

# CERTIFICATE

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

This is to certify that **Zakłady Remontowe Energetyki Katowice S.A.**  
Martyniaków 7  
43-603 Jaworzno  
Poland

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

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

**Field of application:** Manufacturing of new assemblies and components for railway vehicles, repair of railway components; except design

### Range of certification

| Welding process according to EN ISO 4063 | Material group according to ISO/TR 15608 | Dimensions   | Comments |
|--|--|--|----------|
| 111                                      | 1.1                                      | $t \geq 5,0$ mm                                    | FW       |
|  |  | $t = 3,0 \div 12,0$ mm<br>$t = 35,0 \div 140,0$ mm | BW       |
|  | 1.2                                      | $t \geq 4,0$ mm                                    | FW       |
|  |  | $t = 3,0 \div 150,0$ mm<br>$D \geq 44,5$ mm        | BW       |

(continuation: see reverse)

**Responsible welding coordinator:** Krzysztof Kusy, IWE born: 08.02.1973  
**Deputy with equal rights:** Konrad Kurek, IWE born: 24.10.1982  
**Deputy:** Bartłomiej Wąsala, IWE born: 07.04.1985  
**Comments:** see reverse  
**Certificate no.:** TUVRh/15085/CL1/PL013/23  
**Valid:** from 30.06.2023 to 29.06.2026  
**Issued on:** 26.06.2023  
**Auditor:** Krzysztof Skrzypek  
General regulations (see reverse)



*Handwritten signature*  
Andrzej Kierzek  
Certification Body

© TÜV, TÜEV and TÜV are registered trademarks. Utilization and application requires prior approval.

## Continuation of range of certification

| Welding process according to EN ISO 4063 | Material group according to ISO/TR 15608 | Dimensions   | Comments                                      |                                 |
|--|--|--|---|---------------------------------|
| 111                                      | 1.2 / 8.2                                | t = 3,0 ÷ 24,0 mm  | BW  |                                 |
|  | 3.1 / 8.2                                | t = 3,0 ÷ 10,0 mm  | FW  |                                 |
|  | 8.1                                      | t = 3,0 ÷ 10,0 mm  | BW  |                                 |
|  | 8.2                                      | t ≥ 5,0 mm<br>t = 3,0 ÷ 24,0 mm                              | FW<br>BW                                      |                                 |
| 114                                      | 1.2                                      | t = 3,0 ÷ 20,0 mm  | BW  |                                 |
| 135                                      | 1.2                                      | t ≥ 4,0 mm   | FW  |                                 |
|  |  | t = 3,0 ÷ 260,0 mm   | BW  |                                 |
|  | 2.2                                      | t ≥ 3,0 mm<br>t = 1,0 ÷ 30,0 mm                              | FW<br>BW                                      |                                 |
| 135p                                     | 2.2                                      | t = 1,4 ÷ 4,0 mm   | FW  |                                 |
| 135                                      | 1.2 / 3.1                                | t = 1,4 ÷ 4,0 mm<br>t = 3,0 ÷ 59,0 mm                        | FW  |                                 |
|  |  | 2.2 / 8.1  | t = 1,0 ÷ 56,0 mm<br>t = 1,4 ÷ 20,0 mm        | FW<br>BW                        |
|  | 3.1                                      | t ≥ 5,0 mm<br>t = 3,0 ÷ 240,0 mm                             | FW<br>BW                                      |                                 |
|  |  | 3.2  | t ≥ 5,0 mm<br>t = 3,0 ÷ 100,0 mm              | FW<br>BW                        |
|  | 8.1                                      | t = 3,0 ÷ 56,0 mm<br>t = 1,4 ÷ 24,0 mm                       | FW<br>BW                                      |                                 |
|  |  | 1.2  | t ≥ 5,0 mm<br>t = 3,0 ÷ 24,0 mm               | FW<br>BW                        |
|  | 136                                      |  | 1.2   | t ≥ 5,0 mm<br>t = 3,0 ÷ 24,0 mm |
|  |  | 138  |   | 1.2                             |
| 141                                      | 1.1                                      |  | t ≥ 5,0 mm<br>t = 1,6 ÷ 14,2 mm<br>D ≥ 8,0 mm |                                 |
|  |  | 1.2  | t = 1,5 ÷ 6,0 mm<br>D ≥ 27,0 mm               | BW, FW                          |
|  | 1.2                                      | t = 3,0 ÷ 22,0 mm<br>D ≥ 10,65 mm                            | BW, FW  |                                 |
|  | 1.2                                      | t = 3,0 ÷ 12,6 mm<br>D ≥ 25,0 mm                             | BW  |                                 |
|  | 2.2                                      | t = 3,0 ÷ 40,0 mm  | FW  |                                 |
|  | 3.1 / 2.2                                | t = 3,0 ÷ 40,0 mm  | FW  |                                 |
|  | 1.1 / 8.1                                | t = 1,4 ÷ 12,0 mm<br>D = 6,0 ÷ 42,6 mm<br>D ≥ 57,2 mm        | BW  |                                 |
|  | 2.2 / 8.1                                | t = 3,0 ÷ 30,0 mm  | FW  |                                 |
|  | 8.1                                      | t = 0,7 ÷ 12,0 mm<br>t = 0,8 ÷ 22,0 mm<br>D = 8,6 ÷ 152,2 mm | FW<br>BW                                      |                                 |
| 141 / 111                                | 1.2                                      | t = 8,0 ÷ 32,0 mm<br>D ≥ 109,55 mm                           | BW  |                                 |
| 141 / 121                                | 1.2                                      | t = 12,5 ÷ 72,0 mm   | BW  |                                 |
| 141 / 135p                               | 2.2                                      | t = 3,0 ÷ 40,0 mm  | FW  |                                 |
|  | 3.1 / 2.2                                | t = 3,0 ÷ 24,0 mm  | BW, FW  |                                 |
| 141 / 136                                | 1.2                                      | t = 6,3 ÷ 25,0 mm  | BW  |                                 |
| 141 / 138                                | 1.2                                      | t = 6,25 ÷ 25,0 mm<br>D ≥ 69,85 mm                           | BW  |                                 |
| 783                                      | 1.2                                      | D = 8,0; 10,0 mm   | ---   |                                 |
|  | 2.2                                      | D = 6,0; ≥1,5 mm   | ---   |                                 |

Certificate no.: TUVRh/15085/CL1/PL013/23

**Comments:**

Certification conditions EN 15085-2 are available on:  
[www.tuv.pl/zalaczniki](http://www.tuv.pl/zalaczniki)

Company's registered address:  
Zakłady Remontowe Energetyki Katowice S.A.  
Generała Zygmunta Waltera Jankego 13  
40-615 Katowice

Additional welding coordinators:  
Jacek Czardybon, born: 05.08.1971, IWE;  
Piotr Michalski, born: 31.10.1993, IWE;

The responsible welding coordination personnel representatives, Mr. Krzysztof Kusy, Mr. Konrad Kurek and Mr. Bartłomiej Wąsala are authorized to test the qualification of welders according to the applicable standards within the range of certification of this certificate.

**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