

Certificaat

Document nr.: 250006.170119.90

SP TH 019

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC 54) SoW-5
- Filler metal: 54 / Z90 SoW-5(-E)

produced by:

Elektro-Thermit GmbH & Co. KG
Halle (Saale), Germany

has been approved for normal gap butt joints in:

54E5 R260Mn to 54E5 370CrHT

in accordance with the specification:

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

Details are mentioned in annex 1 and 2.

Original Approval : November 2006
Current Certificate : June 2025
Certificate Expiry : June 2028

On behalf of DEKRA Rail

G-J Los
IWE nr.: 554



Welding Qualification Approval Record

Document Nr.: 250006.170119.90
Number:

Kenmerk: See DeltaRail/06/60095/002
Designation:

Certificaat: SP TH 019
Certificate:

Oprichtgever: Elektro-Thermit GmbH & Co. KG
Client:

Keuringsinstantie: DEKRA Rail B.V.
Test body:

Adres: Chemiestraße 24 D-06132 Halle (Saale), Germany
Address:

Kwalificatie geldig tot: June 2028
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	54E5 to 54E5	54E1_E5 to 54E1_E5	
Soort verbinding Joint type	Stomplas Butt weld normal gap		
Basismateriaal groep(en) Parent metal group(s)	R260Mn to 370CrHT	R260Mn to 370CrHT	
Lasmal type Filler mould type	54E1 (UIC 54) SoW-5	54E1 (UIC 54) SoW-5	
Lastoevoegmateriaal Filler metal designation	54 / Z90 SoW-5(-E)	54 / 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:	DeltaRail/06/60095/002	
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	Handleiding voor het Thermiet® snellasproces SoW- 5 versie 24/11/2017
Geometrie Geometrically		Acceptable	
Ultrasoon onderzoek Ultrasonic testing		Acceptable	
Magnetisch onderzoek Magnetic particle inspection		Not required	
Buig/breektest Bend/Break test		Acceptable	
Vermoeiingsproef Fatigue test		Acceptable	
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/06/60095/002 d.d. november 2006
Additional information is available on: See report DR/19/170307/008 (Smart Weld Jet) d.d. 03 April 2019

Datum: **Handtekening:**
Date: 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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rapportnummer:**
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DeltaRail/08/80370.007/002 DeltaRail/08/80370.007/005	18 September 2008 10 Oktober 2008		DR/17/170078.003.002 DR/17/170078.003.012	24 April 2017 31 May 2017	
DeltaRail/09/80370.021/001 ET6/1045054888 DeltaRail/10/80370.021/002	14 December 2009 28 August 2008 22 January 2010		DR/19/190008.003/001 DR/19/190008.003/013	08 May 2019 12 July 2019	
DeltaRail/11/110165.014/001 DeltaRail/11/110165.014/002	4 September 2011 17 December 2011		DR/22/220052.192 DR/22/220052.193	11-05-2022 13-05-2022	
Investigation Report -P03/11 Rev. 1-, DeltaRail/11/110531/002, DeltaRail/12/110531/007	September 2011, September 2011, July 2012		250006.170119.25 250006.170119.27	12-06-2025 22-07-2025	
Plurel/13/130143/003 Plurel/13/130143/007	6 June 2013, 14 August 2013				
DR/15/150004.003/001 DR/15/150004.003/012	2 April 2015 30 April 2015				