

Certificate

Certification number SP TH 045

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC 54) 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 R350HT

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 045
Number: Annex 1

Kenmerk:
Designation: See DeltaRail/06/60095/006,

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	Thermietlassen (71) Alumino-thermic (71)	Geldigheidsgebied Range of approval	Opmerkingen Remarks
Lasproces Welding process				
Spoorstaaf type Rail type	54E1 to 54E1		54E1 to 54E1	
Soort verbinding Joint type		Stomplas Butt weld wide gap (L50)		
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R350HT		R260Mn to R350HT	
Lasmal type Filler mould type	54E1 (UIC 54) L50		54E1 (UIC 54) 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:		DeltaRail/06/60095/006,	
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	
Visueel Visual			Acceptable	
Geometrie Geometrically			Acceptable	
Ultrasoon onderzoek Ultrasonic testing			Acceptable	
Magnetisch onderzoek Magnetic particle inspection			Not required	
Buig/breuktest Bend/Break test	Zie rapport: See report: DeltaRail/06/60095/006,		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	

Handleiding voor het Thermiet® snelasproces SoW-5, versie 21/11/2017

Vakkennis Job knowledge
 Acceptabel Acceptable
 Niet beoordeeld 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:

DeltaRail/06/60095/006, d.d. November 2006
 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 045** 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/15/150004.003/009 DR/15/150004.003/012	2 April 2015 30 April 2015				
DR/17/170078.003/010 DR/17/170078.003/012	24 April 2017 31 May 2017				
DR/19/190008.003/009 DR/19/190008.003/013	08 May 2019 12 July 2019				
DR/22/220052.452 DR/22/220052.453	11-05-2022 13-05-2022				