

Certificate

Certification number SP TH 047

This is to certify that the aluminothermic welds

- Filler mould: 60E1 (UIC 60) SoW-5
- Filler metal: 60 / Z130(+) SoW-5-E

produced by:

Elektro-Thermit GmbH & Co. KG
Halle (Saale), Germany

has been approved for normal gap butt joints in:

60E1 370CrHT to 60E1 370CrHT

in accordance with the specification RLN00451-2 d.d. 01-10-2021, and EN 14730-1:2017.

Details are mentioned in annex 1 and 2.

Original Approval : February 2016
Current Certificate : February 2022
Certificate Expiry : June 2025

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

Nummer: SP TH 047
Number: Annex 1

Kenmerk:
Designation: See DR/16/160018/002

Keuringsinstantie:
Test body: DEKRA Rail B.V.

Opdrachtgever:
Employer: Elektro-Thermit GmbH & Co. KG

Datum van uitgifte:
Date of issue: February 2022

Adres:
Address: Chemiestraße 24
D-06132 Halle (Saale), Germany

	Details van de proeflas Weld test details	Geldigheidsgebied Range of approval	
Lasproces Welding process			Thermietlassen (71) Alumino-thermic (71)
Spoorstaaf type Rail type	60E1 to 60E1	60E1 to 60E1 60E2 to 60E2	
Soort verbinding Joint type			Stomplas Butt weld normal gap
Basismateriaal groep(en) Parent metal group(s)	370LHT to 370LHT	370LHT to 370LHT 370CrHT to 370CrHT	
Lasmal type Filler mould type	60E1 (UIC 60) SoW-5	60E1 (UIC 60) SoW-5	
Lastoevoegmateriaal Filler metal designation	60 / Z130 SoW-5-E	60 / Z130(+) SoW-5-E	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a.	n.v.t. n.a.	
Overige middelen Auxiliaries	Zie rapport: See report	DR/16/160018/002	
Lasmachine/Bedieners identificatie Welding machine/Operators identification			
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	Opmerkingen Remarks
Visueel Visual		Acceptable	Dit certificaat is alleen geldig voor toepassing in NG2.0 wissels.
Geometrie Geometrically		Acceptable	
Ultrasoon onderzoek Ultrasonic testing		Acceptable	This certificate is only valid for use in NG2.0 switches.
Magnetisch onderzoek Magnetic particle inspection		Acceptable	
Buig/breektest Bend/Break test	Zie rapport: DR/16/160018/002	Acceptable	Handleiding voor het Thermjet® snelasproces SoW-5, versie 21/11/2017
Vermoeingsproef Fatigue test	See report: DR/16/160018/002	Acceptable	
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro-examination		Acceptable	
Mirco-onderzoek Micro-examination		Acceptable	
Chemische analyse Chemical analysis		Acceptable	

Vakkennis
 Job knowledge
 Acceptabel
 Acceptable
 Niet beoordeeld
 Not tested

Aparte bladen toegevoegd indien vereist
 Append separate sheet(s) if required
 JA / Yes
 NEE / No

Aanvullende informatie beschikbaar op: Zie rapport:
Additional information is available on: See report

Kwalificatie geldig tot: June 2025
Validity of approval until: DR/16/160018/002 d.d. February 2016
DR/19/170307/008 (Smart Weld Jet) d.d.d. 03 April 2019

Datum: 01-04-'22
Date:

Handtekening:
Signature:

J.G.M. Jansen
IWE 192

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

