

Certificate

Certification number SP TH 048

This is to certify that the aluminothermic welds

- Filler mould: 60E1 / E2 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 R350HT

in accordance with the specification:

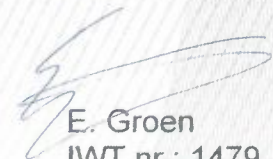
RLN00451-2, d.d. 01 Oct 2021.

Details are mentioned in annex 1 and 2.

Original Approval : May 2018
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 048
Number: Annex 1

Kenmerk:
Designation: See DR/18/170001/005

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	60E1 to 60E1	60E1, 60E2	
Soort verbinding Joint type		Stomplas Butt weld normal gap	
Basismateriaal groep(en) Parent metal group(s)	R260Mn to R350HT	R260Mn to R350HT	
Lasmal type Filler mould type	60E1 / E2 SoW-5	60E1 / E2 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	DR/18/170001/005	
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	Acceptable criteria Acceptation criteria	Acceptabel / Niet vereist Acceptable / Not required	Opmerkingen Remarks
Visueel Visual		Acceptable	Handleiding voor het Thermit® snellasproces SoW-5, rev.01/ (22 mei 2023)
Geometrie Geometrically		Not required	
Ultrasoon onderzoek Ultrasonic testing		Not required	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breektest Bend/Break test	Zie rapport: DR/18/170001/005	Acceptable	
Vermoeingsproef Fatigue test		Not required	
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro-examination		Not required	
Mirco-onderzoek Micro-examination		Not required	
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:

DR/18/170001/005 d.d. 18 May 2018

Datum:
Date:
06-06-2023

Handtekening:
Signature:

 
E. Groen
IWT 1479

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