

Certificaat

Document nr.: 240020.150101.90

SP TH 022

This is to certify that the aluminothermic welds

- Filler mould: 54E1 LP.2S (SmF-P / SoWoS-P)
- Filler metal: 65L R350 (HT/LHT)

manufactured by:

Pandrol SpA
Raimes, France

applicant:

Alom B.V.
Arkel, The Netherlands

has been approved for normal gap butt joints in:

54E1 R350HT to 54E1 R350HT

in accordance with the specification:

EN 14730-1, d.d. March 2017.

Details are mentioned in annex 1 and 2.

Original Approval : June 2008
Current Certificate : december 2024
Certificate Expiry : december 2027

On behalf of DEKRA Rail


E. Groen
IWT nr.: 1479

Welding Qualification Approval Record

Document Nr.: 240020.150101.90
Number:

Kenmerk: See DeltaRail/08/70279/004
Designation:

Certificaat: SP TH 022
Certificate:

Oprichtgever: Pandrol SpA
Client:: applicant:

Keuringsinstantie: DEKRA Rail B.V.
Test body:

Adres: ZI du Bas Pré – BP 9 59590 Raimés, France
Address:

Kwalificatie geldig tot: december 2027
Validity until:

	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 normal gap		
Basismateriaal groep(en) Parent metal group(s)	R350HT to R350HT	R350HT to R350HT	
Lasmal type Filler mould type	54E1 LP.2S (SmF-P / SoWoS-P)	54E1 LP.2S (SmF-P / SoWoS-P)	
Lastoevoegmateriaal Filler metal designation	65L R350 (HT/LHT)	65L R350 (HT/LHT)	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a	n.v.t. n.a	
Overige middelen Auxiliaries	Zie rapport: See report:	DeltaRail/08/70279/004	
Bedieners identificatie Welding Operators identification			
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	Werkinstructie: SkV / SP / LP voor vignole- en groefrail, voorbreedte 25 / 50 / 70 strand.
Geometrie Geometrically		Acceptable	
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breektest Bend/Break test		Acceptable	
Vermoeiingsproef Fatigue test		Not required	
Hardheidsmetingen Hardness measurements		Acceptable	
Macro-onderzoek Macro- examination		Acceptable	
Mirco-onderzoek Micro-examination		Acceptable	
Chemische analyse Chemical analysis		Not required	

Vakkennis Acceptabel Niet beoordeeld
Job knowledge Acceptable Not tested

Aparte bladen toegevoegd indien vereist JA NEE
Append separate sheet(s) if required Yes No

Aanvullende informatie beschikbaar op: Zie rapport: DeltaRail/08/70279/004 d.d. June 2008
Additional information is available on: See report

Datum: 24-01-2025
Date:

Handtekening:
Signature:

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Verlenging door beoordelaar met 3 jaar Authorized prolongation for the following 3 years

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

Datum:
 Date:

Handtekening:
 Signature:
Functie of titel:
 Position or title:

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DeltaRail/10/10234.010/001 DeltaRail/10/10234.010/005	30 June 2010 27 September 2010				
DeltaRail/12/110165.023/001 DeltaRail/11/110165.023/003	01 May 2012 07 June 2012				
Plurel/14/130497.004/008 Plurel/14/130497.004/011	04 august 2014 03 September 2014				
DR/15/150541.004/004 DR/15/150541.004/006	1 April 2016 18 April 2016				
DR/21/210089/00x	30-7-2021				
240020.150101.25 240020.150101.27	december 2024				