

Certificate

Certification number SP TH 008

This is to certify that the aluminothermic welds

- Filler mould: UIC60 SoW-5
- Filler metal: 60 / Z90 SoW-5(-E)

produced by:

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

has been approved for normal gap butt joints in:

60E1 R260Mn to 60E1 R260Mn

in accordance with the specification:


RLN00451-2, d.d. 01 Oct 2021.

Details are mentioned in annex 1 and 2.

Original Approval : April 2004
Current Certificate : June 2023
Certificate Expiry : June 2026

On behalf of DEKRA Rail


ir. A.J.P. Verweij
Manager Certification


E. Groen
IWT nr.: 1479



Welding Qualification Approval Record – Certificate

Nummer: SP TH 008
Number: Annex 1

Kenmerk:
Designation: See AEAT/04/2800046/012

Keuringsinstantie:
Test body: DEKRA Rail B.V.

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

Datum van uitgifte:
Date of issue: June 2023

Adres:
Address: Chemiestraße 24
D-06132 Halle (Saale), Germany

	Details van de proeflas Weld test details		Geldigheidsgebied Range of approval		Opmerkingen Remarks
Lasproces Welding process	Thermietlassen (71) Alumino-thermic (71)		60E1 to 60E1		
Spoorstaaf type Rail type	60E1 to 60E1		60E1 to 60E1		
Soort verbinding Joint type	Stomplas Butt weld normal gap				
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn		R260Mn to R260Mn		
Lasmal type Filler mould type	UIC60 SoW-5		UIC60 SoW-5		
Lastoevoegmateriaal Filler metal designation	60 / Z90 SoW-5(-E)		60 / Z90 SoW-5(-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/04/2800046/012		
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	↑		Acceptable		Handleiding voor het Thermiet® snellasp proces SoW-5, rev.01 (22 mei 2023)
Geometrie Geometrically	↑		Acceptable		
Ultrasoon onderzoek Ultrasonic testing	↑		Acceptable		
Magnetisch onderzoek Magnetic particle inspection	↑		Not required		
Buig/breektest Bend/Break test	↑		Acceptable		
Vermoeingsproef Fatigue test	↑		Acceptable		
Hardheidsmetingen Hardness measurements	↑		Acceptable		
Macro-onderzoek Macro-examination	↑		Acceptable		
Mirco-onderzoek Micro-examination	↑		Acceptable		
Chemische analyse Chemical analysis	↑		Not required		
	Zie rapport: AEAT/04/2800046/012 See report				

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: AEAT/04/2800046/012 d.d. 38078
 Additional information is available on: See report
 KWALIFICATIE GELDIG TOT: June 2026
 Validity of approval until:

Datum: _____
 Date: _____
 Handtekening: _____
 Signature: _____

 E. Groen IWT nr.: 1479

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:

DeltaRail/06/60028/069 DeltaRail/07/60028/083	12 December 2006 26 January 2007		DR/18/180004.003/002 DR/18/180004.003/011	23 February 2018 29 March 2018	
DeltaRail/08/80370.002/003 DeltaRail/08/80370.002/005	1 April 2008 16 May 2008		DR/20/190224/003 DR/20/190224/011	14 April 2020 15 May 2020	
DeltaRail/10/10234.1.2/002 DeltaRail/10/10234.1.2/003	02 march 2010 29 march 20109		DR/23/230142.082 DR/23/230142.083	02-06-2023 06-06-2023	
DeltaRail/12/110165.018/003 DeltaRail/12/110165.018/006	12 March 2012 20 April 2012				
Plurel/14/130497.003/002 Plurel/14/130497.003/012	08 April 2014 02 June 2014				
DR/16/150541.003/003 DR/16/150541.003/011	29 March 2016 31 May 2016				