

CERTIFICATE

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

This is to certify that **AXTONE S. A.**

**Zielona 2
37-220 Kanczuga
POLAND**

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

Certification level CL1 according to EN 15085-2

Field of application:

- New build, design, purchase and resale of welded parts for railway vehicles
- Classification level CL 1 according to DIN 27201-6 for repairing - for repairing and construction for repair

Range of certification

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Comments
111	1.2	t = 3 - 20 mm	FW
121	3.1	t = 3 - 20 mm	FW
	1.3	t = 7 - 35 mm	BW
	1.2	t = 11 - 95 mm D >= 87 mm	BW

(continuation: see reverse)

Responsible welding coordinator: Ryszard Ochyra (EWE) born: 11.01.1966

Deputy with equal rights: -

Deputy: see reverse

Certificate no.: TÜVNORD/15085/CL1/398/0/20

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Valid: from 03.06.2020 to 27.05.2023

Issued on: 04.06.2020

Auditor: KRULISZ
General regulations (see reverse)



Zabrocki
certification body

Continuation of range of certification

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Comments
135/121	11	t = 3 - 14 mm D ≥ 5 mm	BW
	1.2	t ≥ 5 mm D ≥ 104 mm	FW
	4.2/1.2	t = 11 - 42 mm D ≥ 5 mm	FW
135	1.1/X120Mn12		FW
	1.2		overlay welding
	1.2	t ≥ 3 mm	FW
	5	t ≥ 3 mm	overlay welding
	1.2/X120Mn12	t = 3 - 80 mm	FW
	11	t = 3 - 88 mm	FW
	11	t = 3 - 140 mm	BW
	1.2	t = 3 - 300 mm	BW
	11	t = 5 - 30 mm D ≥ 123 mm	BW
	3.2/1.2	t = 7 - 28 mm	BW
	3.2	t = 7 - 30 mm	BW
	5	t = 8 - 34 mm D ≥ 90 mm	BW
	1.3	t = 8 - 34 mm D ≥ 98 mm	BW
	11	t = 9 - 37 mm D ≥ 98 mm	overlay welding
	4.2	t = 10 - 60 mm D ≥ 105 mm	BW (34CrNiMo6+QT)
	4.2/1.2	t = 11 - 42 mm D ≥ 5 mm	FW
5.1	t = 15 - 60 mm	BW (42CrNiMo4+QT)	
4.2	t = 18 - 92 mm D ≥ 125 mm	BW (34CrNiMo6+QT)	
1.2/11	t = 19 - 76 mm	BW (mit C35E+N)	
136	8	t = 5 - 12 mm	FW
	3.2	t = 7 - 30 mm	BW
	1.3	t = 9 - 20 mm	FW

Comments:

Authorized for performing, evaluation and approval of qualification tests of welders and welding operators as well as tests for the approval of welding procedure specifications is: Mr. Ryszard Ochrya

Additional deputies:

- Pawel Szlek (IWP) born: 23.03.1974
- Roman Tanski (IWS) [external] born: 03.12.1980
- Janusz Zyla (IWP) born: 11.05.1977

General regulations

It apply the conditions of the standard EN 15085-2:2007, section 7.
 The General Terms and Conditions of the TÜV NORD Systems apply in the currently valid version.
 To verify the validity of the digital signature of the TÜV NORD Systems employee, the installation of the TÜV NORD GROUP root certificate is required:
<https://www.tuev-nord.de/en/customer-login/digital-signature/>