

Certificate

Certification number SP AF 044

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 R260Mn to 54E1 R260Mn

in accordance with the specification RLN00127-1 and -2, version 003, d.d. 25-05-2007. 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 044
Number: Annex 1

Kenmerk:
Designation: See DR/18/180222/003

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: 21079 Hamburg, Germany

	Details van de proeflas Weld test details	Afbrandstuiklassen (241) Flash-butt welding (241)	Geldigheidsgebied Range of approval	
Lasproces Welding process				
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)	R260Mn to R260Mn		R260Mn to R260Mn	
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/18/180222/003	
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			Acceptabel Acceptable	- Upper site foot grinded
Geometrie Geometrically			Acceptabel Acceptable	- One running side only Running site 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/breuktest Bend/Break test	Zie rapport: See report: DR/18/180222/003		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			Niet vereist 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,

Kwalificatie geldig tot: July 2020
 Validity of approval until:

DR/18/180222/003, d.d. September 2018

Datum:
 Date:
 27-09-'18

Handtekening:
 Signature:

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



