

Certificate

Certification number SP AF 054

This is to certify that the flash butt welds produced by the mobile flash butt welding machine the Schlatter AMS 60.0.1/210 Supra flex, AS.1.2624.02997 (MW03) of

Vossloh Mobile Rail Services GmbH Leipzig, Germany

has been approved for butt joints in:

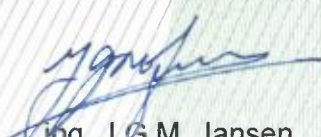
54E1 R260Mn to 54E1 R260Mn

in accordance with the specification EN 14587-2: 2009 & RLN00127, version 004, d.d. 01-02-2019. Details are mentioned in annex 1 and 2.

Current Certificate : April 2021
Certificate Expiry : April 2024

On behalf of DEKRA Rail


ir. A.J.P. Verweij
Manager Certification


ing. J.G.M. Jansen
IWE nr.: 192



Welding Qualification Approval Record – Certificate

Number: SP AF 054
Number: Annex 1

Kenmerk:
Designation: See DR/21/200464/005

Keuringsinstantie:
Test body: DEKRA Rail bv

Opdrachtgever:
Employer: Vossloh Mobile Rail Services GmbH

Datum van uitgifte:
Date of issue: 21 April 2021

Adres:
Address: Hugo-Aurig-str.3, D-04319
Place: Leipzig, Germany

	Details van de proeflas Weld test details	Geldigheidsgebied Range of approval
Lasproces Welding process	Afbrandstuiklassen (241) Flash-butt welding (241)	
Spoorstaaf type Rail type	54E1 to 54E1	54E1/5 to 54E1/5
Soort verbinding Joint type	Stuiklas Butt weld	
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn
Lasmachine fabrikant Welding machine manufacturer	Schlatter	Schlatter
Lasmachine identificatie Welding machine identification	MW 03	MW 03
Machine type Machine type	AMS 60.0.1/210 supra flex	AMS 60.0.1/210 supra flex
Machine nummer Machine number	AS.1.2624.02397	
Lasmachine/Bedieners identificatie Welding machine/Operators identification	Zie rapport: See report	DR/21/230464/005
Laspositie Welding position	n.v.t. n.a	n.v.t. n.a
Voorbehandeling Gouging / backing	n.v.t. n.a	n.v.t. n.a
Aard van de beproeving Type of testing	Acceptatie criteria Acceptation criteria	Acceptabel / niet vereist Acceptable / not required
Visueel Visual	Zie rapport: See report: DR/21/200464/005	Acceptabel Acceptable
Geometrie Geometrically		Acceptabel Acceptable
Magnetisch onderzoek Magnetic particle inspection		Acceptabel Acceptable
Penetrant Dye penetrant		Niet vereist Not required
Buig/breektest Bend/Break test		Acceptabel Acceptable
Vermoeingsproef Fatigue test		Niet vereist Not required
Hardheidsmetingen Hardness measurements		Niet vereist Not required
Macro-onderzoek Macro-examination		Niet vereist Not required
Micro-onderzoek Micro-examination		Acceptabel Acceptable
Aanvullende beproevingen Additional tests		Niet vereist Not required

Opmerkingen
Remarks
Top of the rail foot is ground
Pay attention to the upset

- Vakkenis Acceptabel Niet beoordeeld
- Job knowledge Acceptable Not tested
- Aparte bladen toegevoegd indien vereist JA / Yes
- Append separate sheet(s) if required NEE / No

Aanvullende informatie beschikbaar op Zie rapport:
Additional information is available on See report,
DR/21/200464/005, d.d. 4 mei 2021

Kwalificatie geldig tot: **April 2024**
Validity of approval until:

Datum:
Date: 06-05-2021

Handtekening:
Signature: 


ing. J.G.M. Jansen IWE nr.: 192

