

# Manufacturer-related product qualification

HPQ expansion joints for transverse and longitudinal joints on railway bridges as per RIL 804.5201 as well as module 804.9010, 804.9020 and 804.9030

**The manufacturer:**  
(party placing the products on the market)

**STOG GmbH, Suessenguthstraße 28,  
81247 München, Germany**

**and its manufacturing  
facility:**  
(plant)

**1. STOG GmbH, Suessenguthstraße 28, 81247 München, Germany  
2. STOG GmbH, NL Waltrop, Schmiedeweg 8, 45731 Waltrop,  
Germany**

is basically qualified to manufacture the product: joints and the associated components:

- ☒ **Closed joints and expansion joints**
- ☒ **Superstructure closures** (special design of closed and expansion joints)
- ☒ **Open joints and expansion joints**

Restrictions:

In the list on page 2 of this certificate, the scope related to the manufacturer is stipulated in detail.

**Manufacturer's mark used: 00006\_DB-HPQ\_RIL\_804.5201\_STOG-G06-2025**

This certificate confirms that the requirements of RIL 804.5201 Joints as part of the manufacturer-related product qualification (document verification and audit) were audited.

Validity: Repeat qualification for a limited period ending on 22.06.2025

Start: 01.03.2018

Validity period:  
For restriction see above.

A valid certification in accordance with DIN EN 1090-1 WPK (conformity of internal production control), welding certification in accordance with DIN EN 1090-1 Table B.1 for welding steel structures in accordance with DIN EN 1090-2 (EXC3 or EXC4) is required for this qualification to be valid in keeping with RIL 804.5201 EXC3 (cf. DBS 918005 Tab. 2). This qualification is valid for as long as the provisions of RIL 804.5201 mentioned above in conjunction with DIN EN 1090, the manufacturing conditions and/or the internal production control system have not significantly changed (see page 2: General Provisions).

General provisions to be followed: see back of this certificate

**Deutsche Bahn AG**  
**Infrastructure Procurement**  
**Quality Assurance**

Berlin, 11.05.2023

p.p. \_\_\_\_\_  
Müller

p.p. \_\_\_\_\_  
Dr. Eghdam

## General provisions:

1. Deutsche Bahn AG, Infrastructure Procurement, Quality Assurance, must be informed in due time if person(s) mentioned in this certificate who are responsible for the implementation of the HPQ requirements leave the company, or if the conditions for obtaining the HPQ have significantly changed. Deutsche Bahn AG, Infrastructure Procurement, Quality Assurance, can request a repeat inspection to be carried out on the manufacturer's premises if necessary.
2. If doubts arise concerning the suitability of the manufacturer and/or if the quality requirements for the product(s) are not met, Deutsche Bahn AG, Infrastructure Procurement, Quality Assurance, reserves the right to conduct unannounced audits at the manufacturer's expense at any time.
3. This certificate can be withdrawn, modified and/or restricted at any time with immediate effect and without compensation if the conditions under which the certificate was granted have changed or if the requirements are not met. In the event of a withdrawal, the manufacturer is obliged to immediately remove all issued HPQ certificates that are publicly available including any references to them.
4. If the HPQ is to be extended, the manufacturer must coordinate the dates and terms of the extension with Deutsche Bahn AG, Infrastructure Procurement, Quality Assurance, at least two months prior to expiry of the validity of the HPQ or before the date of the next inspection.
5. After a recertification, significant changes to the certificates (e.g. vSAP), etc., the holder of the qualification in accordance with RIL 804.5201 Joints must provide Deutsche Bahn AG, Infrastructure Procurement, Quality Assurance, with proof of the validity of the certification (EN 1090-1 - internal production control and welding - EXC3 or EXC4). The same applies if the persons responsible for implementing the HPQ requirements change.
6. Audit for compliance review: - / -

Observe Item 11 on the information sheet HPQ RIL 804.5201 Joints.

A compliance review is carried out if, for example, the requirements change or there are delays in implementing the findings of the audit. If no changes have occurred and continuous acceptances were completed, the manufacturer can request that the compliance review be skipped. Agreeing on a date to conduct the compliance review or skip the compliance review for a justified reason does not invalidate or limit the validity of the HPQ in accordance with RIL 804.5201 Joints. If the validity changes as a result of the review, Deutsche Bahn AG, Infrastructure Procurement, Quality Assurance, will announce this on their website.

## Comments:

### 1. Scope of the HPQ:

<b>M-ÜF 1903</b>	Seal on the support-beam or bearing end as low-lying transverse joint	<b>S-ÜF 30</b>	Latitudinal joint between steel structure and abutment of type 30 Q
<b>M-ÜF 1904</b>	Sealing at end of deck terminating in latitudinal joint in approach section	<b>S-ÜF 32</b>	Latitudinal joint between steel structure and abutment of type 80 Q
<b>M-ÜF 1905</b>	Seal on the support-beam or bearing end as frame corner	<b>S-ÜF 34</b>	Latitudinal joint between steel structure and abutment of type 130 Q
<b>M-ÜF 1910</b>	Open latitudinal joint on beam bridges (structure for abutment)	<b>S-ÜF 36</b>	Longitudinal and transverse joint with steel support beams – Type 30 L
<b>M-ÜF 1911</b>	Open latitudinal joint on beam bridges (sealing and drainage)	<b>S-ÜF 37</b>	Longitudinal and transverse joint with steel support beams – Type 80 L
<b>M-ÜF 1912</b>	Open latitudinal joint on beam bridges (component parts)	<b>S-ÜF 38</b>	Longitudinal and transverse joint with steel support beams – Type 130 L
<b>M-ÜF 1913</b>	Open latitudinal joint as ballast bed separation	<b>M-TFU 10</b>	Open joint on viaducts < 90 m
<b>M-ÜF 1914</b>	Joint and expansion joint constructions with variable drain	<b>M-TFU 11</b>	Open joint on viaducts 90 – 300 m
<b>M-ÜF 1930</b>	Longitudinal waterstop on bridges and viaducts	<b>M-TFU 12</b>	Open joint on viaducts > 300 m
<b>M-ÜF 1931</b>	Watertight joint Type 30 for longitudinal and transverse joints on railway bridges	<b>M-TFU 13</b>	Open joint on viaducts > 300 m (sections)
<b>M-ÜF 1934</b>	Watertight joint Type 80 for longitudinal and transverse joints on railway bridges	<b>RIL 804.6101</b>	Waterbar K 40
<b>M-ÜF 1937</b>	Watertight joint Type 130 for longitudinal and transverse joints on railway bridges	<b>image no. 10</b>	

**Comment:** For combinations of elements of the aforementioned types as double joint, the HPQ applies to the associated individual components that comply with RIL 804.5201.  
Required approvals of joint systems outside valid DB reference drawings remain unaffected (cf. RIL 804.0101, Item 1 (6) / RIL 804.5201, Item 1 (7), UIG).

2.  
Person responsible for implementing the HPQ requirements:  
Mr Arnulf Stog

3.  
Deputies to the person responsible for implementing the requirements of the HPQ:  
Mr Bernhard Weckermann

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