

Certificate

Certification number SP TH 012

This is to certify that the aluminothermic welds

- Filler mould: SoW-5 - L75
- Filler metal: 54 / Z90 SoW-5(-E) +1112 / Z90 SoW-5 L75

produced by:

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

has been approved for wide gap (L75) butt joints in:

54E1 R260Mn to 54E1 R260Mn

in accordance with the specification:

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

Details are mentioned in annex 1 and 2.


Original Approval : December 2004

Current Certificate : June 2023

Certificate Expiry : June 2026

On behalf of DEKRA Rail


in. A.J.P. Verweij
Manager Certification


E. Groen
IWT nr.: 1479



Welding Qualification Approval Record – Certificate

Nummer: SP TH 012
Number: Annex 1

Kenmerk:
Designation: See AEAT/04/3600263/013

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	54E1 to 54E1	54E1 to 54E1	
Soort verbinding Joint type		Stomplas Butt weld wide gap (L75)	
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn	
Lasmal type Filler mould type	SoW-5 - L75	SoW-5 - L75	
Lastoevoegmateriaal Filler metal designation	54 / Z90 SoW-5(-E) + 1112 / Z90 SoW-5 L75	54 / Z90 SoW-5(-E) + 1112 / Z90 SoW-5 L75	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a.	n.v.t. n.a.	
Overige middelen Auxiliaries	Zie rapport: See report.	AEAT/04/3600263/013	
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	Opmerkingen Remarks
Visueel Visual		Acceptable	Handleiding voor het Thermiet® snelasproces 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: See report. AEAT/04/3600263/013	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: June 2026

AEAT/04/3600263/013 d.d. 38322
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 door beoordelaar met 3 jaar
Authorized prolongation for the following 3 years

Herkwalificatie
rapportnummer:
Re-qualification
report number:

Datum:
Date:

Handtekening:
Signature:

Herkwalificatie
rapportnummer:
Re-qualification
report number:

Datum:
Date:

Handtekening:
Signature:

Functie of titel:
Position or title:

Functie of titel:
Position or title:

DeltaRail/06/60028/073 DeltaRail/07/60028/083	12 December 2006 26 January 2007		DR/20/190224/005 DR/20/190224/011	14 April 2020 15 May 2020	
DeltaRail/10/10234.014/001 DeltaRail/10/10234.014/005	3 November 2010 8 December 2010		DR/23/230142.122 DR/23/230142.123	02-06-2023 06-06-2023	
DeltaRail/12/110165.032/001 DeltaRail/12/110165.032/006	18 Oktober 2012 21 November 2012				
Plurel/14/130497.003/007 Plurel/14/130497.003/012	08 April 2014 02 June 2014				
DR/16/150541.003/005 DR/16/150541.003/011	29 March 2016 31 May 2016				
DR/18/180004.003/004 DR/18/180004.003/011	23 February 2018 29 March 2018				