

CERTIFICATE

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

TÜVRh/15085/CL1/020/21/0

TÜV Rheinland Industrie Service GmbH hereby certifies that the welding company

Axtone S.A.
Zielona 2
37-220 Kanczuga
Poland

fulfills the requirements
for the scope according to

EN 15085-2 classification level CL1
in the field of activity D, P, M, S
in the range indicated in the annex.

validity: 23.08.2021 until 22.08.2024

ECWRV

Cologne, 23.08.2021
Place and date of issue

Lead auditor: Dipl.-Ing. KRULISZ

signed on original
Dipl.-Ing. MAKOWKA
Head of certification body

Scope of the certificate

TÜVRh/15085/CL1/020/21/0

Scope:

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Remarks
111	1.2	t = 3 - 20 mm	FW, manually
121	1.2 1.3 3.1	t = 11 - 95 mm D ≥ 87 mm t = 7 - 35 mm t = 3 - 20 mm	BW, fully mechanized BW, fully mechanized FW, fully mechanized
135	1.1/X120Mn12 1.2 1.2 1.2 5 1.2 1.2/11 1.2/X120Mn12 1.3 11 11 11.2 11 11 11 3.2/1.2 3.2 4.2 4.2 5 5.1 5.1	- - t = 3 - 60 mm D ≥ 70 mm t ≥ 3 mm t ≥ 3 mm t = 3 - 300 mm t = 19 - 76 mm t = 3 - 80 mm t = 8 - 34 mm D ≥ 98 mm t = 3 - 88 mm t = 3 - 140 mm t = 3 - 140 mm t = 5 - 30 mm D ≥ 123 mm t = 8 - 10 mm t = 9 - 37 mm D ≥ 98 mm t = 7 - 28 mm t = 7 - 30 mm t = 10 - 60 mm D ≥ 105 mm t = 18 - 92 mm D ≥ 125 mm t = 8 - 34 mm D ≥ 90 mm t = 8 - 32 mm D ≥ 90 mm t = 15 - 60 mm	FW, partly mechanized partly mechanized, Auftragsschweißen BW/FW, robotic FW, partly mechanized partly mechanized, Auftragsschweißen BW, partly mechanized BW, partly mechanized, (mit C35E+N) FW, partly mechanized BW, partly mechanized D ≥ 98 mm FW, partly mechanized BW, partly mechanized BW/FW, robotic BW, partly mechanized partly mechanized, Auftragsschweißen BW, partly mechanized BW, partly mechanized BW, partly mechanized, (34CrNiMo6+QT) BW, partly mechanized, (34CrNiMo6+QT) BW, partly mechanized BW, robotic BW, partly mechanized, (42CrMo4+QT)
135/121	1.2 11 4.2/1.2	t ≥ 5 mm D ≥ 104 mm t = 3 - 14 mm D ≥ 5 mm t = 11 - 42 mm D ≥ 5 mm	FW, partly mechanized BW, partly mechanized FW, partly mechanized
136	1.3 3.2 8	t = 9 - 20 mm t = 7 - 30 mm t = 5 - 12 mm	FW, partly mechanized BW, partly mechanized FW, partly mechanized

Area of Application:

- New build, design, purchase and resale of welded parts for railway vehicles,
- Classification level CL1 according to DIN 27201-6 for repairing and construction

Responsible welding coordinator(s):

Ryszard Ochyra, Level A (EWE) born: 1966

1st deputy(ies) of the responsible welding coordinator(s):

Adam Olejarka, Level B (IWT) born: 1974

Others deputies:

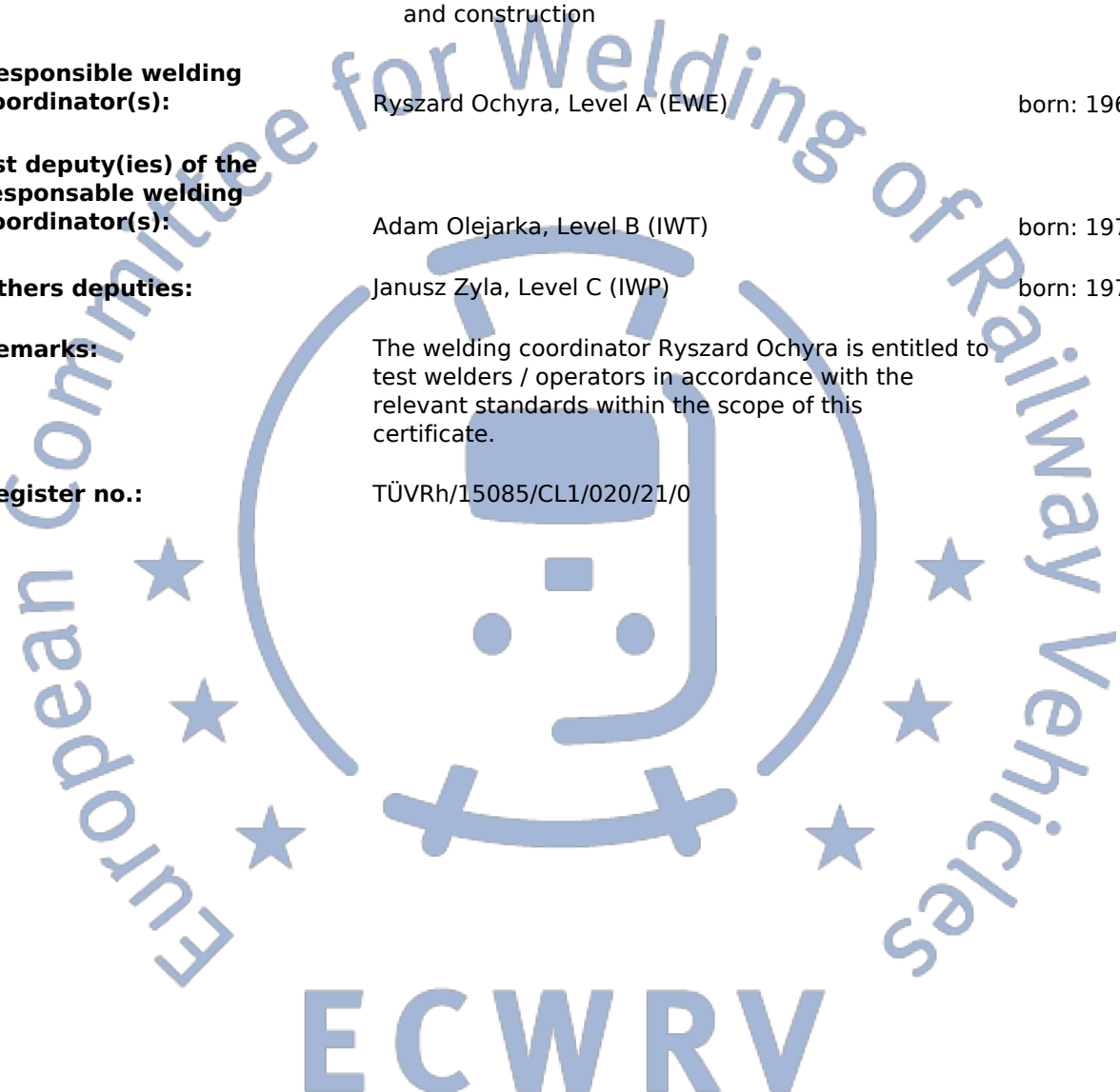
Janusz Zyla, Level C (IWP) born: 1977

Remarks:

The welding coordinator Ryszard Ochyra is entitled to test welders / operators in accordance with the relevant standards within the scope of this certificate.

Register no.:

TÜVRh/15085/CL1/020/21/0



General provisions:

The General Terms and Conditions of the TÜV Rheinland Industrie Service GmbH apply in the currently valid version.

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