

C E R T I F I C A T E

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

This is to certify that **IRONET, s.r.o.**

Pomoranska 471/3

**181 00 Prague 8 - Troja
CZECH REPUBLIC**

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

Certification level CL1 according to EN 15085-2

- Field of application:**
- Level CL1
 - new build, conversion and repair of rail vehicles and their components
 - examples for components:
 - draw and buffing gear
 - supporting frames for external equipment parts (e. g. tanks, electrical, air-conditioning and compressed air containers)
 - welded components for drag transmission from bogie to vehicle (bolster)

 - Level CL1 or Level CL2
 - self-supporting equipment boxes and underfloor containers (fresh water and waste-water containers)
 - machine room equipment (transformer casing, transformer suspension, engine suspension, transmission suspension, attachment for traction motor, instrument racks)

 - Level CL2
 - payload container for non-dangerous materials
 - other transport containers
 - internal parts of passenger coaches (partitions, walls, doors, panelling)
 - supporting frame for internal parts (electrical, air-conditioning and compressed air installations)
 - driving cab equipment
 - sliding doors in vehicles including runways
 - non-self-supporting equipment boxes underneath the base frame (without supporting frame)
 - steps, hand rails (including handrails in entry areas) and railings external to the vehicle

 - Level CL3
 - cranks and levers for various operations;
 - equipment boxes and switch cabinets in rail vehicles (including gearboxes and consoles for hand brake operation, without supporting frame);
 - holders for index plates
 - seating frames

Range of certification

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Comments
131	22.1, 22.2, 22.3, 22.4, 23.1	t = 3 - 8 mm	BW, FW
135	1.1, 1.2, 1.4 8.1	t = 1.05 - 24 mm t = 1.4 - 12 mm	BW, FW BW, FW
141	22.1, 22.2, 22.3, 22.4, 23.1 1.1, 1.2, 1.4 8.1	t = 0.75 - 12 mm t = 1 - 12 mm t = 1.4 - 12 mm	BW, FW BW, FW BW, FW
212	8.1	D ≤ 2 mm	spot weld

Responsible welding coordinator: anonymous (The data are known to the mcb.)

Deputy with equal rights: anonymous (The data are known to the mcb.)

Deputy: anonymous (The data are known to the mcb.)

Certificate no.: 12.612.126

Register number: TSCZ/15085/CL1/006/4/19

Valid: from 03.10.2019 to 03.10.2022

Issued on: 03.10.2019

Auditor: ONDRUŠ

General regulations (see reverse)

Nerandzicova
Deputy head of certification body

Certificate no.: 12.612.126

General regulations

according to EN 15085-2

Revocation of the Certificate

The national safety authority or the 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. The manufacturer certification body shall notify the national safety authority.

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