Certificate

Certification number SP TH 053

This is to certify that the aluminothermic welds
- Filler mould: 54E1 SoW-5
- Filler metal: 54 / Z120 SoW-5-E

produced by:

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

has been approved for normal gap butt joints in:

54E5 MHH to 54E5 370LHT

in accordance with the specification RLN00451-2 (2021) & EN 14730-1 (2017).
Details are mentioned in annex 1 and 2.

Original Approval	:	July 2019
Current Certificate	:	July 2022
Certificate Expiry	:	July 2025

On behalf of DEKRA Rail

i.a. R.J.P. Mennens

ir. A.J.P Verweij
Manager Certification

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

Welding Qualification Approval Record – Certificate

Nummer: SP TH 053
Number: Annex 1

Kenmerk:
Designation: See DR/19/190272/002

Keuringsinstantie:
Test body: DEKRA Rail B.V.

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

Datum van uitgifte:
Date of issue: June 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	54E5 to 54E5	54E5 to 54E5	
Soort verbinding Joint type	**Stomplas** Butt weld normal gap		
Basismateriaal groep(en) Parent metal group(s)	MHH to 370LHT	MHH to 370LHT	
Lasmal type Filler mould type	54E1 SoW-5	54E1 SoW-5	
Lastoevoegmateriaal Filler metal designation	54 / Z120 SoW-5-E	54 / Z120 SoW-5-E	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a	n.v.t. n.a	
Overige middelen Auxiliarities	Zie rapport: See report:	DR/19/190272/002	
Lasmachine/Bedieners 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	**Prolongation of certificate based on combined results of prodution tests SP TH 020 (R370CrHT) and SP TH 038 (MHH). SP TH 053 is a combination materials (R370CrHT on MHH) with identical Portion.**
Geometrie Geometrically		Niet vereist Not required	
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Acceptable	
Buig/breektest Bend/Break test	Zie rapport: See report: DR/19/190272/002	Acceptable	
Vermoeiingsproef Fatigue test		Acceptable	**Transfer of Ownership confirmed via letter, document number DR/22/220052.533 dd. 31 may 2022**
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro- examination		Acceptable	
Mirco-onderzoek Micro-examination		Acceptable	**Handleiding voor het Thermiet® snellasproces SoW-5, versie 21/11/2017**
Chemische analyse Chemical analysis		Niet vereist Not required	

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

Aparte bladen toegevoegd indien vereist ■ **JA** / Yes
Append seperate 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:

DR/19/190272/002 d.d. 43754
DR/19/170307/008 (Smart Weld Jet) d.d. 03 April 2019

Datum: 30-05-2022
Date:

Handtekening:
Signature :

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

Verlenging
Prolongation

Nummer:
Number: SP TH 053 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/22/220052.202 DR/22/220052.382 DR/22/220052.533	11-05-2022 11-05-2022 31-05-2022	DEKRA			