Certificate

Certification number SP AF 024

This is to certify that the flash butt welds produced by the stationiare flash butt welding machine: the Schlatter Type GAAS 80/700, Number AS1.9034 2875 of, of

voestalpine Rail Center Duisburg GmbH
Duisburg, Germany

has been approved for butt joints in:

54E1 R260Mn to 54E1 R260Mn

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

Original Approval	:	June 2004
Current Certificate	:	May 2022
Certificate Expiry	:	May 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 AF 024
Number: Annex 1

Kenmerk:
Designation: See AEAT/04/3600194/004

Keuringsinstantie:
Test body: DEKRA Rail bv

Opdrachtgever:
Employer: voestalpine Rail Center Duisburg GmbH

Datum van uitgifte:
Date of issue: May 2022

Adres:
Address: **Lintorfer Waldweg 501a**
Place: D-47269 Duisburg, Germany

	Details van de proeflas Weld test details	Geldigheidsgebied Range of approval	
Lasproces Welding process		**Afbrandstuiklassen (241)** Flash-butt welding (241)	
Spoorstaaf type Rail type	54E1 to 54E1		
Soort verbinding Joint type		**Stuiklas** Butt weld	
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn	
Lasmachine fabrikant Welding machine manufacturer	the Schlatter	the Schlatter	
Lasmachine identificatie Welding machine identification			
Machine type Machine type	the Schlatter Type GAAS 80/700	the Schlatter Type GAAS 80/700	
Machine nummer Machine number		Number AS1.9034 2875 of	
Lasmachine/Bedieners identificatie Welding machine/Operators identification	Zie rapport: See report:	AEAT/04/3600194/004	
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		Acceptabel Acceptable	Upper side of the foot grinded
Geometrie Geometrically		Acceptabel Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Acceptabel Acceptable	
Penetrant Dye penetrant		Niet vereist Not required	
Buig/breektest Bend/Break test	Zie rapport: See report: AEAT/04/3600194/004	Acceptabel Acceptable	
Vermoeiingsproef Fatigue test		Acceptabel Acceptable	
Hardheidsmetingen Hardness measurements		Acceptabel Acceptable	
Macro-onderzoek Macro- examination		Acceptabel Acceptable	
Mirco-onderzoek Micro-examination		Acceptabel Acceptable	
Aanvullende beproevingen Additional tests		Acceptabel Acceptable	

Vakkennis ☐ **Acceptabel** ■ **Niet beoordeeld**
Job knowledge Acceptable Not tested

Aparte bladen toegevoegd indien vereist
Append seperate sheet(s) if required
■ **JA** / Yes
☐ **NEE** / No

Aanvullende informatie beschikbaar op
Additional information is available on
Zie rapport:
See report, AEAT/04/3600194/004, d.d. June 2004

Kwalificatie geldig tot: May 2025
Validity of approval until:

Datum:
Date:

Handtekening:
Signature:

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

Verlenging
Prolongation

Nummer
Number SP AF 024 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
DeltaRail/06/60028/030 DeltaRail/07/60028/098	12 December 2006 14 July 2007	
DeltaRail/09/80370/014/001 DeltaRail/09/80370/014/002	23 January 2009 5 March 2009	
DeltaRail/11/110165.003/001 DeltaRail/11/110165.003/002	24 February 2011 8 April 2011	
Plurel/13/130013.005/001 Plurel/13/130013.005/002	7 May 2013 21 June 2013	
DR/15/150004.006/001 DR/15/150004.006/002	20 April 2015 01 June 2015	
DR/17/170078.007.001 DR/17/170078.007.002	27 February 2017 14 April 2017	

Herkwalificatie rapportnummer Re-qualification report number	**Datum** Date	**Handtekening** Signature **Functie of titel** Position or title
Dokument: Duisburg DR-19-190008.009-001	07 March 2019 08 May 2019	
DR/22/220001.005.002 DR/22/220001.005.003	12 May 2022 19 May 2022	DEKRA E. Groen IWE-1979