

Certificate

Certification number SP TH 052

This is to certify that the aluminothermic welds

- Filler mould: 60E1 / E2 SoW-5
- Filler metal: 60 / Z90 SoW-5-E

produced by:

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

has been approved for normal gap butt joints in:

60E1 R260 to 60E1 R350HT

in accordance with the specification RLN00451-2 (2021) & EN 14730-1 (2017).

Details are mentioned in annex 1 and 2.

Original Approval : December 2018
Current Certificate : December 2021
Certificate Expiry* : June 2025

On behalf of DEKRA Rail

ir. A.J.P. Verweij
Manager Certification

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

* Validity period of this certificate has been extended for an additional 6 months to ensure the evaluation of this certificate coincides with prolongation of other Thermit certificates by Elektro Thermit GmbH.



Welding Qualification Approval Record – Certificate

Nummer: SP TH 052
Number: Annex 1

Kenmerk:
Designation: See DR/19/180179/002
DR/19/180470/002

Keuringsinstantie:
Test body: DEKRA Rail B.V.

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

Datum van uitgifte:
Date of issue: December 2021

Adres:
Address: Chemiestraße 24
D-06132 Halle (Saale), Germany

	Details van de proefas Weld test details	Geldigheidsgebied Range of approval	
Lasproces Welding process		Thermietlassen (71) Alumino-thermic (71)	
Spoorstaaf type Rail type	60E1 to 60E1	60E1, 60E2	
Soort verbinding Joint type		Stompllas Butt weld normal gap	
Basismateriaal groep(en) Parent metal group(s)	R260 to R350HT	R260 to R350HT	
Lasmal type Filler mould type	60E1 / E2 SoW-5	60E1 / E2 SoW-5	
Lastoevoegmateriaal Filler metal designation	60 / Z90 SoW-5-E	60 / Z90 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	DR/19/180179/002 DR/19/180470/002	
Lasmachine/Bediens identificatie Welding machine/Operators identification			
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	<p>Tests based on EN14730-1:2017, except internal hardness which is based on RLN00127, version 005 (see DR/19/180470/002). NOTE: RLN00127 is superseded by RLN00451-2</p> <p>Handleiding voor het Thermiet® snellasp proces, SoW-5, versie 21/11/2017</p>
Geometrie Geometrically		Niet vereist Not required	
Ultrasoon onderzoek Ultrasonic testing		Niet vereist Not required	
Magnetisch onderzoek Magnetic particle inspection		Niet vereist Not required	
Buig/breuktest Bend/Break test	Zie rapport: See report: DR/19/180179/002 DR/19/180470/002	Acceptable	
Vermoelingsproef Fatigue test		Niet vereist Not required	
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro- examination		Niet vereist Not required	
Mirco-onderzoek Micro-examination		Niet vereist Not required	
Chemische analyse Chemical analysis		Niet vereist 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: DR/19/180179/002
Additional information is available on: See report DR/19/180470/002 d.d. 07-11-2019
DR/19/170307/008 (Smart Weld Jet) d.d. 03-04-2019

Kwalificatie geldig tot: June 2025
Validity of approval until:

Datum: 05-04-2022
Handtekening:
Date: 05-04-2022 Signature:



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

