

Certificaat

Document nr.: 250006.170120.90

SP TH 020

This is to certify that the aluminothermic welds

- Filler mould: 54E1 (UIC 54) SoW-5
- Filler metal: 54 / Z120 SoW-5(-E)

produced by:

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

has been approved for normal gap butt joints in:

54E5 370CrHT 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.: 250006.170120.90
Number:

Kenmerk: See DeltaRail/06/60095/003
Designation:

Certificaat: SP TH 020
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)	370CrHT to 370CrHT	R370CrHT to R370CrHT	
Lasmal type Filler mould type	54E1 (UIC 54) SoW-5	54E1 (UIC 54) SoW-5	
Lastoevoegmateriaal Filler metal designation	54 / Z120 SoW-5(-E)	54 / Z120 SoW-5(-E)	
Type beschermgas / poeder Shielding gas / flux	n.v.t. n.a	n.v.t. n.a	
Overige middelen Auxiliaries			
Bedieners identificatie Welding Operators identification	Zie rapport: See report:	DeltaRail/06/60095/003	
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® snelasproces SoW- 5, versie 21/11/2017
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
Job knowledge Acceptable

Niet beoordeeld
Not tested

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

NEE
No

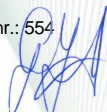
Aanvullende informatie beschikbaar op: Zie rapport:
Additional information is available on: See report

DeltaRail/06/60095/003 d.d. november 2006
DR/19/170307/008 (Smart Weld Jet) d.d. 03 April 2019

Datum:
Date:

Handtekening:
Signature :

G-J Los IWE nr.: 554



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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/08/80370.007/003 DeltaRail/08/80370.007/005	18 September 2008 10 Oktober 2008		DR/17/170078.003.003 DR/17/170078.003.012	24 April 2017 31 May 2017	
DeltaRail/09/80370.019/001 ET6/1045054888 DeltaRail/09/80370.019/002	10 August 2009 9 September 2009 28-8-2008		DR/19/190008.003/002 DR/19/190008.003/013	08 May 2019 12 July 2019	
DeltaRail/11/110165.009/001 DeltaRail/11/110165.009/002	07 July 2011 17 August 2011		DR/22/220052.202 DR/22/220052.203	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		250006.170120.25 250006.170120.27	12-06-2025 22-07-2025	
Plurel/13/130143/004 Plurel/13/130143/007	6 June 2013, 14 August 2013				
DR/15/150004.003/002 DR/15/150004.003/012	2 April 2015 30 April 2015				