

# Certificate

## Certification number SP AF 042

This is to certify that the flash butt welds produced by the stationary flash butt welding machine: Schlatter Type GAAS 100/580, Number AS 1.2660.2879, of

**Vossloh Cogifer Kihn  
Rumelange, Luxemburg**

has been approved for butt joints in:

**54E1 R260 to 54E1 R260Mn**

in accordance with the specification EN 14587-1; 2018. Details are mentioned in annex 1 and 2.

Original Approval : April 2017  
Current Certificate : March 2022  
Certificate Expiry : March 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 042  
Number: Annex 1

**Kenmerk:**  
Designation: See DR/17/170111/002

**Keuringsinstantie:**  
Test body: DEKRA Rail bv

**Opdrachtgever:**  
Employer: Vossloh Cogifer Kihn

**Datum van uitgifte:**  
Date of issue: March 2022

**Adres:**  
Address: 17 Rue de l'Usine  
Place: 3754 Rumelange Luxemburg

	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	54E1, 54E5	
Soort verbinding Joint type		Stuiklas Britt weld	
Basismateriaal groep(en) Parent metal group(s)	R260 to R260Mn	R260 to R260Mn	
Lasmachine fabrikant Welding machine manufacturer	Schlatter	Schlatter	
Lasmachine identificatie Welding machine identification	200397	200397	
Machine type Machine type	Schlatter Type GAAS 100/580	Schlatter Type GAAS 100/580	
Machine nummer Machine number	Number AS 1.2660.2879		
Lasmachine/Bedieners identificatie Welding machine/Operators identification	Zie rapport: See report:	DR/17/170111/002	
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	Zie rapport: See report: DR/17/170111/002	Acceptabel Acceptable	De niet afgeschoven lassen moeten rondom geslepen worden en moeten voldoen aan de "upset" eisen uit EN 14587-1.
Geometrie Geometrically		niet acceptabel Not acceptable	De lasgeometrie moet voldoen aan de eisen uit RLN00451-2 & -4.
Magnetisch onderzoek Magnetic particle inspection		Acceptabel Acceptable	The non-irrigated welds shall be ground and shall meet the "upset" requirements of EN 14587-1
Penetrant Dye penetrant		Niet vereist Not required	Upper side of the foot grinded
Buig/breektest Bend/Break test		Acceptabel Acceptable	The weld geometry shall meet the straightness requirements of RLN00451-2 & -4
Vermoeingsproef 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		Niet vereist Not required	

Vakkennis Job knowledge  
 Acceptabel Acceptable  
 JA / Yes  
 NEE / No  
 Aparte bladen toegevoegd indien vereist  
 Append separate sheet(s) if required  
 Aanvullende informatie beschikbaar op  
 Additional information is available on  
 Zie rapport:  
 See report, DR/17/170111/002, d.d. June 09, 2017  
 Kwalificatie geldig tot:  
 Validity of approval until: March 2025

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

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

