

Certificate

Certification number SP TH 046

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC 54) L50
- Filler metal: 54 / Z120 SoW-5(-E) + 812 / Z120 SoW5 L50(-E)

produced by:

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

has been approved for wide gap (L50) 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 : 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 046
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 wide gap (L50)	
Basismateriaal groep(en) Parent metal group(s)	R350HT to R350HT	R350HT to R350HT	
Lasmal type Filler mould type	54E1 (UIC 54) L50	54E1 (UIC 54) L50	
Lastoevoegmateriaal Filler metal designation	54 / Z120 SoW-5(-E) + 812 / Z120 SoW5 L50(-E)	54 / Z120 SoW-5(-E) + 812 / Z120 SoW5 L50(-E)	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a	n.v.t. n.a	
Overige middelen Auxiliaries			
Lasmachine/Bedieners identificatie Welding machine/Operators identification	Zie rapport: See report:	DeltaRail/12/110531/006	
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	
Geometrie Geometrically		Acceptable	Handleiding voor het Thermiet® snellaspasproces SoW-5, versie 21/11/2017
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breektest 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	
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 separate 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:

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

Datum:
Date: 19-05-22

Handtekening:
Signature:

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

Verlenging
Prolongation

Nummer:
Number: **SP TH 046** 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/15/150004.003/010 DR/15/150004.003/012	2 April 2015 30 April 2015				
DR/17/170078.003/011 DR/17/170078.003/012	24 April 2017 31 May 2017				
DR/19/190008.003/010 DR/19/190008.003/013	08 May 2019 12 July 2019				
DR/22/220052.462 DR/22/220052.463	11-05-2022 13-05-2022	