

# CERTIFICATE

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

This is to certify that **AS Saku Metall Allhanke Tehas**

**Porguvalja Road 25**

**75306 Harjumaa  
ESTONIA**

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

**Certification level CL1 according to EN 15085-2**

**Field of application:** • Welding during construction and reconstruction of railway vehicles and their components

### Range of certification

| Welding process according to EN ISO 4063 | Material group according to CEN ISO/TR 15608 | Dimensions       | Comments        |
|--|--|------------------|-----------------|
| 131                                      | 22.4   | t = 1 - 4 mm     | BW, FW          |
| 135                                      | 2.1  | t = 0.9 - 2.6 mm | BW, FW          |
|  | 8.1  | t = 1 - 4 mm     | BW, FW 1-6 mm   |
|  | 1.2/8.1                                      | t = 2 - 6 mm     | BW, FW 1.7-5 mm |
|  | 1.4  | t = 2 - 10 mm    | BW, FW          |
|  | 1.2  | t = 3 - 12 mm    | BW, FW          |

(continuation: see reverse)

**Responsible welding coordinator:** Engineer Robert Talalaev (IWE) born: 1985

**Deputy with equal rights:** -

**Deputy:** Mait Kukk (IWE) [external] born: 1986

**Certificate no.:** Inspecta/15085/CL1/036/0/19

**Valid:** from 21.12.2018 to 28.11.2021

**Issued on:** 21.12.2018

**Auditor:** KIHLMARK

General regulations (see reverse)

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Jonas  
Deputy head of certification body

Certificate no.: Inspecta/15085/CL1/036/0/19

### Continuation of range of certification

| Welding process according to EN ISO 4063 | Material group according to CEN ISO/TR 15608 | Dimensions                                   | Comments                                 |
|--|--|--|--|
| 141                                      | 21<br>8.1<br>23.1                            | t = 1 - 4 mm<br>t = 1 - 4 mm<br>t = 1 - 4 mm | BW, FW<br>BW, FW 1-6 mm<br>BW, FW 1-8 mm |
| 212                                      | 8.1<br>2.1                                   | t = 1 - 1.5 mm<br>t = 1.2 - 2 mm             | Lap joint<br>Lap joint                   |
| 784                                      | 8.1  |  | Diameter 8.9 mm Stud                     |

## 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