

# Certificaat

Document nr.: 240020.150103.90

## SP TH 026

This is to certify that the aluminothermic welds

- Filler mould: 54E1 LP.2S (SmF-P / SoWoS-P)
- Filler metal: 65L R260

manufactured by:

**Pandrol GmbH**  
**Raimes, France**

applicant:

**Alom B.V.**  
**Arkel, The Netherlands**

has been approved for normal gap butt joints in:

**54E1 R260Mn to 54E1 R260Mn**

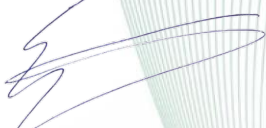
in accordance with the specification:

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

Details are mentioned on page 2 and 3.

Original Approval : February 2009  
Current Certificate : december 2024  
Certificate Expiry : december 2027

On behalf of DEKRA Rail

  
E. Groen  
IWT nr.: 1479

# Welding Qualification Approval Record

Document Nr.: 240020.150103.90  
Number:

**Kenmerk:** See DeltaRail/09/70279/011  
Designation:

**Certificaat:** SP TH 026  
Certificate:

**Oprichtgever:** Pandrol GmbH  
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:

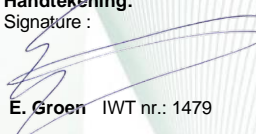
	Details van de proeflas Weld test details	Geldigheidsgebied Range of approval	
<b>Lasproces</b> Welding process	<b>Thermietlassen (71)</b> Alumino-thermic (71)		
<b>Spoorstaaf type</b> Rail type	54E1 to 54E1	54E1 to 54E1	
<b>Soort verbinding</b> Joint type	<b>Stomplas</b> Butt weld normal gap		
<b>Basismateriaal groep(en)</b> Parent metal group(s)	R260Mn to R260Mn	R260Mn to R260Mn	
<b>Lasmal type</b> Filler mould type	54E1 LP.2S (SmF-P / SoWoS-P)	54E1 LP.2S (SmF-P / SoWoS-P)	
<b>Lastoevoegmateriaal</b> Filler metal designation	65L R260	65L R260	
<b>Type beschermgas / poeder</b> Shielding gas / flux	n.v.t. n.a	n.v.t. n.a	
<b>Overige middelen</b> Auxiliaries	<b>Zie rapport:</b> See report:	<b>DeltaRail/09/70279/011</b>	
<b>Bedieners identificatie</b> Welding Operators identification			
<b>Laspositie</b> Welding position	n.v.t. n.a	n.v.t. n.a	
<b>Voorbehandeling</b> Gouging / backing	n.v.t. n.a	n.v.t. n.a	
<b>Aard van de beproeving</b> Type of testing	<b>Acceptatie criteria</b> Acceptation criteria	<b>Acceptabel / Niet vereist</b> Acceptable / Not required	<b>Opmerkingen</b> Remarks
<b>Visueel</b> Visual	↑ ↓	Acceptable	<b>Werkinstructie: SkV / SP / LP voor vignole- en groefrail, voegbreedte 25 / 50 / 70, stand: Jan 2021</b>  <b>Aanvullende vermoeiingstesten uitgevoerd op lasverbinding met 6mm STEP.</b>
<b>Geometrie</b> Geometrically		Acceptable	
<b>Ultrasoon onderzoek</b> Ultrasonic testing		Acceptable	
<b>Magnetisch onderzoek</b> Magnetic particle inspection		Not required	
<b>Buig/breektest</b> Bend/Break test		Acceptable	
<b>Vermoeiingsproef</b> Fatigue test		Acceptable	
<b>Hardheidsmetingen</b> Hardness measurements		Acceptable	
<b>Macro-onderzoek</b> Macro- examination		Acceptable	
<b>Mirco-onderzoek</b> Micro-examination	Not required		
<b>Chemische analyse</b> 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/09/70279/011 d.d. February 2009  
Additional information is available on: See report

**Datum:**  
Date: 28-01-2025

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

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Valid until: december 2027

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

**Datum:**  
Date:

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

DeltaRail/11/110165.002/001 DeltaRail/11/110165.002/002	22 February 2011 25 March 2011				
Plurel/13/130013.003/001 Plurel/13/130013.003/002	01 February 2013 19 February 2013				
Plurel/15/150004.004/001 Plurel/15/150004.004/005	22 January 2015 09 March 2015				
DR/16/150541.004/014 DR/17/150541.004/017	4 January 2017 6 February 2017				
DR/21/210089/00x	30-7-2021				
240020.150103.25 240020.150103.27	december 2024	