

Certificate

Certification number SP AF 044

This is to certify that the flash butt welds produced by the stationary flash butt welding machine Schlatter Type GAAS 80/580, Number AS 1.2653.2804 of

**Vossloh Rail Center GmbH
Hamburg, Germany**

has been approved for butt joints in:


54E1 R260Mn to 54E1 R260Mn

in accordance with the specification RLN00127, version 004, d.d. 01-02-2019. Details are mentioned in annex 1 and 2.

Current Certificate : July 2020
Certificate Expiry : July 2023

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 044
Number: Annex 1

Kenmerk:
Designation: See DR/18/180222/003

Keuringsinstantie:
Test body: DEKRA Rail bv

Opdrachtgever:
Employer: Vossloh Rail Center GmbH

Datum van uitgifte:
Date of issue: July 2020

Adres:
Address: Reller 28
Place: D-21079 Hamburg, 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	54E1/E5 to 54E1/E5	
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	Schlatter	Schlatter	
Lasmachine identificatie Welding machine identification	AS 1.2653.2804	AS 1.2653.2804	
Machine type Machine type	GAAS 80/580	GAAS 80/580	
Machine nummer Machine number		GAAS 80 VRCH	
Lasmachine/Bedieners identificatie Welding machine/Operators identification	Zie rapport: See report:	DR/18/180222/003	
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 foot grinded
Geometrie Geometrically		Acceptabel Acceptable	- One running side only. Running site marked white
Magnetisch onderzoek Magnetic particle inspection		Acceptabel Acceptable	- No pull up straightening as a last straightening action
Penetrant Dye penetrant		Niet vereist Not required	
Buig/breektest Bend/Break test	Zie rapport: See report: DR/18/180222/003	Acceptabel Acceptable	
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
 Niet beoordeeld Not tested
 Aparte bladen toegevoegd indien vereist Append separate sheet(s) if required
 JA / Yes
 NEE / No
 Aanvullende informatie beschikbaar op Additional information is available on Zie rapport: See report, DR/18/180222/003, d.d. September 2018

Kwalificatie geldig tot: July 2023
Validity of approval until:

Datum:
Date: 26-11-20

Handtekening:
Signature:

J.G.M. Jansen
IWE 192

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

