

CERTIFICATE

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

This is to certify that **AXTONE S.A.**
ul. Zielona 2
37-220 Kańczuga
POLAND

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

Classification level CL 1 and type of activity
D – design, P – production, M – maintenance, S - purchase and supply
according to EN 15085-2:2020

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

Range of certification

Welding process according to EN ISO 4063	Material group according to ISO/TR 15608	Dimensions	Comments
111	1.2	t = 3,0÷20,0 mm	FW
121	1.2	t = 11 ÷ 95 mm; D ≥ 87 mm	BW; fully mechanised
	1.3	t = 7 ÷ 35 mm	BW; fully mechanised
	3.1	t = 3 ÷ 20 mm	FW; fully mechanised
135	1.1/X120Mn12	-	FW; partly mechanised
	1.2	-	partly mechanised; overlay welding
		t = 3 ÷ 60 mm; D ≥ 70 mm	BW/FW; a automatic
		t ≥ 3 mm	FW; partly mechanised
	5	t ≥ 3 mm	partly mechanised; overlay welding
	1.2	t = 3 ÷ 300 mm	BW; partly mechanised
	1.2/11	t = 19 ÷ 76 mm	BW; partly mechanised
	1.2/X120Mn12	t = 3 ÷ 80 mm	FW; partly mechanised
	1.3	t = 8 ÷ 34 mm; D ≥ 98 mm	BW; partly mechanised
	11	t = 3 ÷ 88 mm	FW; partly mechanised

(continuation: see reverse)

Responsible welding coordinator: Ryszard Ochyra (EWE) born: 11.01.1966
Deputy with equal rights: Arkadiusz Duda (IWE) born: 16.04.1993
Deputy: Janusz Żyła (IWP) born: 11.05.1977
Comments: see reverse

Certificate no.: TUVRh/15085/CL1/PL013/24
Valid: from 10.05.2024 to 09.05.2027
Issued on: 10.05.2024
Auditor: Andrzej Kierzek
 General regulations (see reverse)



Jankowski

Tomasz Jankowski
Certification Body



AC 141



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Precisely Right.

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Continuation of range of certification

Welding process according to EN ISO 4063	Material group according to ISO/TR 15608	Dimensions	Comments
135	11	t = 3 ÷ 140 mm	BW; partly mechanised
	11.2	t = 3 ÷ 140 mm	BW/FW; automatic
	11	t = 5 ÷ 30 mm; D ≥ 123 mm	BW; partly mechanised
		t = 8 ÷ 10 mm	BW; partly mechanised
		t = 9 ÷ 37 mm; D ≥ 98 mm	partly mechanised; overlay welding
	3.2/1.2	t = 8 ÷ 34 mm	BW; partly mechanised
	3.2	t = 7 ÷ 30 mm	BW; partly mechanised
	4.2	t = 10 ÷ 60 mm; D ≥ 105 mm	BW; partly mechanised
		t = 18 ÷ 92 mm; D ≥ 125 mm	BW; partly mechanised
	5	t = 8 ÷ 34 mm; D ≥ 90 mm	BW; partly mechanised
5.1	t = 8 ÷ 32 mm; D ≥ 90 mm	BW; automatic	
	t = 15 ÷ 60 mm	BW; partly mechanised	
135/121	1.2	t ≥ 5 mm; D ≥ 104 mm	FW; partly mechanised
	11	t = 3 ÷ 14 mm; D ≥ 5 mm	BW; partly mechanised
	4.2/1.2	t = 11 ÷ 42 mm; D ≥ 5 mm	FW; partly mechanised
136	1.3	t = 9 ÷ 20 mm	FW; partly mechanised
	3.2	t = 7 ÷ 30 mm	BW; partly mechanised
	8	t = 5 ÷ 12 mm	FW; partly mechanised

Comments:

Certification conditions EN 15085-2 are available on:

www.tuv.pl/zalaczniki

Additional welding coordinator:

Paweł Siuśta 23.03.1980 (Level C)

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