

Certificate

Certification number SP AF 043

This is to certify that the flash butt welds produced by the stationary flash butt welding machine Schlatter Type GAAS 80/580, Number AS 1.2653.2804 of

Vossloh Rail Center GmbH Hamburg, Germany

has been approved for butt joints in:


54E1 R350HT to 54E1 R350HT

in accordance with the specification EN 14587-1, d.d. June 2007. Details are mentioned in annex 1 and 2.

Original Approval : July 2018
Current Certificate : July 2018
Certificate Expiry : July 2020

On behalf of DEKRA Rail


ir. A.J.P. Verweij
Manager Certification


ing. J.G.M. Jansen
IWE nr.: 192

Welding Qualification Approval Record – Certificate

Number: SP AF 043
Number: Annex 1

Kenmerk:
Designation: See DR/18/180222/002

Keuringsinstantie:
Test body: DEKRA Rail bv

Opdrachtgever:
Employer: Vossloh Rail Center GmbH

Datum van uitgifte:
Date of issue: July 2018

Adres:
Address: Reller 28
Place: D -21079 Hamburg, Germany

	Details van de proeflas Weld test details	Geldigheidsgebied Range of approval	
Lasproces Welding process		Afbrandstuiklassen (241) Flash-butt welding (241)	
Spoorstaaf type Rail type	54E1 to 54E1	54E1/E5 to 54E1/E5	
Soort verbinding Joint type		Stuiklas Butt weld	
Basismateriaal groep(en) Parent metal group(s)	R350HT to R350HT	R350HT to R350HT	
Lasmachine fabrikant Welding machine manufacturer	Schlatter	Schlatter	
Lasmachine identificatie Welding machine identification	AS 1.2653.2804	AS 1.2653.2804	
Machine type Machine type	GAAS 80/580	GAAS 80/580	
Machine nummer Machine number		GAAS 80 VRCH	
Lasmachine/Bedieners identificatie Welding machine/Operators identification	Zie rapport: See report:	DR/18/180222/002	
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	↑ Zie rapport: See report: DR/18/180222/002 ↓	Acceptabel Acceptable	- Upper side foot grinded
Geometrie Geometrically		Acceptabel Acceptable	- One running side only Running side marked white
Magnetisch onderzoek Magnetic particle inspection		Acceptabel Acceptable	- No pull up straightening as a last straightening action
Penetrant Dye penetrant		Niet vereist Not required	
Buig/breektest Bend/Break test		Acceptabel Acceptable	
Vermoeingsproef Fatigue test		Acceptabel Acceptable	
Hardheidsmetingen Hardness measurements		Acceptabel Acceptable	
Macro-onderzoek Macro-examination		Acceptabel Acceptable	
Mirco-onderzoek Micro-examination		Acceptabel Acceptable	
Aanvullende beproevingen Additional tests		Acceptabel Acceptable	

Vakkennis Job knowledge
 Acceptabel Acceptable
 Niet beoordeeld Not tested

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

Aanvullende informatie beschikbaar op Additional information is available on Zie rapport: See report, DR/18/180222/002, d.d. September 2018

Kwalificatie geldig tot: July 2020
 Validity of approval until:

Datum: 27-09-18
 Date:

Handtekening:
 Signature:
 ing. J.G.M. Jansen IVE nr.: 192

J.G.M. Jansen
 I.W.E. 192

