

# Certificate

**Certification number SP TH 037**

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC 54) SoW-5
- Filler metal: 54 / Z120 SoW-5(-E)

produced by:

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

has been approved for normal gap butt joints in:

**54E5 MHH to 54E5 MHH**

in accordance with the specification:


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

Details are mentioned in annex 1 and 2.

Original Approval : May 2012  
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 037  
Number: Annex 1

**Kenmerk:**  
Designation: See DeltaRail/12/110531/004

**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	54E5 to 54E5	54E5 to 54E5	
Soort verbinding Joint type		Stomplas Butt weld normal gap	
Basismateriaal groep(en) Parent metal group(s)	MHH to MHH	MHH to MHH	
Lasmal type Filler mould type	54E1 (UIC 54) SoW-5	54E1 (UIC 54) SoW-5	
Lastoevoegmateriaal Filler metal designation	54 / Z120 SoW-5(-E)	54 / Z120 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	DeltaRail/12/110531/004	
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	Investigation Report - P03/11 Rev. 1- DeltaRail/11/110531/00 2
Geometrie Geometrically		Acceptable	September 2011, September 2011
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breuktest Bend/Break test	Zie rapport: See report: DeltaRail/12/110531/004	Acceptable	Handleiding voor het Thermiet snellasproces SoW-5, rev.01 (22 mei 2023)
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  
 JA / Yes  
 Aparte bladen toegevoegd indien vereist Append separate sheet(s) if required  NEE / No

Aanvullende informatie beschikbaar op: Zie rapport:  
Additional information is available on: See report

Kwalificatie geldig tot: June 2026  
Validity of approval until: DeltaRail/12/110531/004 d.d. July 2012  
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 037** 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:

**Herkwalificatie  
rapportnummer:**  
Re-qualification  
report number:

**Datum:**  
Date:

**Handtekening:**  
Signature:

**Functie of titel:**  
Position or title:

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Position or title:

Plurel/14/130497.003/005 Plurel/14/130497.003/012	08 April 2014 02 June 2014				
DR/16/150541.003/010 DR/16/150541.003/011	29 March 2016 31 May 2016				
DR/18/180004.003/009 DR/18/180004.003/011	23 February 2018 29 March 2018				
DR/20/190224/010 DR/20/190224/011	14 April 2020 15 May 2020				
DR/23/230142.372 DR/23/230142.373	02-06-2023 06-06-2023				