

Certificate

Certification number SP TH 042

This is to certify that the aluminothermic welds

- Filler mould: 60E1 (UIC60) L50
- Filler metal: 60 / 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:


60E1 R260Mn to 60E1 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 042
Number: Annex 1

Kenmerk:
Designation: See AEAT/04/2800046/012,

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	60E1 to 60E1	60E1 to 60E1	
Soort verbinding Joint type		Stomplas Butt weld wide gap (L53)	
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn	
Lasmal type Filler mould type	60E1 (UIC60) L50	60E1 (UIC60) L50	
Lastoevoegmateriaal Filler metal designation	60 / Z90 SoW-5(-E) + 812 Z90 SoW-5 L50(-E)	60 / 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/04/2800046/012	
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® snellasproces SoW-5, versie 21/11/2017
Geometrie Geometrically		Acceptable	
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breuktest Bend/Break test	Zie rapport: AEAT/04/2800046/012	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 Job knowledge
 Acceptabel Acceptable
 Niet beoordeeld Not tested
 Aparte bladen toegevoegd indien vereist JA / Yes
 Append sepearte sheet(s) if required NEE / No

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

Kwalificatie geldig tot: June 2025
Validity of approval until: AEAT/04/2800046/012, d.d. April 2004
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 042** 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:

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

Datum:
Date:

Handtekening:
Signature:

Functie of titel:
Position or title:

Functie of titel:
Position or title:

DR/15/150004.003/006 DR/15/150004.003/012	2 April 2015 30 April 2015				
DR/17/170078.003/007 DR/17/170078.003/012	24 April 2017 31 May 2017				
DR/19/190008.003/006 DR/19/190008.003/013	08 May 2019 12 July 2019				
DR/22/220052.422 DR/22/220052.423	11-05-2022 13-05-2022	