

Certificate

Certification number SP TH 039

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC54) SoW-5
- Filler metal: 54 / Z120 SoW-5(-E)

produced by:

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

has been approved for normal gap butt joints in:


54E1 R350HT to 54E1 R350HT

in accordance with the specification RLN00451-2, d.d. 01 Oct 2021.
Details are mentioned in annex 1 and 2.

Original Approval : December 2011
Current Certificate : June 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 039
Number: Annex 1

Kenmerk:
Designation: See DeltaRail/12/110531/006

Keuringsinstantie:
Test body: DEKRA Rail B.V.

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

Datum van uitgifte:
Date of issue: May 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	54E1 to 54E1	54E1 to 54E1	
Soort verbinding Joint type		Stomplas Butt weld normal gap	
Basismateriaal groep(en) Parent metal group(s)	R350HT to R350HT	R350HT to R350HT	
Lasmal type Filler metal type	54E1 (UIC54) SoW-5	54E1 (UIC54) SoW-5	
Lastoevoegmateriaal Filler metal designation	54 / Z120 SoW-5(-E)	54 / Z120 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:	DeltaRail/12/110531/006	
Lasmachine/Bedieners identificatie Welding machine/Operators identification	n.v.t. n.a	n.v.t. n.a	
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	Investigation Report - P0311 Rev. 1- DeltaRail/11/110092/01 4
Geometrie Geometrically		Acceptable	September 2011, 27 May 2011
Ultrasoon onderzoek Ultrasonic testing		Acceptable	Handleiding voor het Thermiet® snellasproces SoW-5, versie 21/11/2017
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breuktest Bend/Break test	Zie rapport: See report: DeltaRail/12/110531/006	Acceptable	
Vermoeingsproef Fatigue test		Acceptable	
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro-examination		Acceptable	
Micro-onderzoek Micro-examination		Acceptable	
Chemische analyse Chemical analysis		Not required	

Vakkennis Job knowledge Acceptabel Acceptable Niet beoordeeld Not tested
 Aparte bladen toegevoegd indien vereist 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:

DeltaRail/12/110531/006 d.d. July 2012
DR/19/170307/008 (Smart Weld Jet) d.d. 03 April 2019

Datum: 19-05-22
Date:

Handtekening:
Signature :

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

Verlenging
Prolongation

Nummer:
Number: **SP TH 039** annex 2

Verlenging door beoordelaar met 3 jaar
Authorized prolongation for the following 3 years

**Herkwalificatie
rapportnummer:**
Re-qualification
report number:

Datum:
Date:

Handtekening:
Signature:

Functie of titel:
Position or title:

**Herkwalificatie
rapportnummer:**
Re-qualification
report number:

Datum:
Date:

Handtekening:
Signature:

Functie of titel:
Position or title:

Plurel/13/130143/006 Plurel/13/130143/007	6 June 2013, 14 August 2013				
DR/15/150004.003/004 DR/15/150004.003/012	2 April 2015 30 April 2015				
DR/17/170078.003/005 DR/17/170078.003/012	24 April 2017 31 May 2017				
DR/19/190008.003/004 DR/19/190008.003/013	08 May 2019 12 July 2019				
DR/22/220052.392 DR/22/220052.393	11-05-2022 13-05-2022	