

# Certificate

**Certification number SP TH 043**

This is to certify that the aluminothermic welds

- Filler mould: 46E3 (NP46) L50
- Filler metal: 46 / 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:

**46E3 R260Mn to 46E3 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 043  
Number: Annex 1

**Kenmerk:**  
Designation: See AEAT/04/3600263/010

**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	46E3 to 46E3		46E3 to 46E3	
Soort verbinding Joint type		Stomplas Butt weld wide gap (L50)		
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn		R260Mn to R260Mn	
Lasmal type Filler mould type	46E3 (NP46) L50		46E3 (NP46) L50	
Lastoevoegmateriaal Filler metal designation	46 / Z90 SoW-5(-E) + 812 / Z90 SoW-5 L50(-E)		46 / 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/04/3600263/010	
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			Acceptabel	Handleiding voor het Thermiet® snellaspasproces SoW-5, versie 21/11/2017
Geometrie Geometrically			Acceptabel	
Ultrasoon onderzoek Ultrasonic testing			Acceptabel	
Magnetisch onderzoek Magnetic particle inspection			Niet vereist	
Buig/breektest Bend/Break test	Zie rapport: See report: AEAT/04/3600263/010		Acceptabel	
Vermoeingsproef Fatigue test			Acceptabel	
Hardheidsmetingen Hardness measurements			Acceptabel	
Macro-onderzoek Macro-examination			Acceptabel	
Mirco-onderzoek Micro-examination			Acceptabel	
Chemische analyse Chemical analysis			Niet vereist	

Vakkennis  
 Job knowledge  
 Aparte bladen toegevoegd indien vereist  
 Append separate sheet(s) if required  
 Acceptabel  
 Acceptable  
 JA / Yes  
 NEE / No  
 Niet beoordeeld  
 Not tested

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

**Kwalificatie geldig tot:** June 2025  
Validity of approval until:

AEAT/04/3600263/010, d.d. October 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 043** 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/15/150004.003/007 DR/15/150004.003/012	2 April 2015 30 April 2015				
DR/17/170078.003/008 DR/17/170078.003/012	24 April 2017 31 May 2017				
DR/19/190008.003/007 DR/19/190008.003/013	08 May 2019 12 July 2019				
DR/22/220052.432 DR/22/220052.433	11-05-2022 13-05-2022				