

# Certificate

## Certification number SP TH 041

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC54) L50
- Filler metal: 54 / Z90 SoW-5(-E) + 812 / Z90 SoW-5 L50(-E)

produced by:

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

has been approved for wide gap (L50) butt joints in:

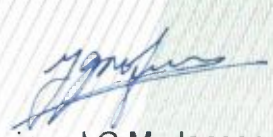
### **54E1 R260Mn to 54E1 R260Mn**

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

Original Approval : June 2013  
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 041  
 Number: Annex 1

**Kenmerk:**  
 Designation: See AEAT/04/2800046/006,

**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 wide gap (<math>\le 50</math>)	
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn	
Lasmal type Filler mould type	54E1 (UIC54) L50	54E1 (UIC54) L50	
Lastoevoegmateriaal Filler metal designation	54 / Z90 SoW-5(-E) + 812 / Z90 SoW-5 L50(-E)	54 / Z90 SoW-5(-E) + 812 / Z90 SoW-5 L50(-E)	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a.	n.v.t. n.a.	
Overige middelen Auxiliaries	Zie rapport See report	AEAT/04/2800046/006	
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	Handleiding voor het Thermiet® snellaspas SoW-5, versie 21/11/2017
Geometrie Geometrically		Acceptable	
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breektest Bend/Break test	Zie rapport: See report: AEAT/04/2800046/006	Acceptable	
Vermoeingsproef Fatigue test		Acceptable	
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro-examination		Acceptable	
Mirco-onderzoek Micro-examination		Acceptable	
Chemische analyse Chemical analysis		Not required	

Vakkennis  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: See report  
 Additional information is available on: See report

**Kwalificatie geldig tot:** June 2025  
 Validity of approval until: AEAT/04/2800046/006, d.d. March 2004  
 DR/19/170307/008 (Smart Weld Jet) d.d. 03 April 2019

**Datum:** 19-05-22  
**Handtekening:**  
 Date: Signature:

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

**Verlenging**  
Prolongation

**Nummer:**  
Number: **SP TH 041** 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:

DR/15/150004.003/005 DR/15/150004.003/012	2 April 2015 30 April 2015				
DR/17/170078.003/006 DR/17/170078.003/012	24 April 2017 31 May 2017				
DR/19/190008.003/005 DR/19/190008.003/013	08 May 2019 12 July 2019				
DR/22/220052.412 DR/22/220052.413	11-05-2022 13-05-2022	