

CERTIFICATE

Welding of railway vehicles and components according to EN 15085-2:2020

This is to certify that **KS KONSTRUKCJE STALOWE Sp. z o. o.**
ul. Kolejowa 1
46-040 Ozimek
POLAND

is qualified to perform welding work within the range of certification of:

**Classification level CL 1 and type of activity
P – production according to EN 15085-2:2020**

Field of application: Manufacturing of new assemblies and components for railway vehicles, except design and except purchasing of welded parts.

Range of certification

Welding process according to EN ISO 4063	Material group according to ISO/TR 15608	Dimensions	Comments
135	1.2	t = 3+140 mm; D ≥ 30 mm	BW
		t ≥ 1,8 mm; D ≥ 25 mm	FW
	8.1	t ≥ 3 mm; D ≥ 40 mm	FW
		t = 3+12 mm; D ≥ 84,3 mm	BW
		t = 10+40 mm; D ≥ 500 mm	FW
8.1+1.2	t = 3+10 mm; D ≥ 38 mm	BW	
136	1.2	t = 3+30 mm; D ≥ 30,15 mm	FW
138	1.1	t = 4+9,6 mm; D ≥ 500 mm	FW
	1.2	t = 3+24 mm; D ≥ 500 mm	BW

(continuation: see reverse)

Responsible welding coordinator: Henryk Flegler (EWE) born: 02.03.1961
Deputy with equal rights: Krzysztof Nalepa (EWE) born: 08.08.1977
Deputy: Piotr Kabata (IWS) born: 01.08.1960
Comments: see reverse
Certificate no.: TUVRh/15085/CL1/PL075/22
Valid: from 20.04.2022 to 19.04.2025
Issued on: 20.04.2022
Auditor: Paweł Szczepanik
 General regulations (see reverse)



Handwritten signature

Andrzej Kierzek
Certification Body

Certificate no.: TUVRh/15085/CL1/PL075/22

Continuation of range of certification

Welding process according to EN ISO 4063	Material group according to ISO/TR 15608	Dimensions	Comments
138+136	1.1	t = 3+24 mm; D ≥ 500 mm	BW
141+135	1.2	t = 3+12,6 mm; D ≥ 30,2 mm	BW
141	1.1	t = 1,3+10 mm; D = 10+96,6 mm	BW
	1.2	t = 4+16 mm; D ≥ 500 mm	FW
		t = 3+16 mm; D ≥ 25 mm	BW
	8.1	t = 1,05+40 mm; D ≥ 9 mm	FW
		t = 1,4+15,2 mm; D ≥ 11 mm	BW
	8.1+1.2	t = 2,03+12 mm; D ≥ 30,2 mm	FW
t = 2,03+3,77 mm; D ≥ 30,2 mm		BW	
141+135	8.1	t = 2+14 mm; D ≥ 150 mm	BW
121	1.2	t = 3+20 mm; D ≥ 500 mm	BW
783	1.2	t ≥ 2 mm	M6 + M10
	8.1	t ≥ 1,5 mm	M6 ÷ M10
	1.2+8.1	t ≥ 3 mm	M10

Comments:

Certification conditions EN 15085-2 are available on:
www.tuv.pl/zalaczniki

Classification of Economic Activities:

Manufacture of engines and turbines, except aircraft, vehicle and cycle engines (28.11)
Repair and maintenance of fabricated metal products (33.11)
Repair and maintenance of other transport equipment (33.17)

General regulations

according to EN 15085-2:2020.

Revocation of the Certificate

Manufacturer certification body issuing this certificate may revoke the certificate if:

- there are justified doubts as to the proper execution of the welding work according to the stated standards,
- there are justified doubts as to the proper welding coordination according to the stated standards,
- no recognized welding coordinator is available any longer,
- no valid qualification test certificates for the welders and welding operators according to the specified standards are available,
- welders or welding operators without tested qualifications have been entrusted with the execution of welding work under the stated standards,
- other conditions according to the stated standards are no longer satisfied,
- the manufacturer certification body was refused an opportunity to perform the annual verification,
- the welding manufacturer waives the certificate.

The welding manufacturer shall acknowledge the revocation in writing to the manufacturer certification body.

If a valid certificate is to be renewed, the renewal must be applied for with the manufacturer certification body at least two months before the end of the period of validity of the current certificate.

Distribution list:

1. Applicant (original)
2. Files