

Certificate

Certification number SP TH 049

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 R370CrHT

in accordance with the specification:

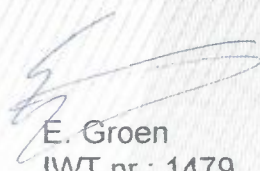
RLN00451-2, d.d. 01 Oct 2021.

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 049
Number: Annex 1

Kenmerk:
Designation: See DR/18/170001/006

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 R370CrHT	R260Mn to R370CrHT	
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/18/170001/006	
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	Acceptable / Niet vereist Acceptable / Not required	Opmerkingen Remarks
Visueel Visual		Acceptable	Handleiding voor het Thermiet® snellaspasproces 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/breuktest Bend/Break test	Zie rapport: DR/18/170001/006	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
 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:
Additional information is available on: See report

Kwalificatie geldig tot: June 2026
Validity of approval until:

DR/18/170001/006 d.d. 18 May 2018

Datum:
Date:
06-06-2023

Handtekening:
Signature:



E. Groen IWT nr.: 1479

