

Certificate

Certification number SP TH 011

This is to certify that the aluminothermic welds

- Filler mould: NP46 SoW-5
- Filler metal: 46 / Z90 SoW-5(-E)

produced by:

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

has been approved for normal gap 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 : September 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 011
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: June 2023

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	46E3 to 46E3	46E3 to 46E3	
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	NP46 SoW-5	NP46 SoW-5	
Lastoevoegmateriaal Filler metal designation	46 / Z90 SoW-5(-E)	46 / 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/04/3600263/010	
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	Acceptable criteria Acceptation criteria	Acceptabel / Niet vereist Acceptable / Not required	Opmerkingen Remarks
Aard van de beproeving Type of testing			
Visueel Visual		Acceptable	Handleiding voor het Thermiet snellasproces 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	Zie rapport: AEAT/04/3600263/010	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	

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: Zie rapport:
Additional information is available on: See report

Kwalificatie geldig tot: June 2026
Validity of approval until:

AEAT/04/3600263/010 d.d. 38261
DR/19/170307/008 (Smart Weld Jet) d.d. 03 April 2019

Datum:
Date:
06-06-2023

Handtekening:
Signature:

E. Groen IWT nr.: 1479

Verlenging
Prolongation

Nummer:
Number: SP TH 011 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:

DeltaRail/06/60028/072 DeltaRail/07/60028/083	12 December 2006 26 January 2007		DR/18/180004.003/003 DR/18/180004.003/011	23 February 2018 29 March 2018	
DeltaRail/08/80370.007/004 DeltaRail/08/80370.007/005	18 September 2008 10 Oktober 2008		DR/20/190224/004 DR/20/190224/011	14 April 2020 15 May 2020	
DeltaRail/10/10234.011/001 DeltaRail/10/10234.011/002	11 August 2010 8 September 2010		DR/23/230142.112 DR/23/230142.113	02-06-2023 06-06-2023	
DeltaRail/12/110165.029/001 DeltaRail/12/110165.029/002	1 August 2012 10 September 2012				
Plurel/14/130497.003/006 Plurel/14/130497.003/012	08 April 2014 02 June 2014				
DR/16/150541.003/004 DR/16/150541.003/011	29 March 2016 31 May 2016				