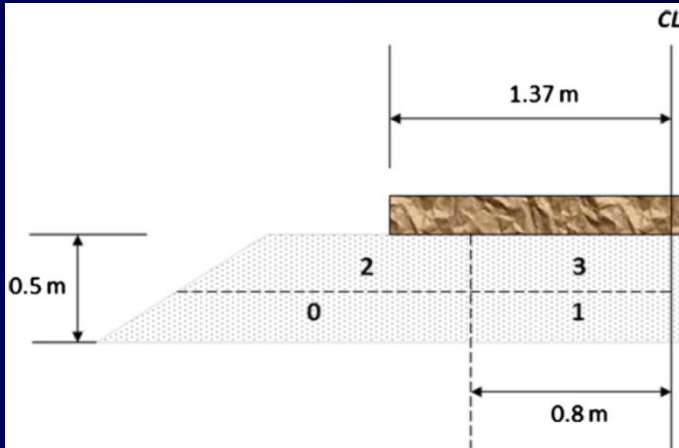
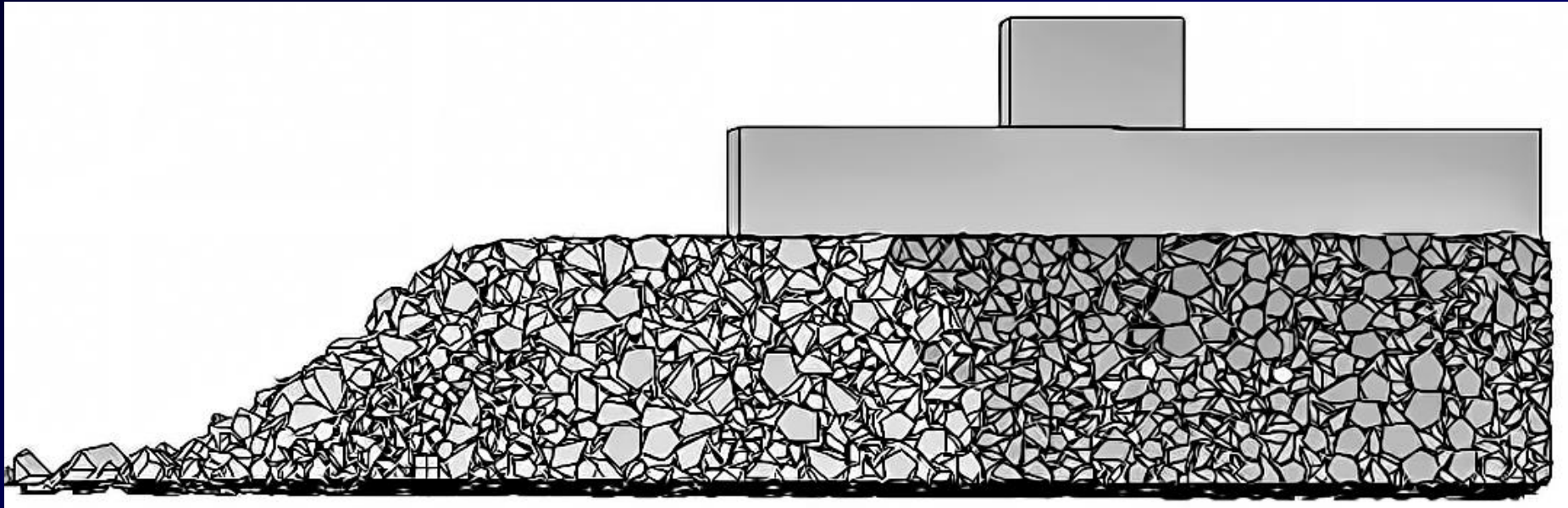


Model particle shapes and sizes



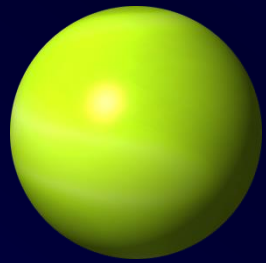
Particle Breakage near the top plate

DEM Model with Different Parts of Track Fouled by Coal Dust

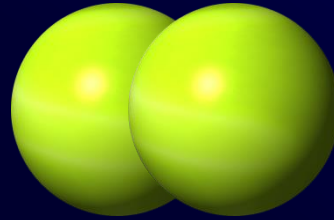


Huang and Tutumluer (2011),
Construction and Building Materials,
 25(8): 3306-3312.

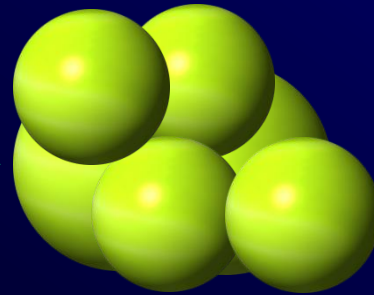
Modelling particle angularity in DEM



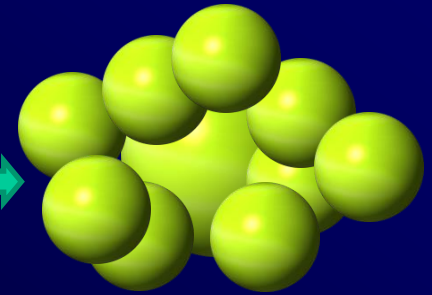
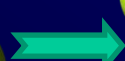
Spherical particle



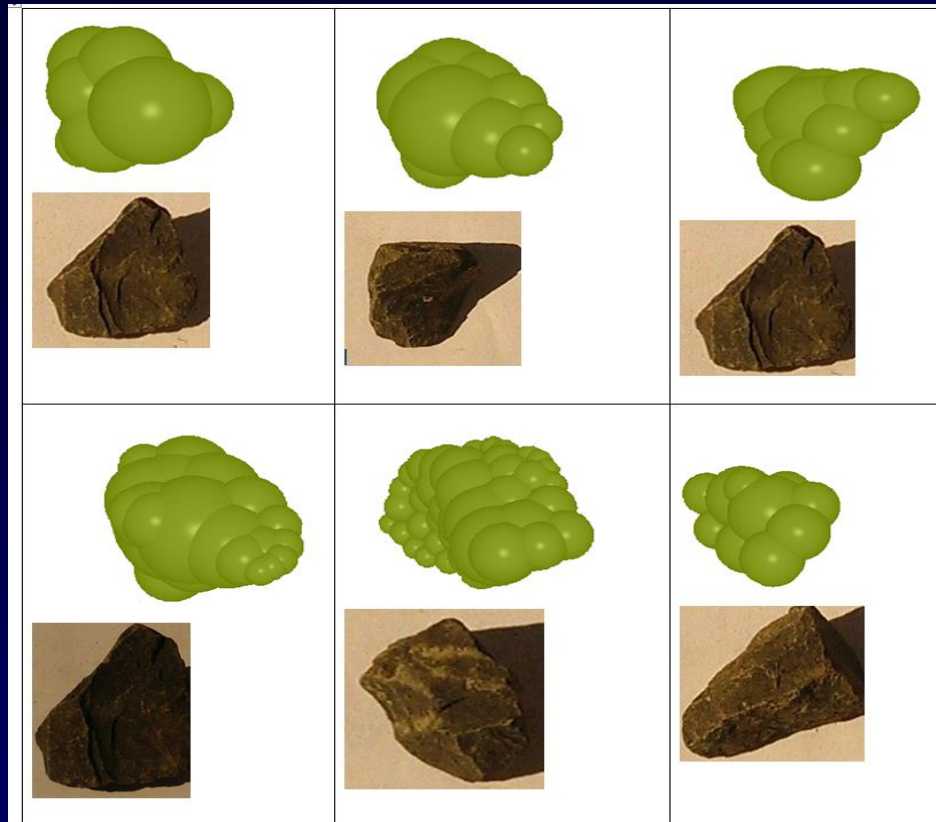
2-particle clump



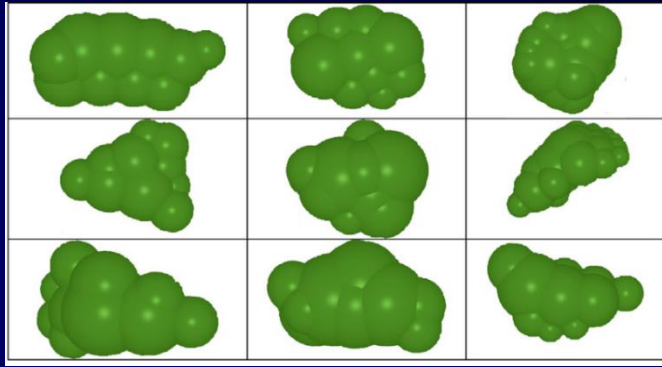
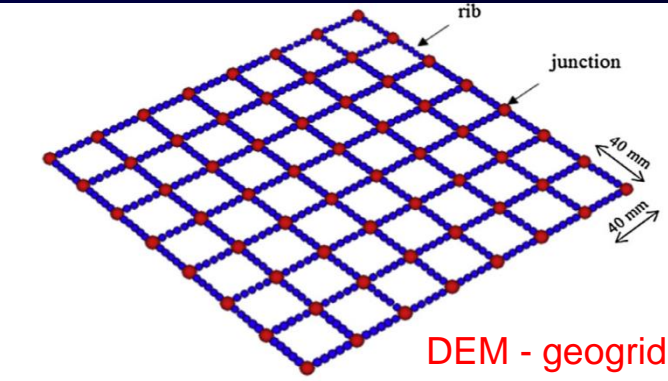
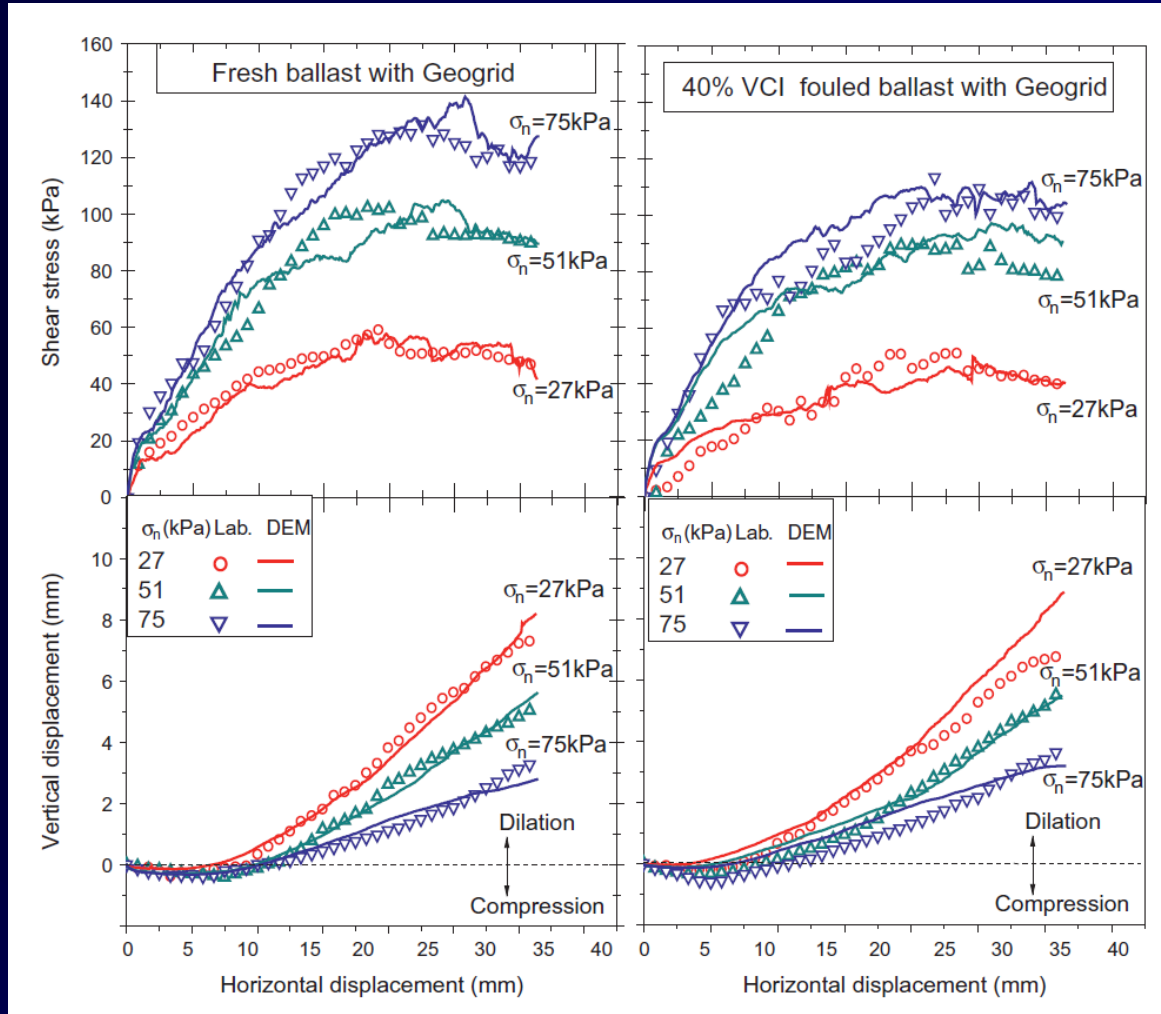
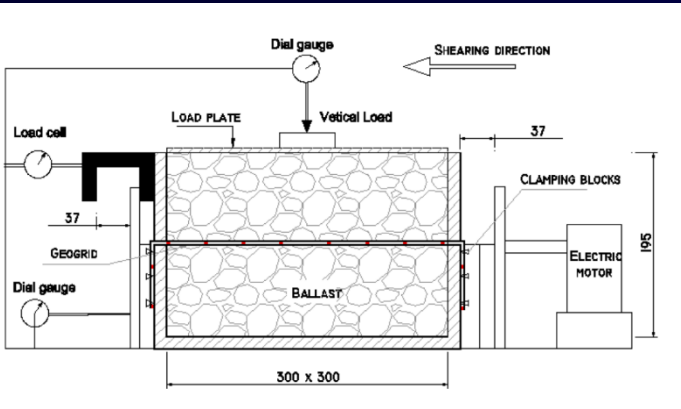
5-particle clump



10-particle clump



DEM Modelling Geogrid-reinforced Ballast under Shearing Loads



DEM particle shapes and sizes

Comparison of shear stress and displacements for DEM simulation of reinforced ballast

DEM Model for Geogrid-reinforced Ballast under Direct Shearing

PFC3D 4.00

Settings: ModelPerspective
Step 16300 14:02:03 Fri Sep 09 2011

Center: Rotation
X: 2.045e-001 X: 25.000
Y: 1.145e-001 Y: 0.000
Z: 5.330e-002 Z: 120.000
Dist: 2.059e+000 Mag.: 1
 Ang.: 22.500

Group

- layer5
- layer2
- layer1
- layer4
- layer7
- layer6
- layer3
- rp1-00076

Axes

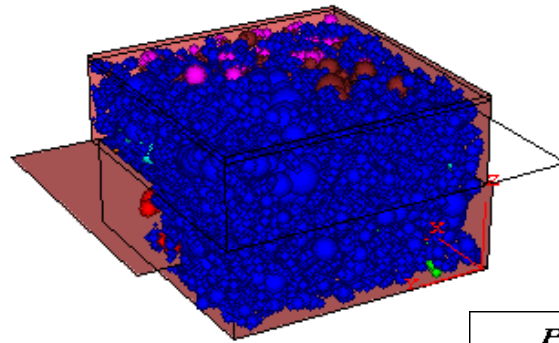
LineStyle

Wall

Cluster

Ball

View Title: Direct Shear Testing of Fresh Ballast



PFC3D 4.00

Step 16300 12:02:35 Fri Sep 09 2011

Table

51 UnNamed
LineStyle
0.000e+000 <-> 1.029e+005

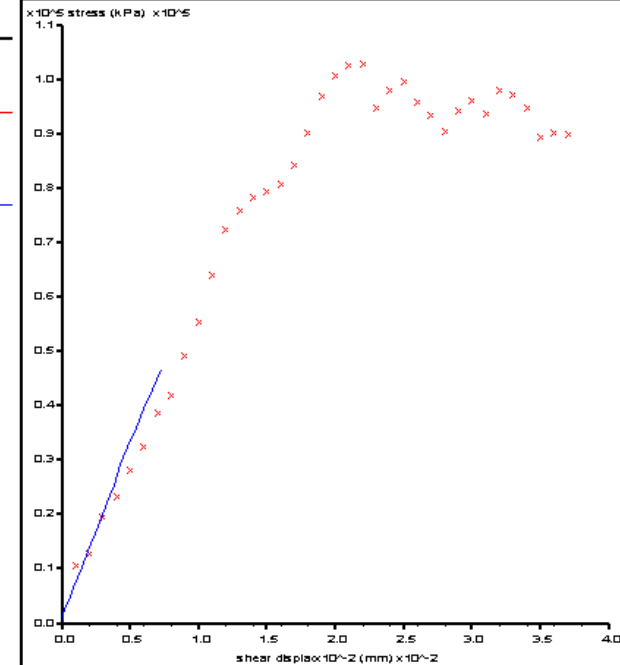
History

1 shearstress (FISH Symbol)
LineStyle
6.489e+002 <-> 4.675e+004

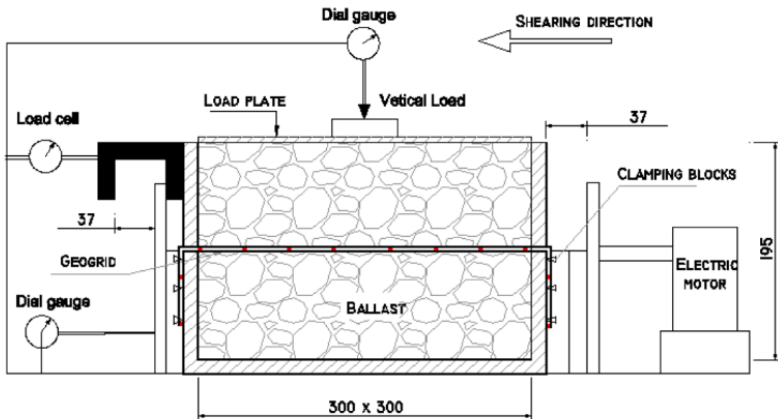
Vs.

2 ydisp2 (FISH Symbol)
1.678e-005 <-> 7.294e-003

View Title: shear stress vs shear displacement

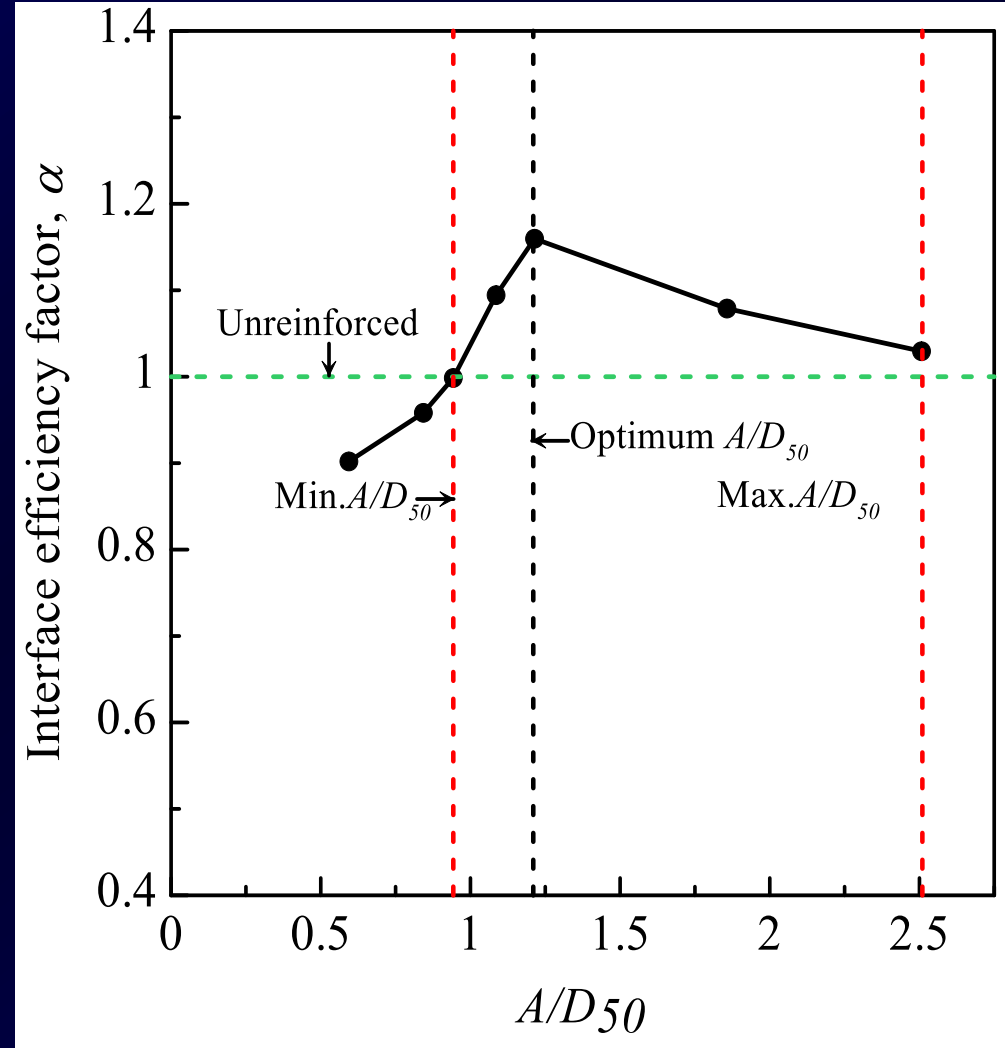


Geogrids for preventing particle movement and breakage



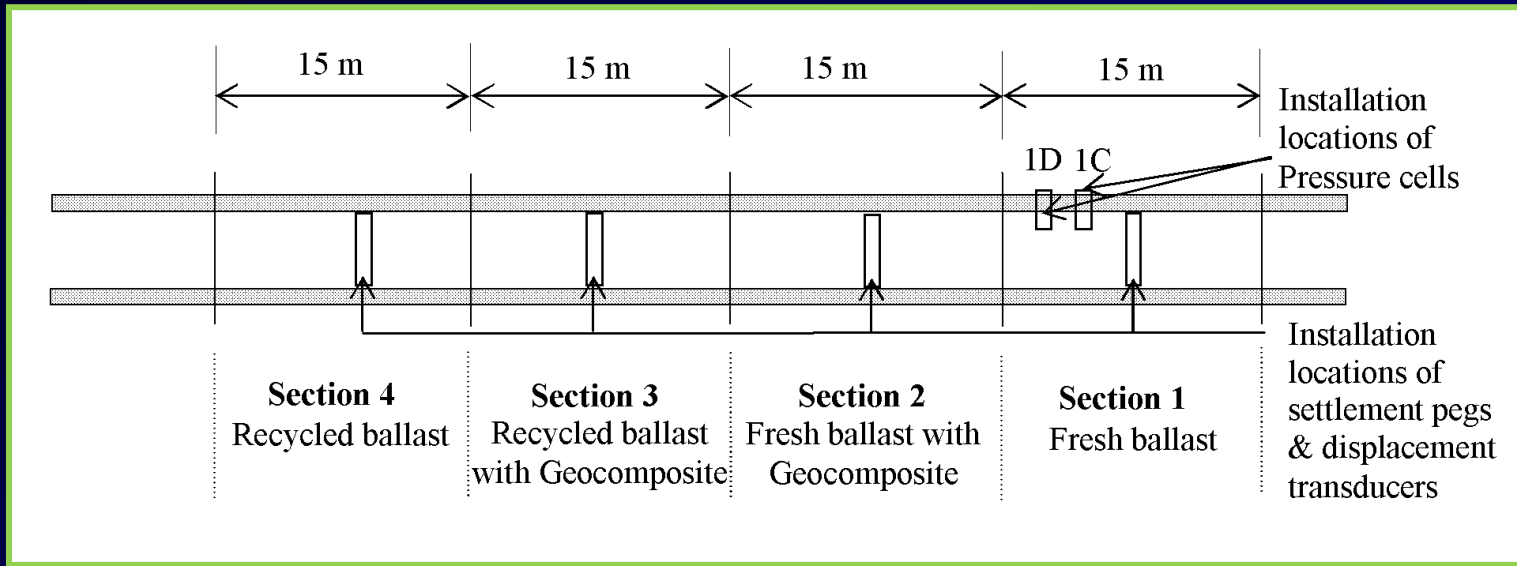
Geogrids Used for Testing

Geogrid type	Aperture shape	Aperture size (mm)	T_{ult} (kN/m)
G1	Square	38 × 38	30
G2	Triangle	36	19
G3	Square	65 × 65	30
G4	Rectangle	44 × 42	30
G5	Rectangle	36 × 24	30
G6	Square	33 × 33	40
G7	Rectangle	70 × 110	20

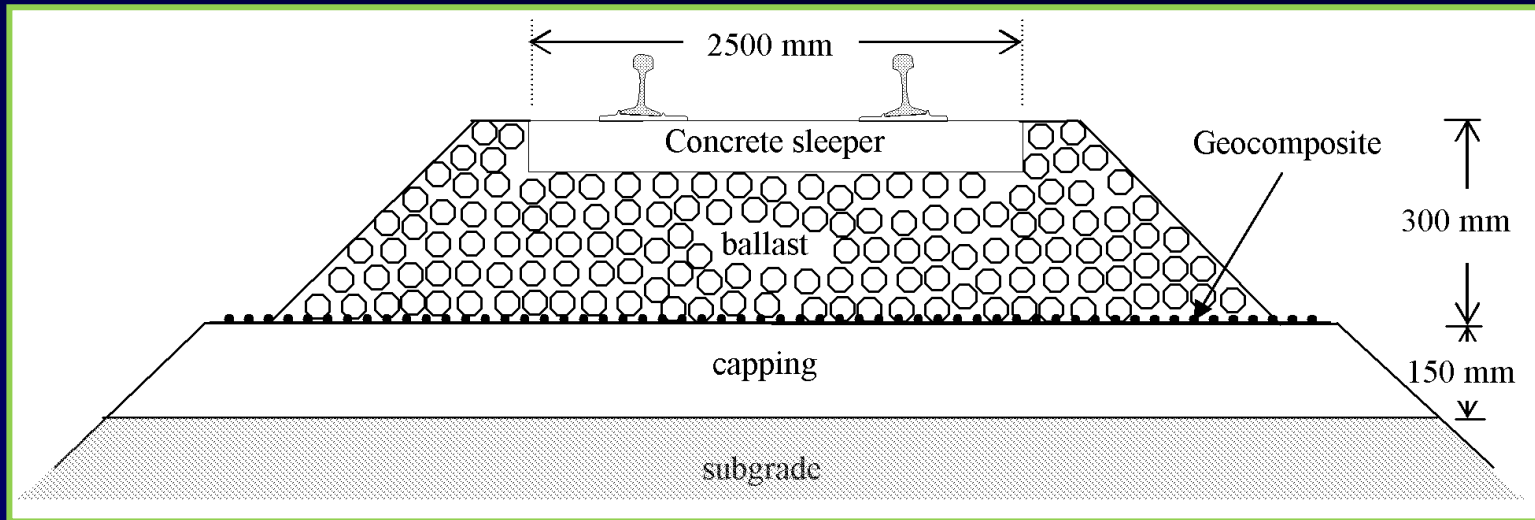


Optimum Aperture Size of Geogrids

Field Trial on Instrumented Track near Wollongong (Bulli)



Details of instrumented track



Section of ballasted track bed with geocomposite layer

Field Trial on Instrumented Track – Town of Bulli



**Geocomposite layer (geogrid+geotextile)
before ballast placement**



**Ballast placement over
the geocomposite**

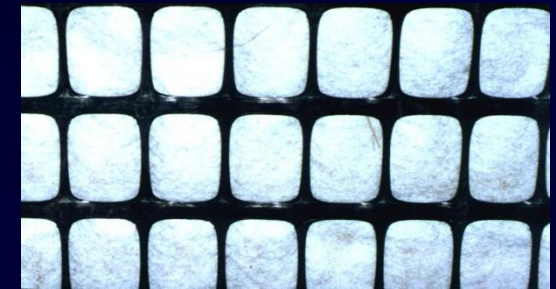
8 October 2006



Recycled Ballast
from Chullora Quarry, Sydney

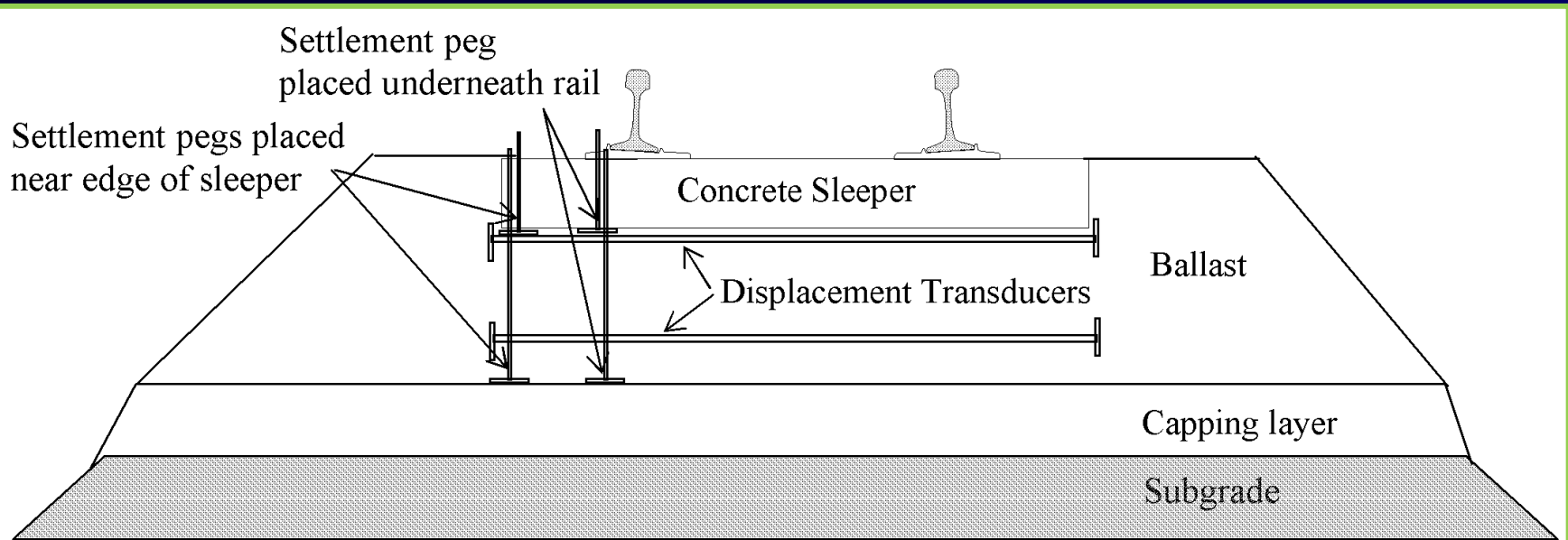


Fresh Ballast
Bombo Quarry, Wollongong



Bonded Geogrid

Field Instrumentation – Town of Bulli



Field Monitoring: Town of Singleton near Newcastle (NSW)



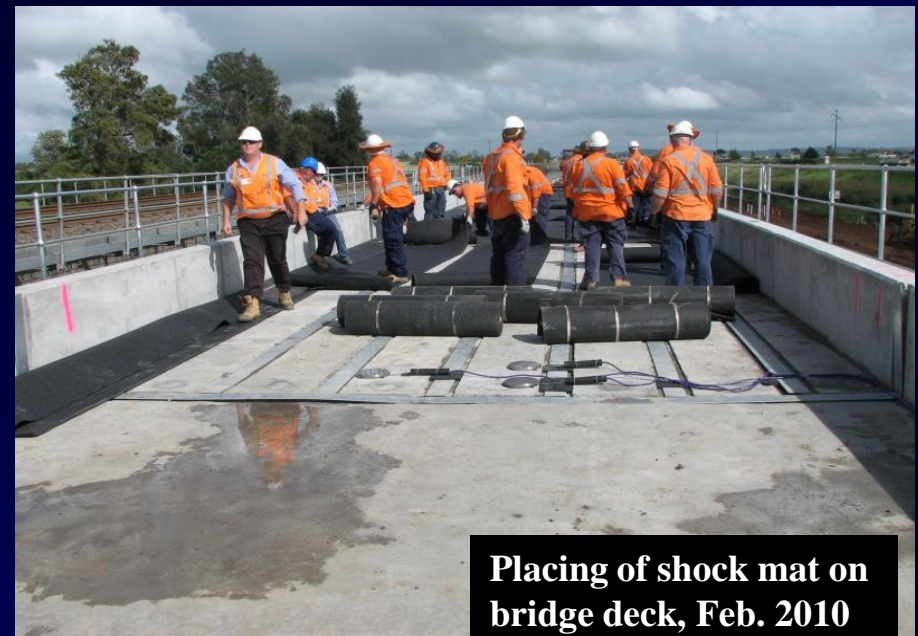
Geogrid layer placed above the capping



Settlement pegs placement in the track



Mudies Creek Bridge pressure cells installation



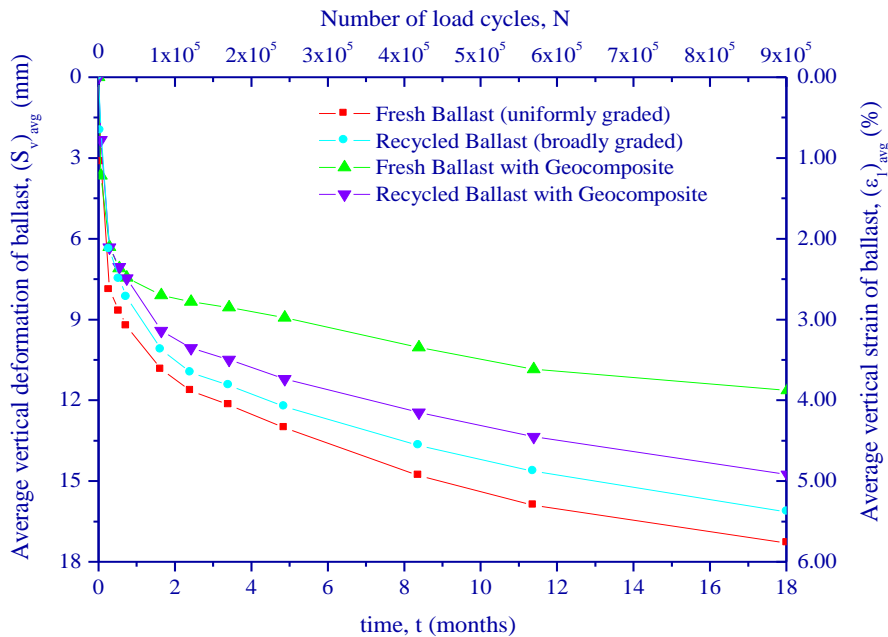
Placing of shock mat on bridge deck, Feb. 2010

Role of Geosynthetics - Field Monitoring of Track Response

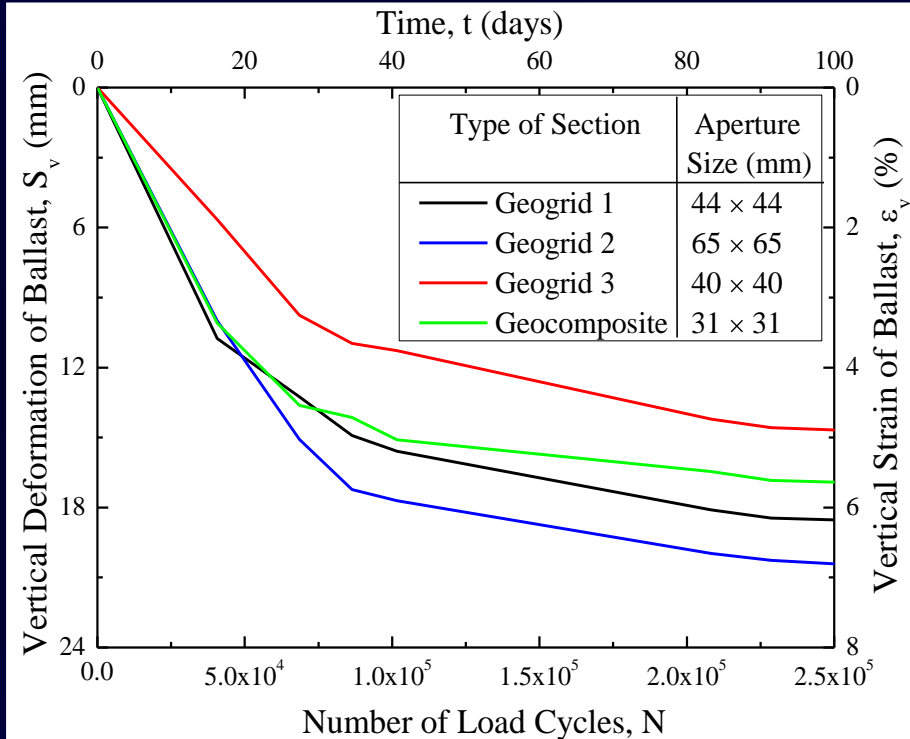
Bulli Track: Indraratna et al. (2010). JGGE, ASCE, Vol. 136(7), 907-917

Singleton Track: Indraratna et al. (2014). ICE Proc. Ground Improvement, 167(1), 24-34

Bulli Track



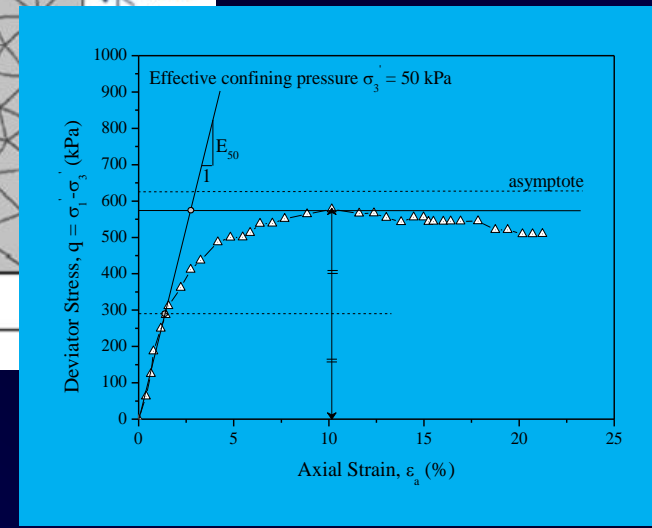
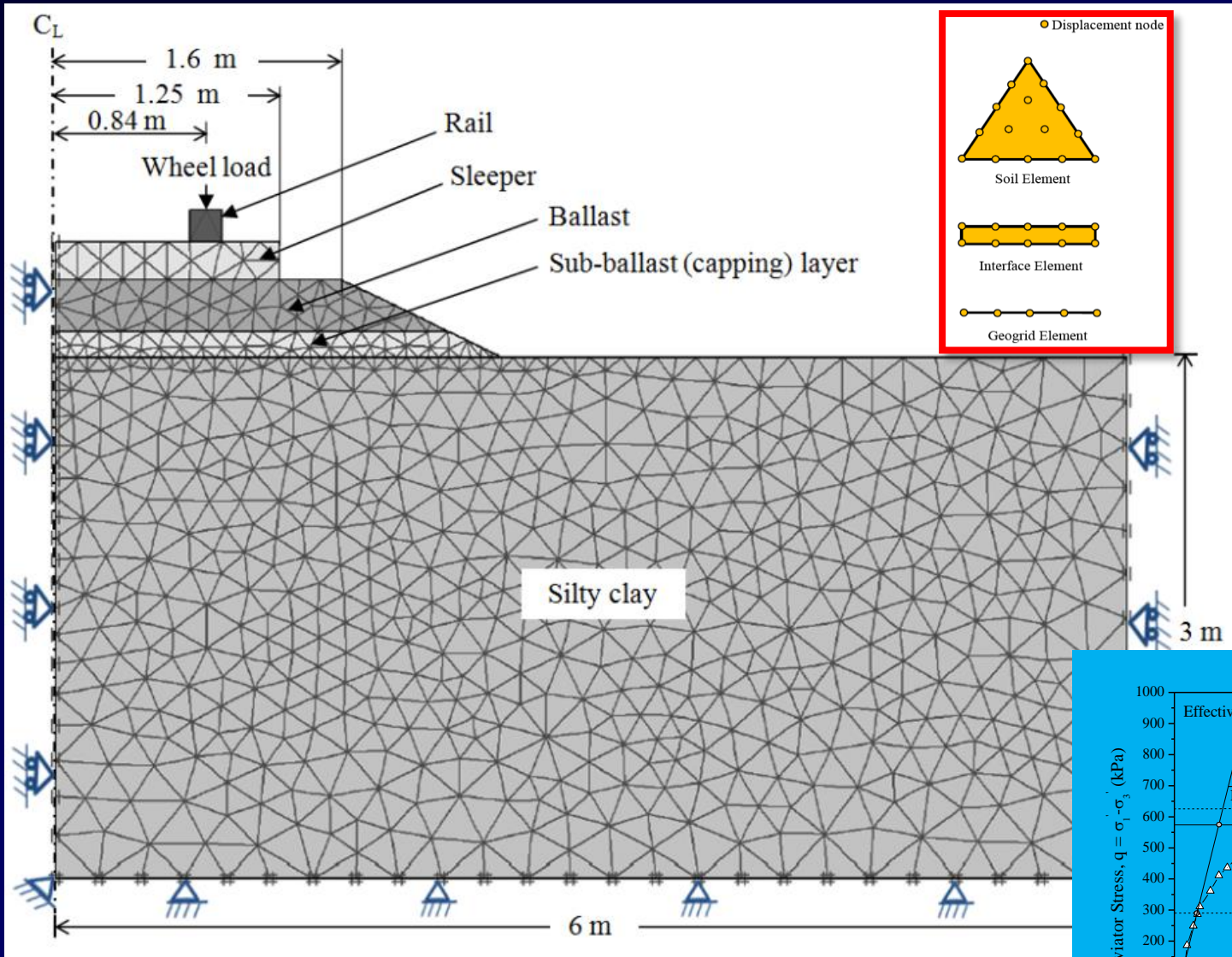
Singleton Track



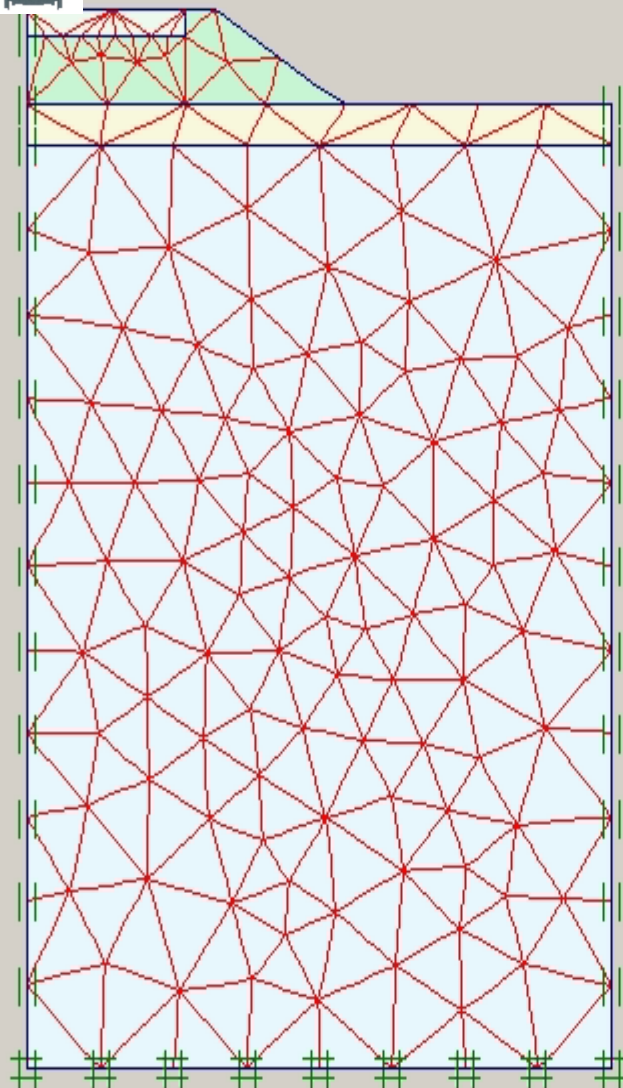
Recycled ballast: broadly-graded compared to uniform fresh ballast – so performed better !

Optimum aperture size of geogrids is about $1.2D_{50}$ of ballast.

Finite Element Analysis of Track: 2D Plane Strain

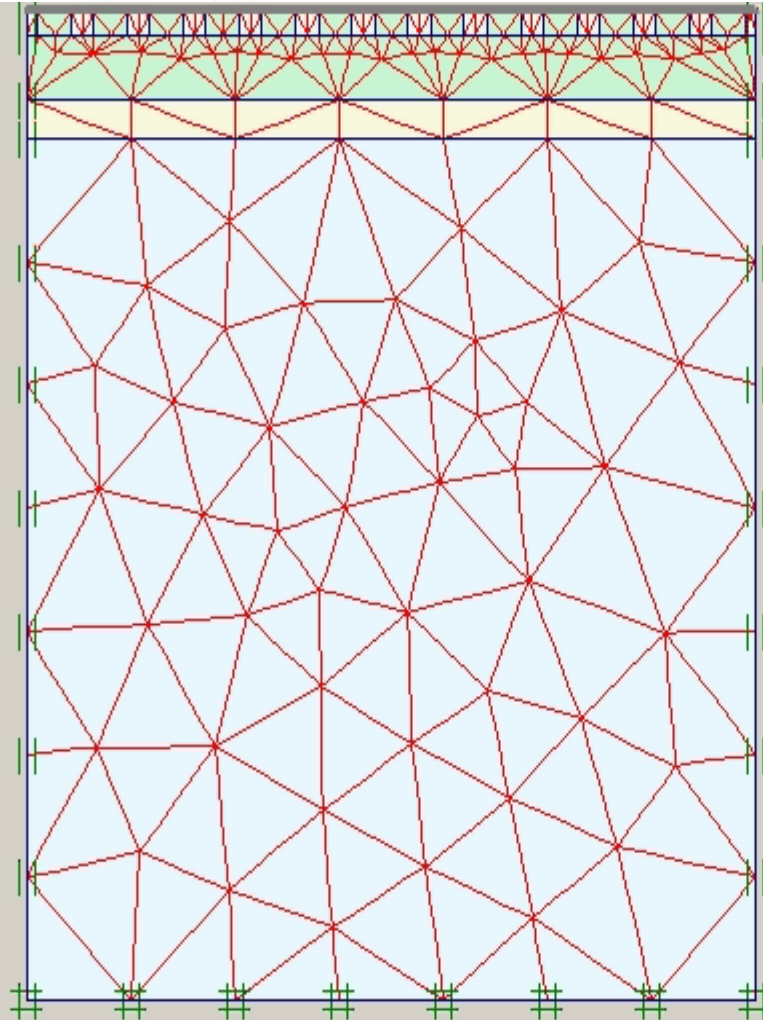
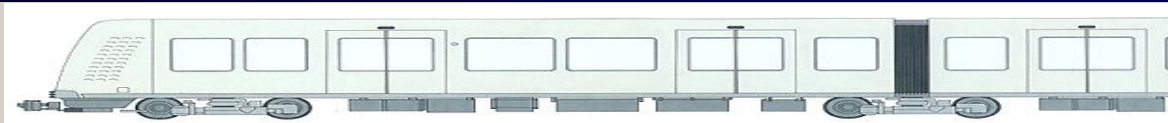


Track transverse section deformation



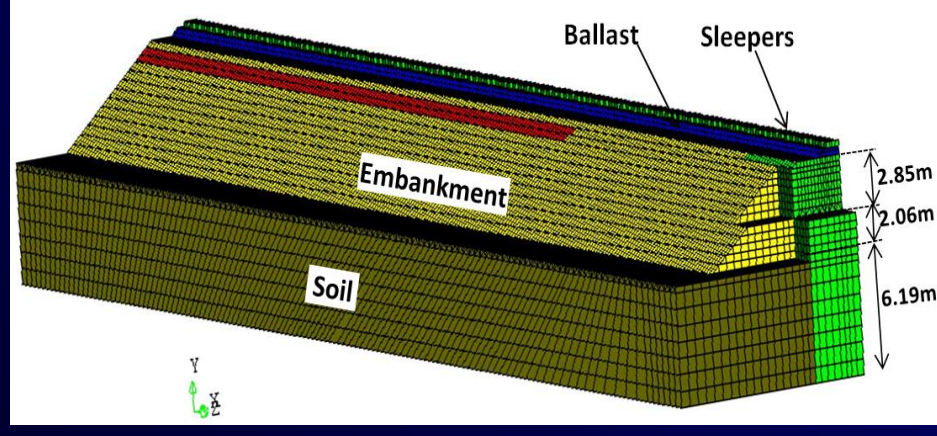
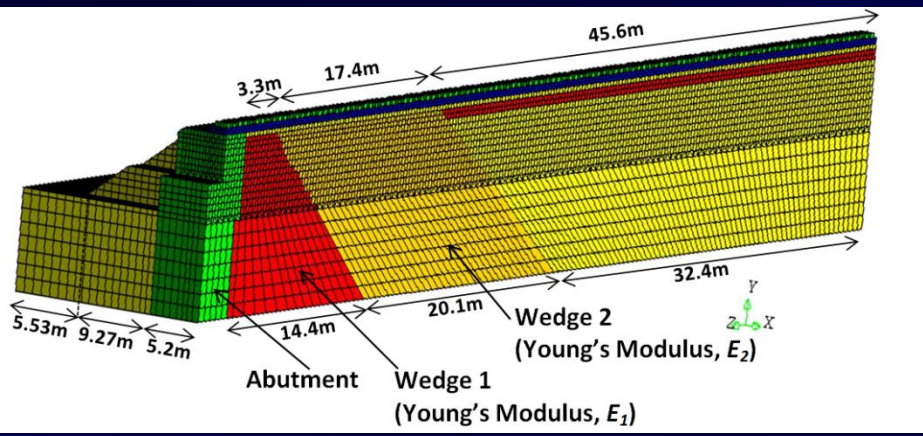
Deformed mesh
(Step 0)

Track longitudinal section deformation



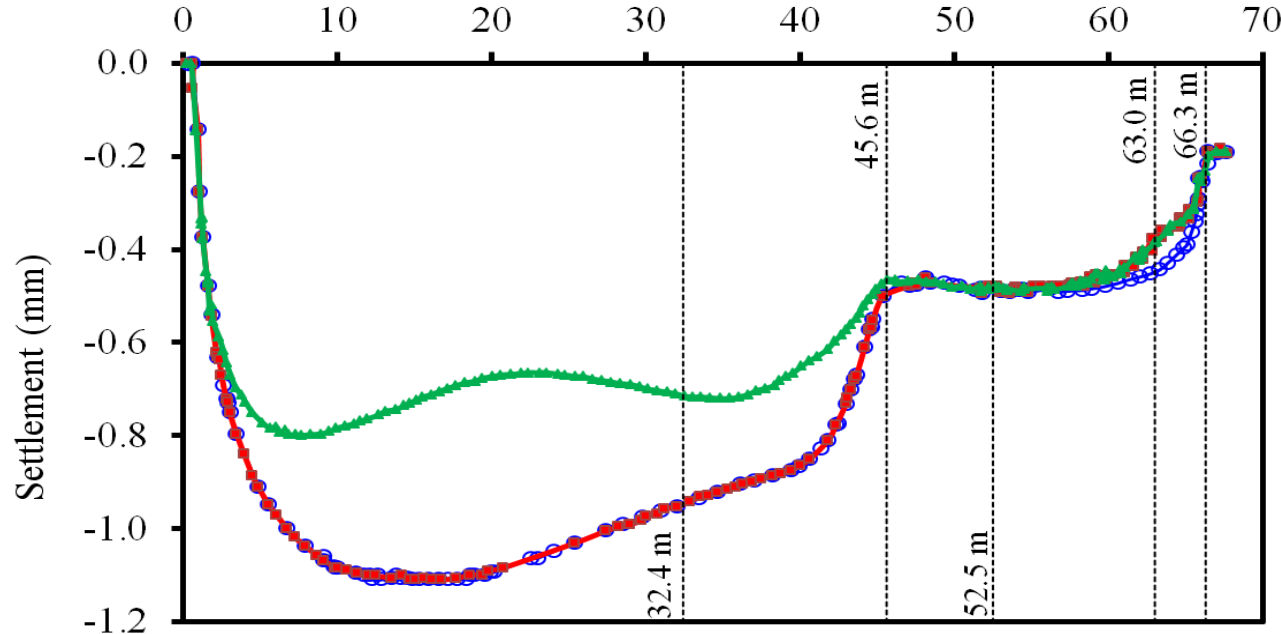
Deformed mesh
(Step 0)

FEM modelling of Transition Zones



- Model 1: $E_{Embankment} = 60 \text{ Mpa}$, $E_1/E_2 = 1.195$
- Model 2: $E_{Embankment} = 60 \text{ Mpa}$, $E_1/E_2 = 2.0$
- Model 3: $E_{Embankment} = 100 \text{ Mpa}$, $E_1/E_2 = 2.0$

Distance from Embankment to bridge deck (m)

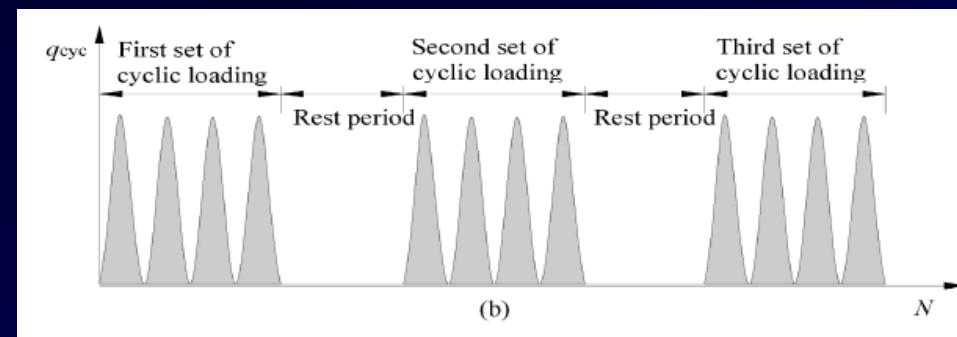
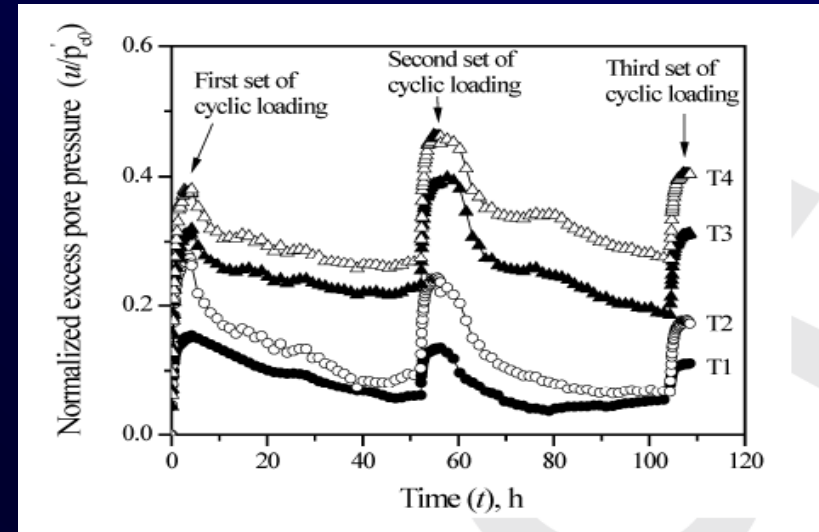
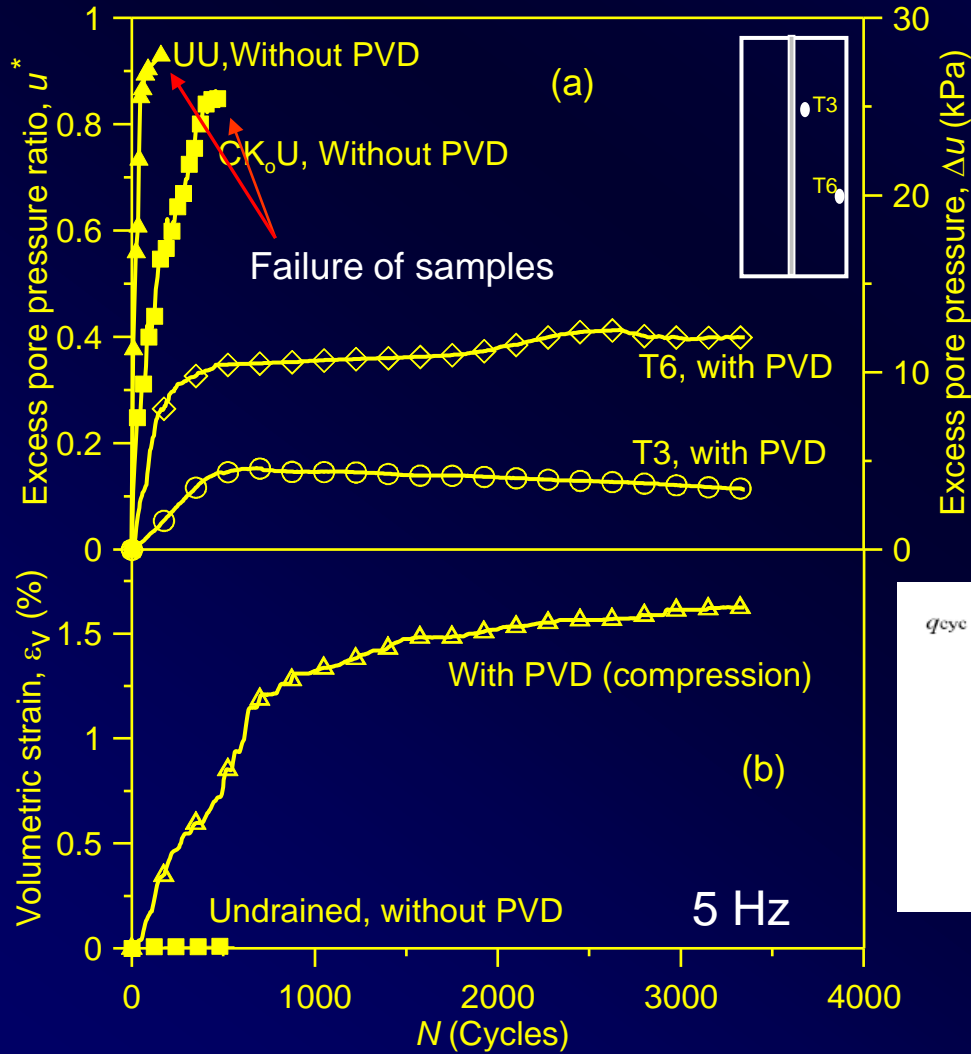


Performance assessment and numerical solutions for transition zones – approaching bridge deck

Seara and Correia (2010), Semana de Engenharia Escola de Engenharia da Universidade do Minho.

Cyclic Response of Soft Subgrade with Vertical Drains under High Speed Rail Conditions

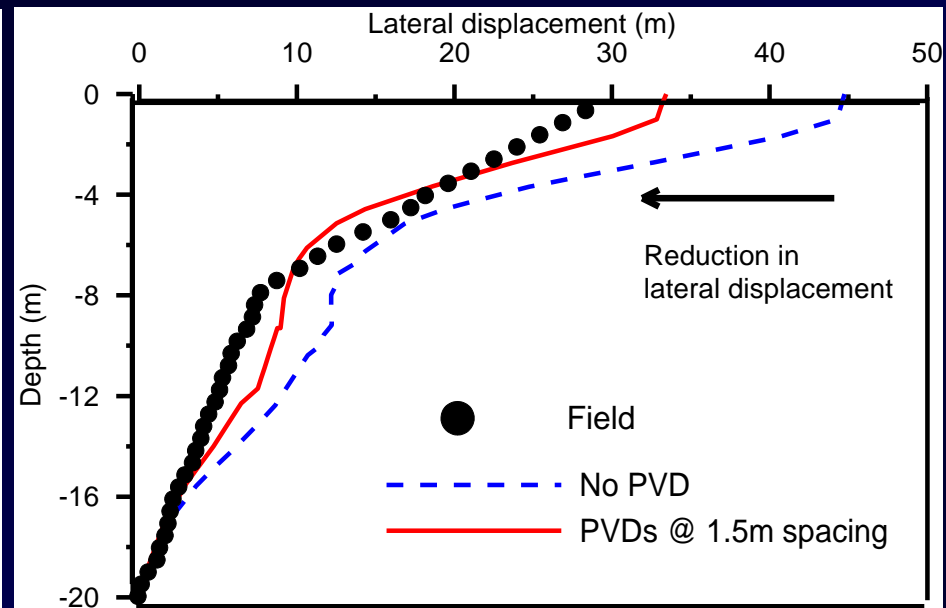
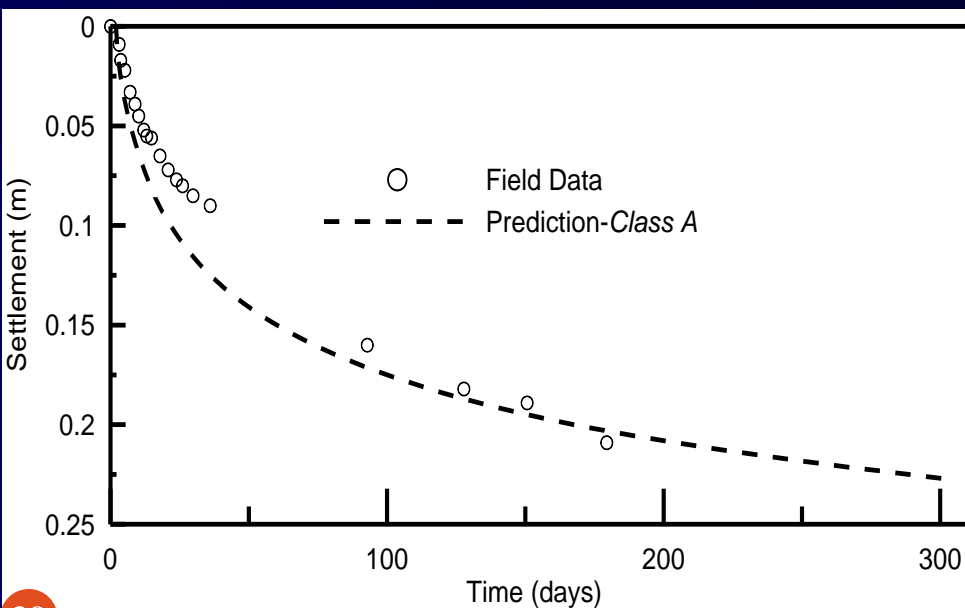
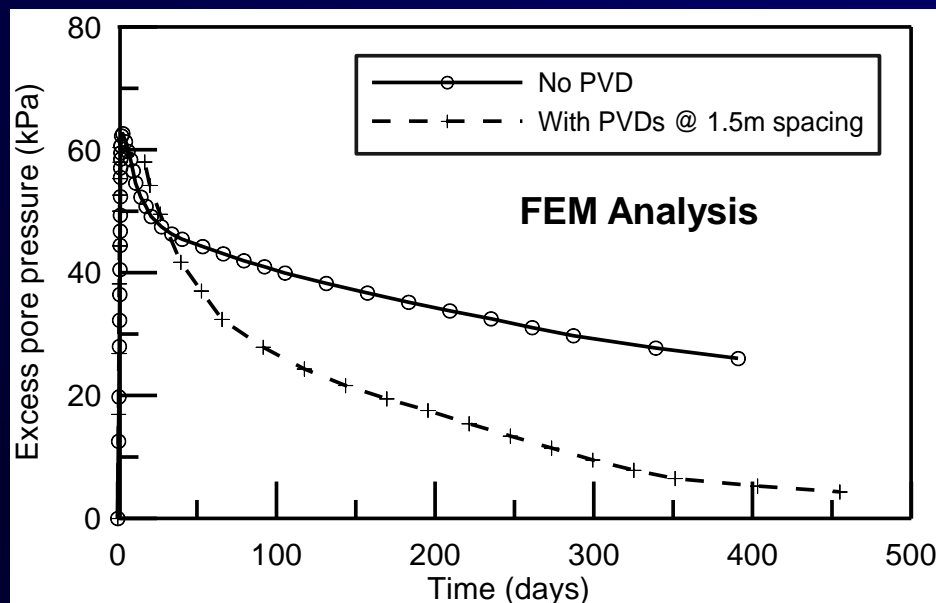
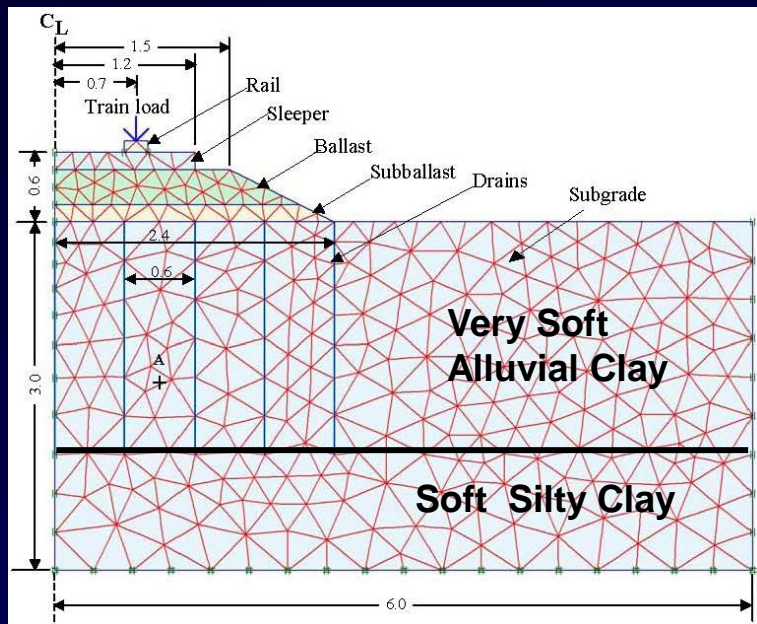
Indraratna, Attya and Rujikiatkamjorn (2009) JGGE, ASCE, Vol. 135(6), 835-839



Specimens without PVD fail very quickly as the excess pore pressure rises rapidly!

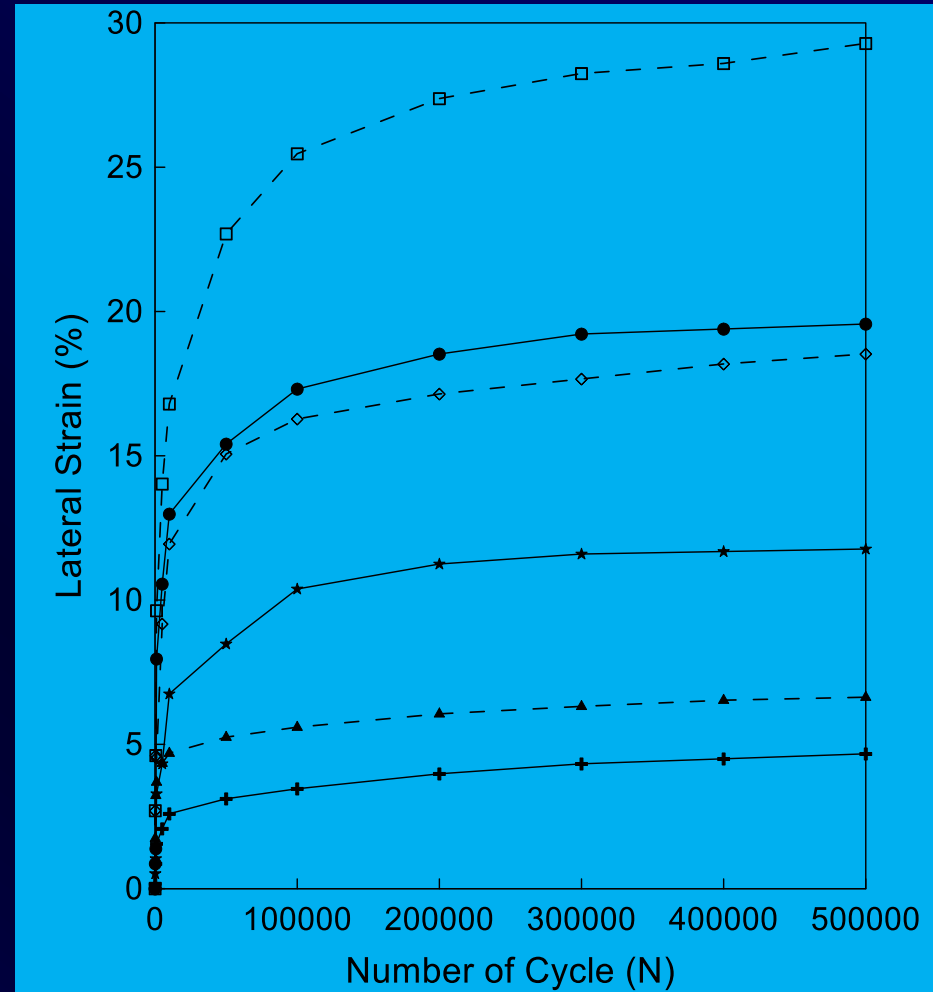
Short PVD Applications to Rail Embankment at Sandgate and FEM Analysis

Class A Prediction (Indraratna et al, ASCE, JGGE, 2010)



Geocell stabilisation of capping layer to minimise mud pumping

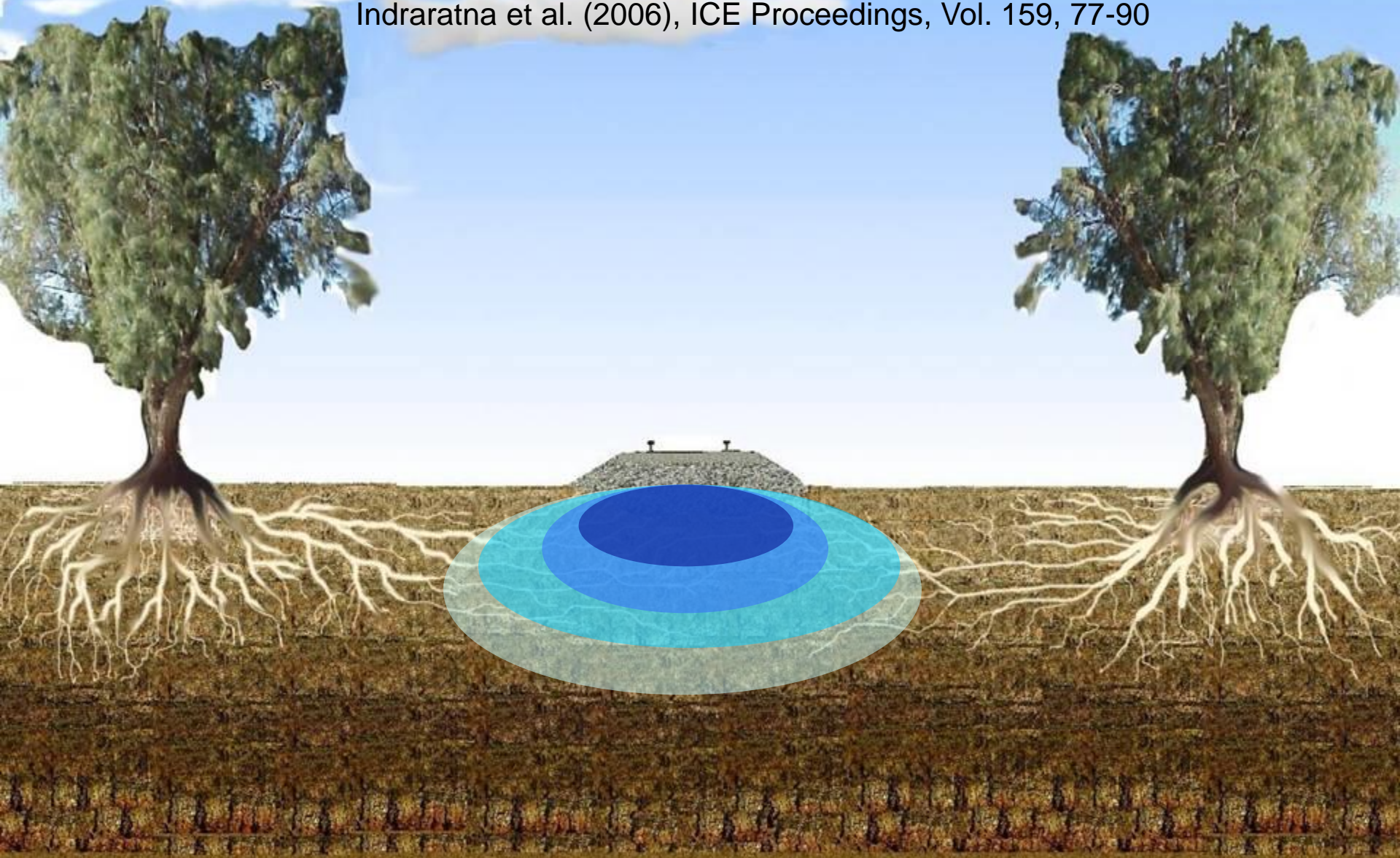
Indraratna et al. (2015). JGGE, ASCE, Vol. 141(1), 1-16



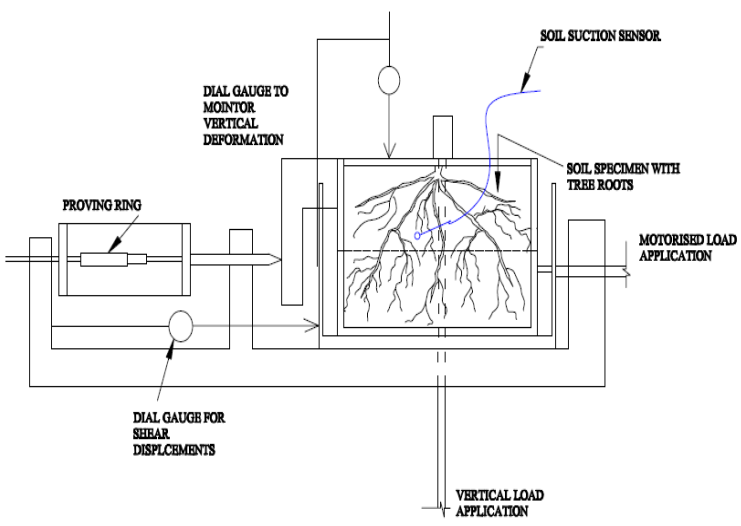
- ▲ - Unreinforced-10 kPa-10 Hz
- ◇ - Unreinforced-10 kPa-20 Hz
- □ - Unreinforced-10 kPa-30 Hz
- + - Reinforced-10 kPa-10 Hz
- ★ - Reinforced-10 kPa-20 Hz
- ● - Reinforced-10 kPa-30 Hz

Interaction of Trees and Ground for Stabilising Rail Corridors

Indraratna et al. (2006), ICE Proceedings, Vol. 159, 77-90

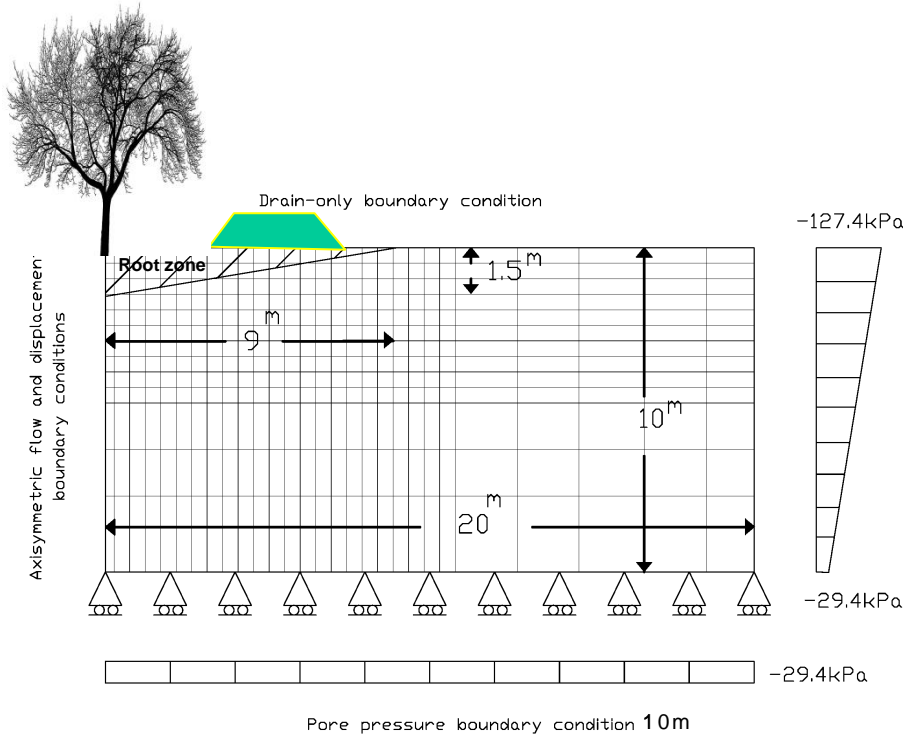


Laboratory and Field Measurements: Role of Soil Suction



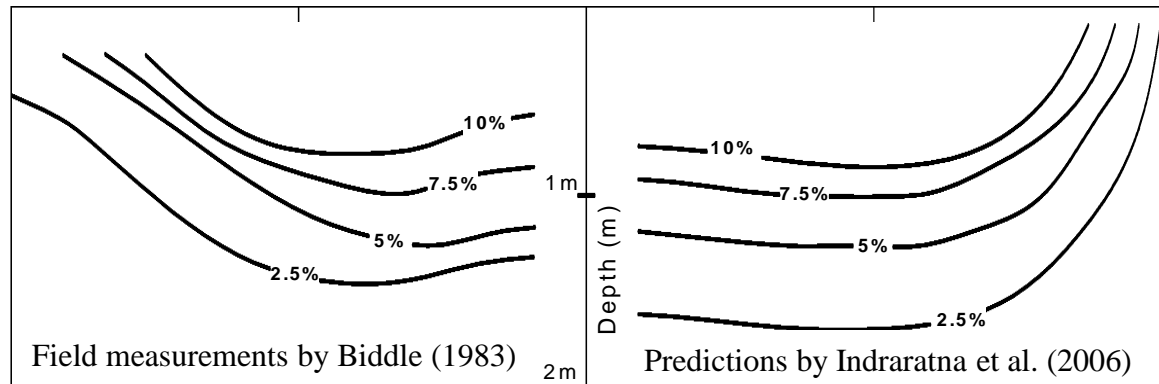
Computational Tree Root Model Validation

Example: A single, 14m high lime tree in U.K (Biddle 1983)



FEM modeling of a single native tree

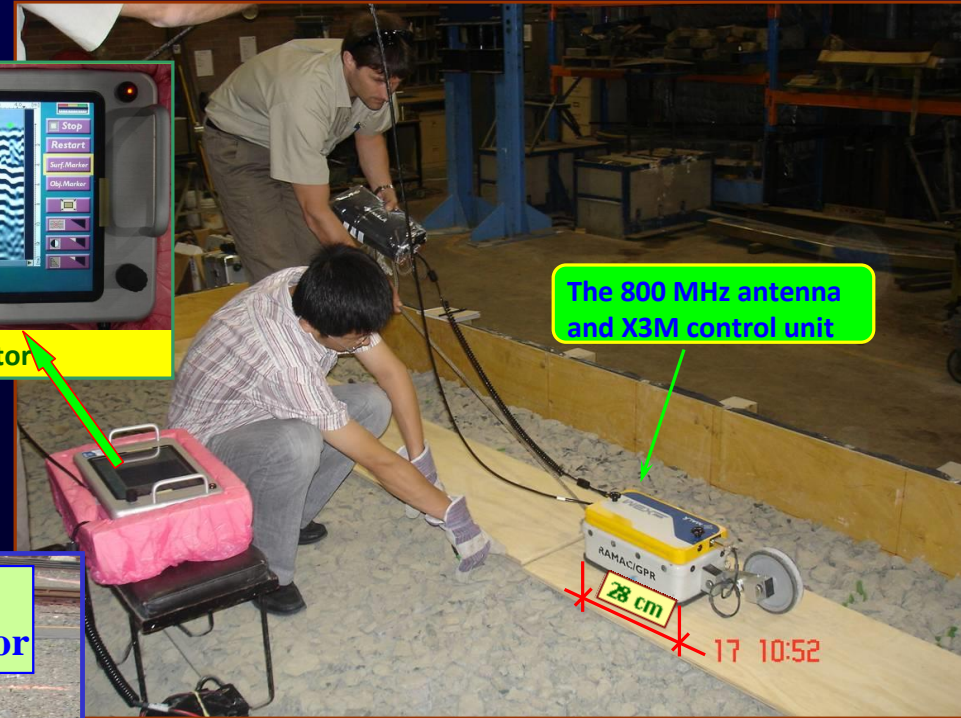
Contours of volumetric soil moisture content reduction (%) in the vicinity of a lime tree



Track Condition Monitoring - Ground Penetration Radar (GPR)

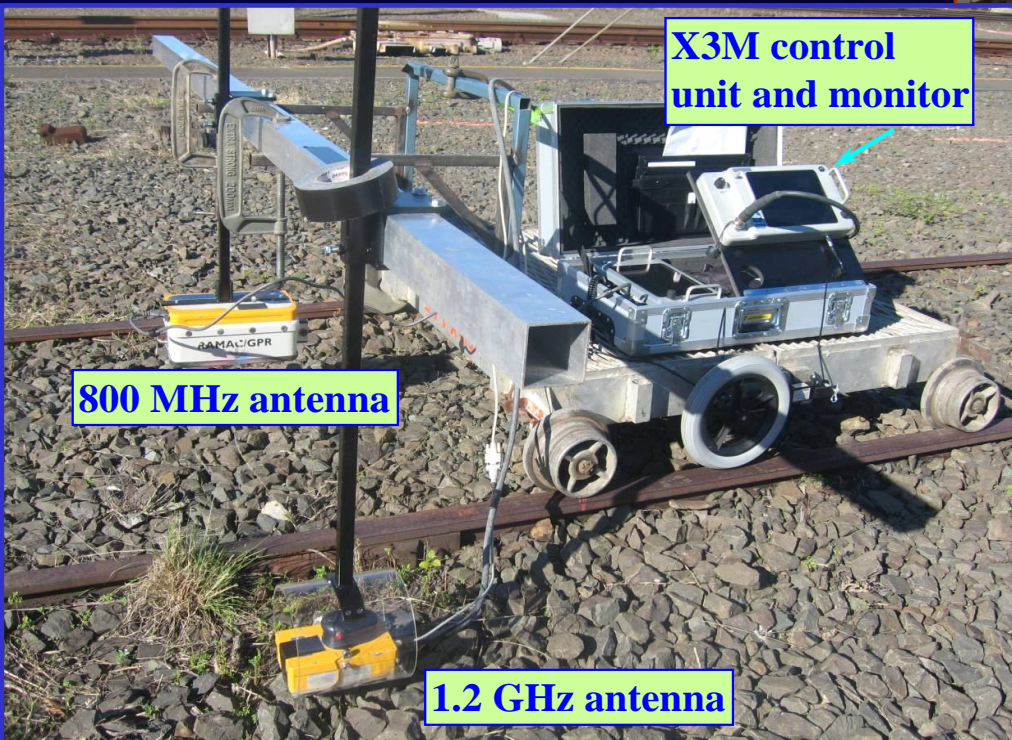


XV11 Monitor



The 800 MHz antenna and X3M control unit

Lab testing (Uni. of Wollongong)



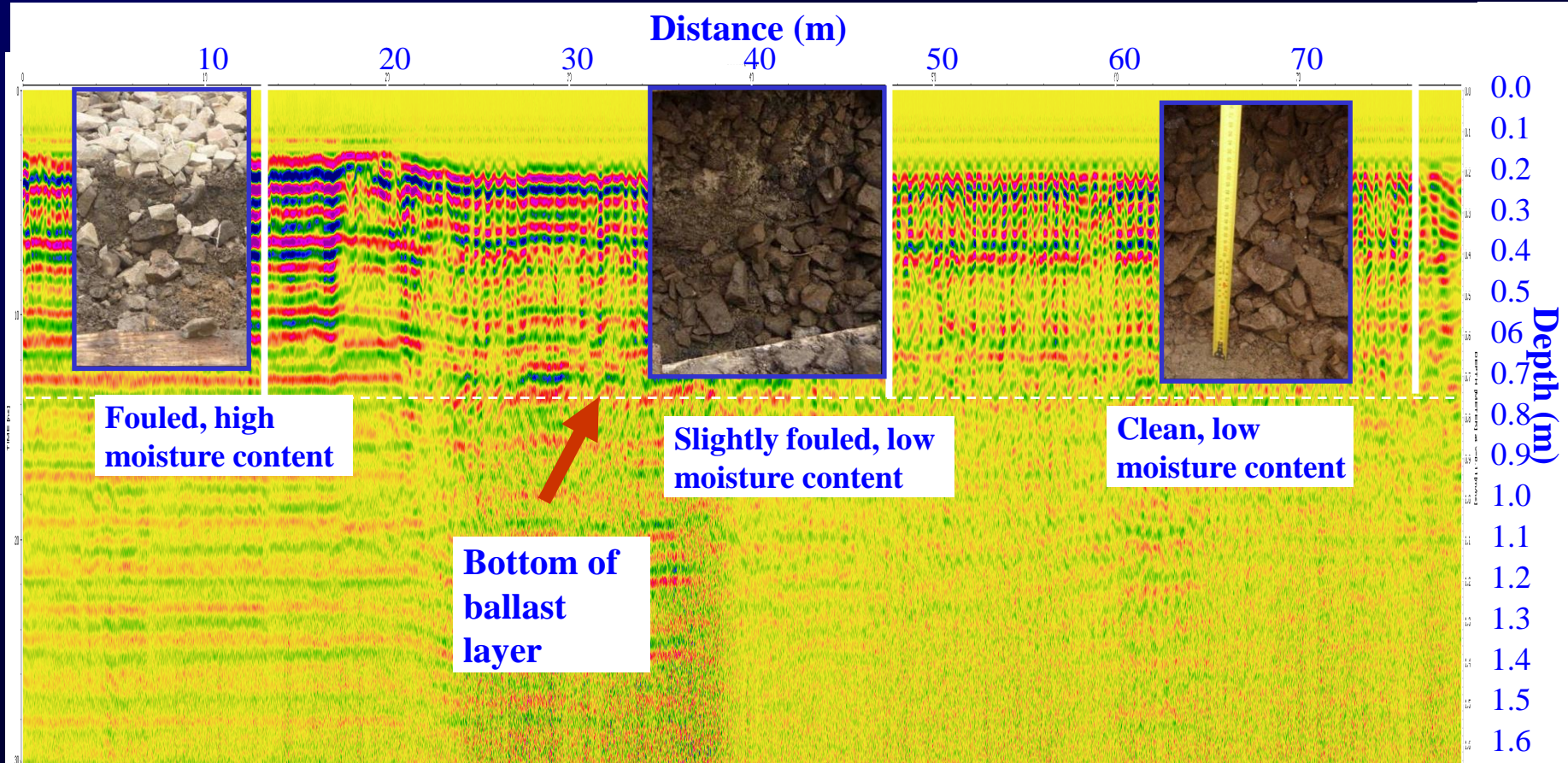
X3M control unit and monitor

800 MHz antenna

1.2 GHz antenna

Field testing (Wollongong)

GPR Lab and Field Testing

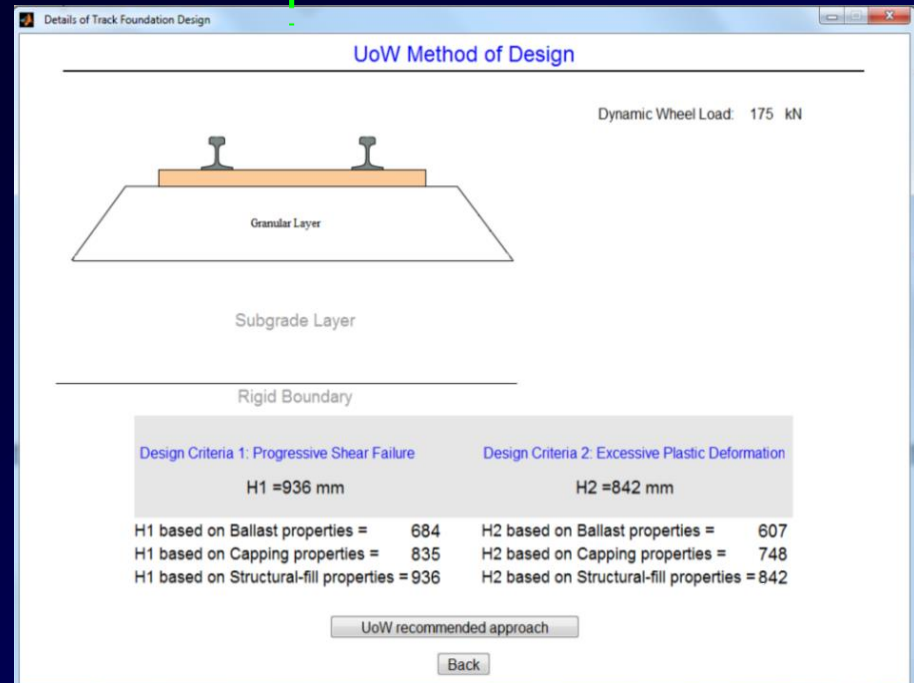
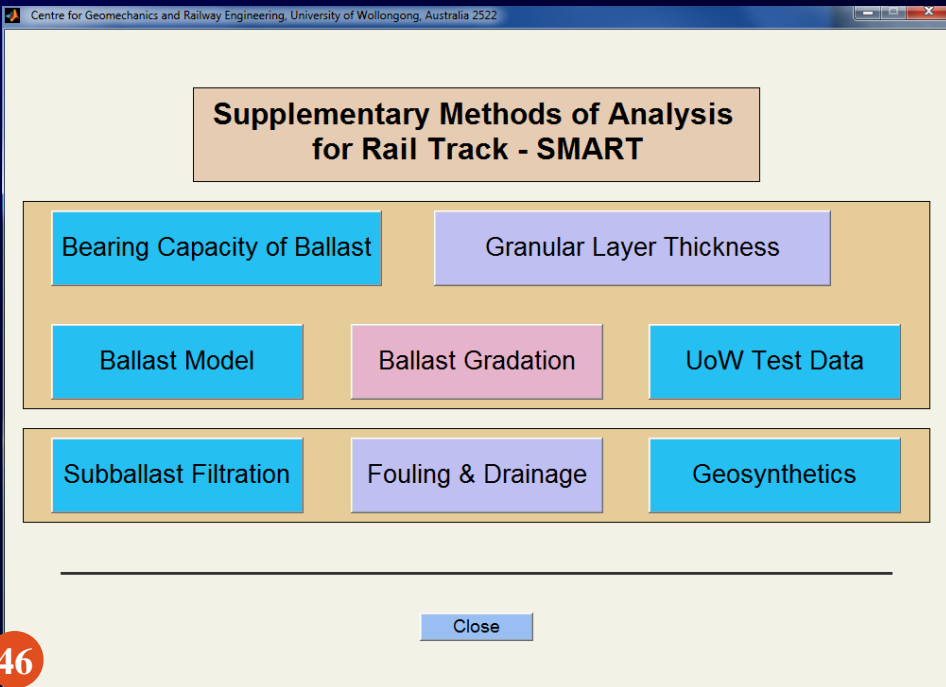
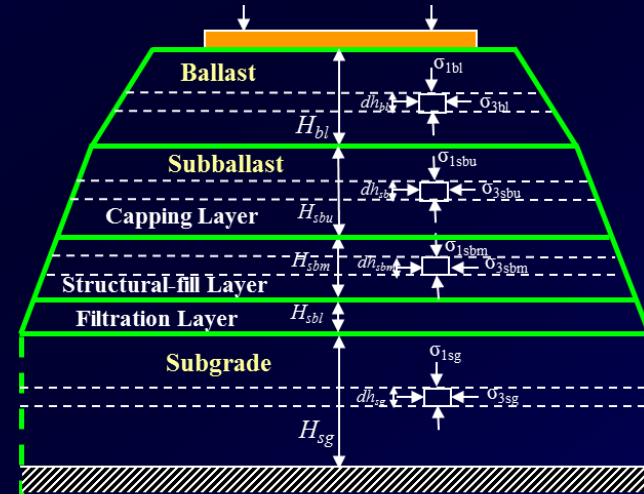


New Design Procedures – UoW Method

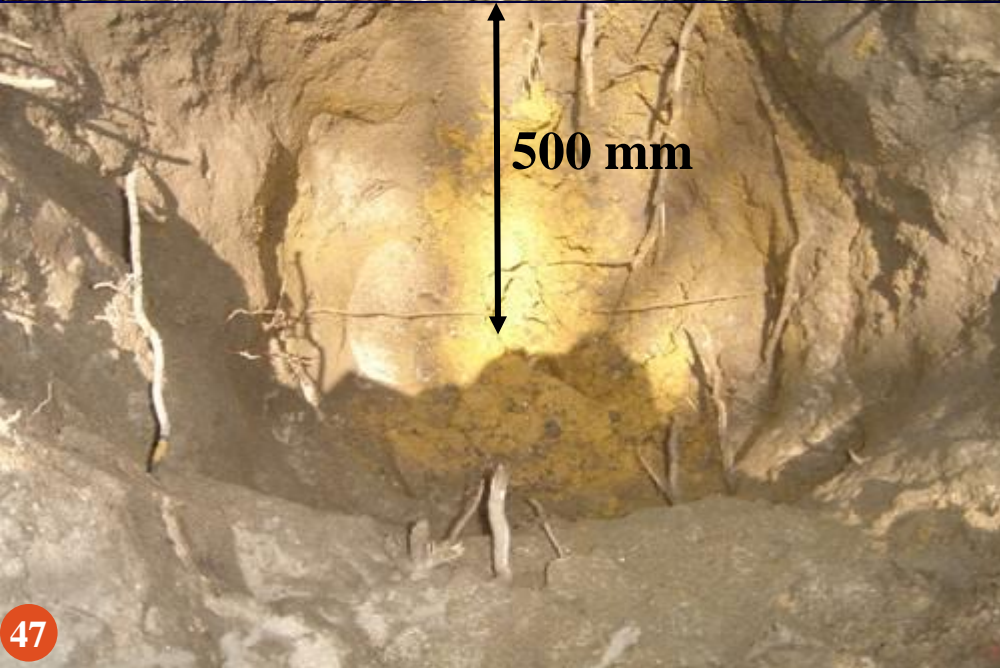
(Supplementary Method of Analysis of Rail Track – *SMART*)

Key features:

- a set of MATLAB subroutines: design and analysis of track based on research outcomes;
- a collection of performance-based methods for formation-track analysis.
- stand-alone computer application: user-friendly interfaces for data input and output.



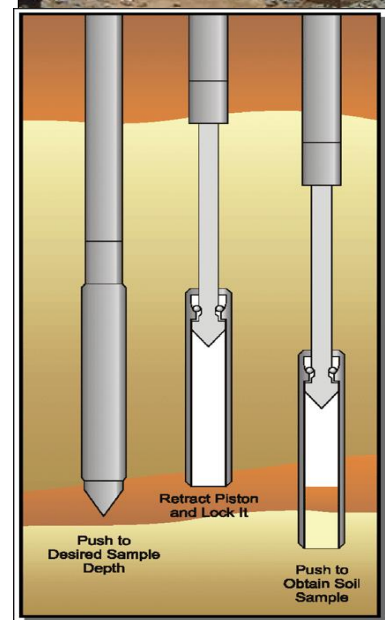
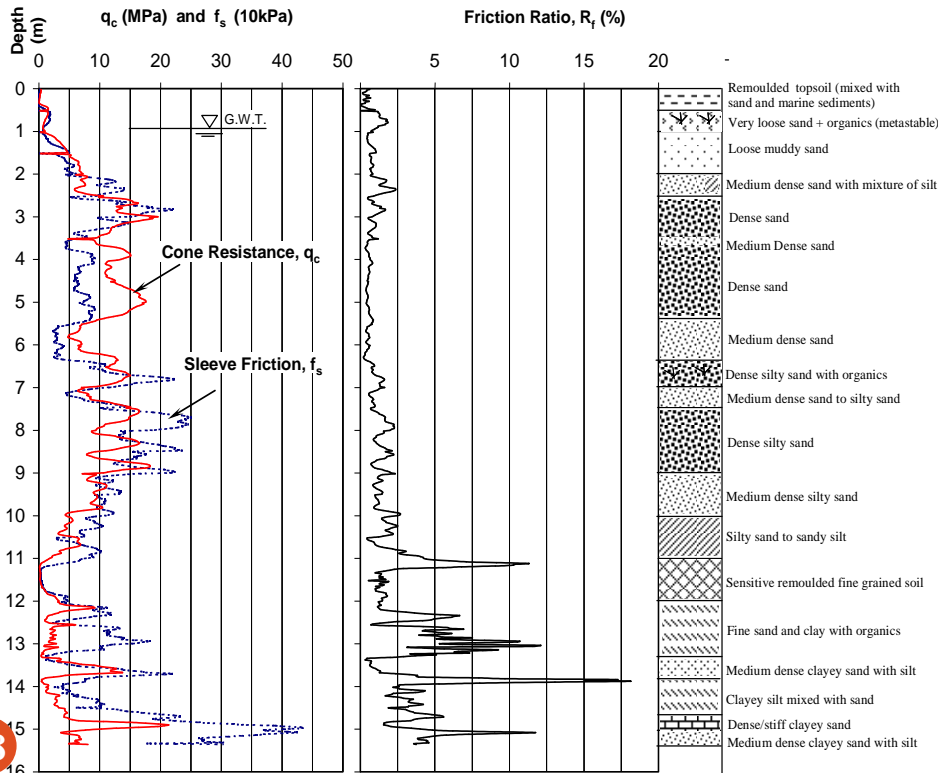
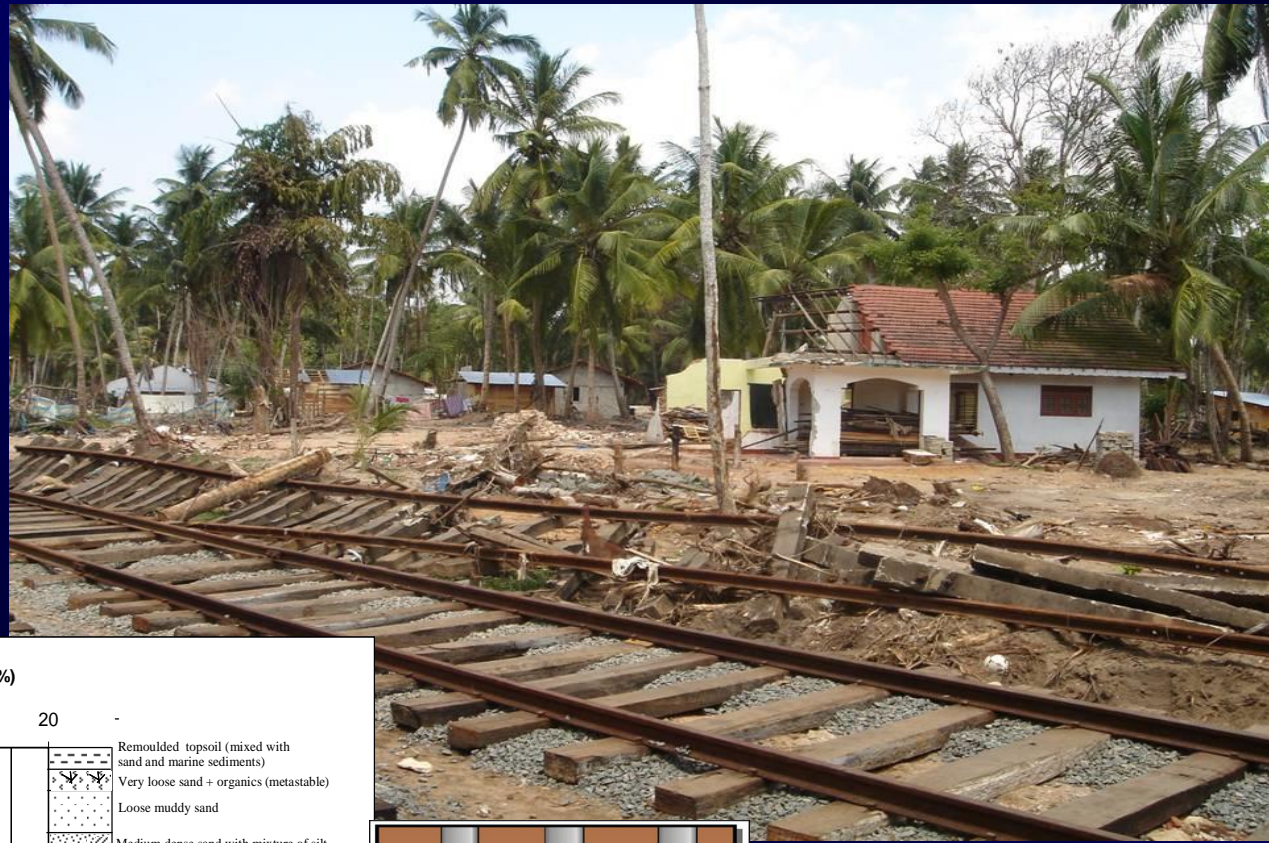
Stressful Challenges in Disaster areas: Post-Tsunami Rail Track Rehabilitation in Sri Lanka (Jan-March 2005)



Cone Penetration Test and Trial Pit

Mixed metastable sands with fine sediments (organic) at shallow depths followed by undisturbed coarser sand at greater depths

Ground condition assessment using cone penetration test (CPT)



Observe the coconut palm trees !

Conclusions and Recommendations

- Geosynthetics: increase internal **confining pressure** and **reduce particle movement** and **breakage** at elevated train speeds.
- **Computational FEM & DEM models** to predict track **degradation** with time, (c.f. empirical assessments).
- **Energy Absorbing Shock Mats** for minimizing impact damage
- **Application of PVDs** for improving soft subgrade soils and prevent mud pumping
- **Condition Monitoring via Field trials:** insight to complex track behaviour - performance verification.
- **Native Vegetation** – Green Corridors provide increased subgrade shear strength and less settlement
- **Ground Penetration Radar** can identify potential “adverse patterns” of hazards in track.

Acknowledgment

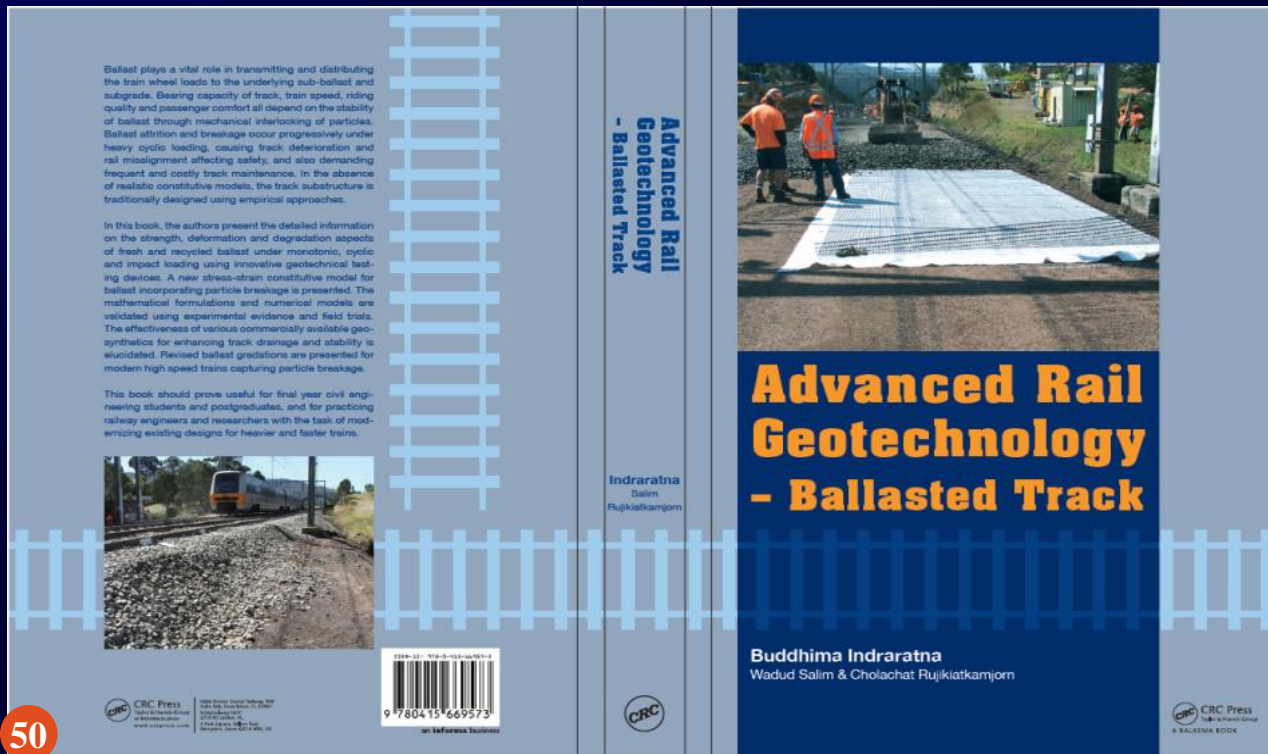
- Australian Research Council (ARC)
- ISSMGE-TC202: Transport Geotechnics
- Centre for Geomechanics and Railway Engineering, University of Wollongong, Australia
- Past and Present research students, Research Associates and Technical Staff
- Industry Organisations: RailCorp (NSW), ARTC, QLD Rail, ARUP, Coffey Geotechnics, Douglas Partners, Roads & Traffic Authority, QLD Main Roads, Port of Brisbane Corporation, Port Kembla Port Corporation



Buddhima Indraratna, Jian Chu, Chalachat Rujkietkarnjorn



Buddhima Indraratna, Jian Chu, Chalachat Rujkietkarnjorn



Buddhima Indraratna, Jian Chu, Chalachat Rujkietkarnjorn

Thank You!