

# Certificaat

Document nr.: DR/24/240020.1301.9001

## Certificate: SP AF 049

This is to certify that the flash butt welds produced by the flash butt welding machine: Plasser & Theurer Type: APT 1500 R-L, number 6877, of

**SWIETELSKY Rail Benelux B.V.,**  
Oisterwijk, the Netherlands

has been approved for butt joints in:

**54E1 R260Mn to 54E1 R260Mn**

in accordance with the specification RLN00451-2 d.d. 01-10-2021 & EN 13674 - 1. Details are mentioned in annex 1 and 2.

Original Approval : 14 Oktober 2020  
Current Certificate : 01 July 2024  
Certificate Expiry : 30 Juni 2027

Namens DEKRA Rail

  
E. Groen  
IWT 1479

# Welding Qualification Approval Record: SP AF 049

Doc.Nr.: DR/24/240020.1301.9001  
Doc. Nr.:

**Kenmerk:** See: DR/20/200274/004  
Designation:

**Datum van uitgifte:** 01 July 2024  
Date of issue:

**Opdrachtgever:** SWIETELSKY Rail Benelux B.V.  
Client:

**Keuringsinstantie:** DEKRA Rail BV  
Examining body:

**Adres:** Laarakkerweg 11  
Address: 5061 JR Oisterwijk, the Netherlands



	Details van de proeflas Weld test details	Geldigheidsgebied Range of approval	
<b>Lasproces</b> Welding process	<b>Afbrandstuiklassen (241)</b> Flash-butt welding (241)		
<b>Soort verbinding</b> Joint type	<b>Stomp las</b> Butt weld		
<b>Spoorstaaf type</b> Rail type	54E1 to 54E1	54E1 to 54E1	
<b>Basismateriaal groep(en)</b> Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn	
<b>Lasmachine fabrikant</b> Welding machine manufacturer	Plasser & Theurer		
<b>Lasmachine identificatie</b> Welding machine identification	6877		
<b>Machine type</b> Machine type	Plasser & Theurer Type: APT 1500 R-L		
<b>Machine nummer</b> Machine number	number 6877		
<b>Lasmachine/Bedieners identificatie</b> Welding machine/Operators identification	See: DR/20/200274/004		
<b>Laspositie</b> Welding position	<b>n.v.t.</b> n.a	<b>n.v.t.</b> n.a	
<b>Smeltbadondersteuning</b> Backing	<b>n.v.t.</b> n.a	<b>n.v.t.</b> n.a	
<b>Aard van de beproeving</b> Type of test	<b>Acceptatie criteria</b> Acceptation criteria	<b>Resultaat</b> Result	<b>Opmerkingen</b> Remarks
<b>Visueel</b> Visual		Acceptabel Acceptable	
<b>Geometrie</b> Geometrically		Acceptabel Acceptable	
<b>Magnetisch onderzoek</b> Magnetic particle inspection		Acceptabel Acceptable	
<b>Ultrasoon</b> Ultrasonic		Niet vereist Not required	
<b>Buig/breektest</b> Bend/Break test		Acceptabel Acceptable	
<b>Vermoeingsproef</b> Fatigue test		Niet vereist Not required	
<b>Hardheidsmetingen</b> Hardness measurements		Niet vereist Not required	
<b>Macro-onderzoek</b> Macro-examination		Acceptabel Acceptable	
<b>Mirco-onderzoek</b> Micro-examination		Acceptabel Acceptable	
<b>Aanvullende beproevingen</b> Additional tests		Niet vereist Not required	

Verlenging door beoordelaar met 3 jaar. Zie ommezijde  
Authorized prolongation for the following 3 years, see reverse side

**Aparte bladen toegevoegd indien vereist**  
Append separate sheet(s) if required

**JA**  **NEE**  
Yes No

**Aanvullende informatie beschikbaar op:**  
Additional information is available on:

**Zie rapport:** DR/20/200274/004, dd.9 November 2020  
See report:

**Datum:** 11-07-2024  
Date:

**Handtekening:** E. Groen  
Signature: IWT 1479



