Welding of Railway Vehicles and Components according to EN 15085-2

The Company: Laser Engineering UK (Part of WEC Group)

Welding Manufacturing Sites: N/A

Address: Britannia House, Junction Street, Darwen, Lancashire, BB3 2RB

Is certified to perform welding under classification level CL 1 according to EN 15085-2

Types of activities performed. P = Production

Field of application: EN 15085 CL1, CL2 and CL3 products, C-Mn steels, Cr-Mo steels, Q and T steels, stainless steels, nickel-chromium alloys and aluminium alloys.

Range of Qualification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for Fillet and Butt welds
111: MMA	Group 1 C-Mn steels	Fillet welds: 5mm & above Butt welds: 3mm – 90mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 7.6mm
	Group 8 Austenitic stainless steels	Butt welds: 3mm – 30mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 5mm & above Butt welds: 3mm – 20mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Butt welds: 3mm – 11,1mm
121: SAW	Group 1 C-Mn steels	Fillet welds: 3mm – 20mm Butt welds: 3mm – 20mm
	Group 8 Austenitic stainless steels	Fillet welds: 6mm – 15,6mm Butt welds: 6mm – 15,6mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 3mm – 20mm Butt welds: 3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	Fillet welds: 3mm – 31,7mm Butt welds: 3mm – 20mm
	Group 43 Nickel Chromium alloys Ni ≥ 40%	Fillet welds: ≥ 5mm Butt welds: 6mm – 32mm
135: MAG	Group 1 C-Mn steels	Fillet welds: 1,4mm & above Butt welds: 1,4mm – 80mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm & above Butt welds: 3mm – 30mm
	Group 7 Ferritic stainless steels	Fillet welds: 1,4mm – 4mm
	Group 8 Austenitic stainless steels	Fillet welds: 1,4mm & above Butt welds: 1mm – 60mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 3mm & above Butt welds: 3mm – 60mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 5mm & above

136: FCAW	Group 1 C-Mn steels	Fillet welds: 3mm & above Butt welds: 3mm – 120mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 30mm Butt welds: 5mm – 20mm
	Group 5 Cr Mo steels	Fillet welds: 30mm – 120mm
	Group 8 Austenitic stainless steels	Fillet welds: 5mm & above Butt welds: 20mm – 80mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 5mm & above Butt welds: 3mm – 70mm
141: TIG	Group 1 C-Mn steels	Fillet welds: 1,5mm – 50mm Butt welds: 1,5mm – 50mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 12mm Butt welds: 7,5mm – 16,5mm
	Group 8 Austenitic stainless steels	Fillet welds: 0,75mm & above Butt welds: 0,75mm – 40mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 1,6mm & above Butt welds: 1,6mm – 58,5mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 1,9mm & above Butt welds:1,9mm – 11,1mm
	23.1 Heat treatable alloys: Al-Mg-Si alloys	Fillet welds: 1mm – 30mm Butt welds: 1mm – 30mm
	22.1 to 22.1 Aluminium-manganese alloys	
	22.2 to 22.2[a] Aluminium-magnesium alloys with Mg ≤ 1.5%	
	22.3 to 22.3[a] Aluminium-magnesium alloys with Mg > 1.5% ≤ 3.5%	
	22.4 to 22.4[a] Aluminium-magnesium alloys with Mg > 3.5%	
	23.1 Heat treatable alloys: Al-Mg-Si alloys welded to Non-heat-treatable alloy combinations of 22.1, 22.2[a], 22.3[a], 22.4[a]	
	Group 43 Nickel-Chromium alloys	Butt welds: 3mm – 20mm
[a] Provided Al-Mg filler material is used		

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for LAP Joints
212: Spot-Resistance Weld	Group 1 C-Mn steels	3mm
	Group 8 Austenitic stainless steels	1,5mm – 2mm

Responsible Welding Coordinator:
William Barr IEng MWeldI, European / International Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, European / International Welding Technologist, HNC Mechanical & Manufacturing Engineering, CSWIP Welding Inspector, NVQ Level 3 Fabrication & Welding, Level A

Wayland Sutton, CSWIP Welding Inspector, Level C

Certificate Number: **CWRVC/059/GB**

Valid Until: 11 May 2026
(subject to satisfactory periodic surveillance)

Issued On: 23 October 2024

Head of Manufacturer Certification Body, TWI Certification Ltd

Issued by: TWI Certification Ltd, Granta Park, Great Abington, Cambridge, CB21 6AL, UK

Welding of Railway Vehicles and Components according to EN 15085-2

The Company: Special Projects (Part of WEC Group)

Welding Manufacturing Sites: N/A

Address: Britannia House, Junction Street, Darwen, Lancashire, BB3 2RB

Is certified to perform welding under classification level CL 1 according to EN 15085-2

Types of activities performed. P = Production

Field of application: EN 15085 CL1, CL2 and CL3 products, C-Mn steels, Cr-Mo steels, Q and T steels, stainless steels, nickel-chromium alloys and aluminium alloys.

Range of Qualification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for Fillet and Butt welds
111: MMA	Group 1 C-Mn steels	Fillet welds: 5mm & above Butt welds: 3mm – 90mm
	Group 3 Quenched and tempered steels with a minimum yield strength R_{eH} >360 N/mm^2	Fillet welds: 3mm – 7,6mm
	Group 8 Austenitic stainless steels	Butt welds: 3mm – 30mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 5mm & above Butt welds: 3mm – 20mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Butt welds: 3mm – 11,1mm
121: SAW	Group 1 C-Mn steels	Fillet welds: 3mm – 20mm Butt welds: 3mm – 20mm
	Group 8 Austenitic stainless steels	Fillet welds: 6mm – 15,6mm Butt welds: 6mm – 15,6mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 3mm – 20mm Butt welds: 3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	Fillet welds: 3mm – 31,7mm Butt welds: 3mm – 20mm
	Group 43 Nickel-Chromium alloys	Fillet weld: ≥ 5mm Butt welds: 6mm – 32mm

136: FCAW	Group 1 C-Mn steels	Fillet welds: 3mm & above Butt welds: 3mm – 120mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 30mm Butt welds: 5mm – 20mm
	Group 5 Cr Mo steels	Fillet welds: 30mm – 120mm
	Group 8 Austenitic stainless steels	Fillet welds: 5mm & above Butt welds: 20mm – 80mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 5mm & above Butt welds: 3mm – 70mm
141: TIG	Group 1 C-Mn steels	Fillet welds: 1,5mm – 50mm Butt welds: 1,5mm – 50mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 12mm Butt welds: 7,5mm – 16,5mm
	Group 8 Austenitic stainless steels	Fillet welds: 0,75mm & above Butt welds: 0,75mm – 40mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 1,6mm & above Butt welds: 1,6mm – 58,5mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 1,9mm & above Butt welds:1,9mm – 11,1mm
	23.1 Heat treatable alloys: Al-Mg-Si alloys	Fillet welds: 1mm – 30mm Butt welds: 1mm – 30mm
	22.1 to 22.1 Aluminium-manganese alloys	
	22.2 to 22.2[a] Aluminium-magnesium alloys with Mg ≤ 1.5%	
	22.3 to 22.3[a] Aluminium-magnesium alloys with Mg > 1.5% ≤ 3.5%	
	22.4 to 22.4[a] Aluminium-magnesium alloys with Mg > 3.5%	
	23.1 Heat treatable alloys: Al-Mg-Si alloys welded to Non-heat-treatable alloy combinations of 22.1, 22.2[a], 22.3[a], 22.4[a]	
	Group 43 Nickel-Chromium alloys	Butt welds: 3mm – 20mm
[a] Provided Al-Mg filler material is used		

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for LAP Joints
212: Spot-Resistance Weld	Group 1 C-Mn steels	3mm
	Group 8 Austenitic stainless steels	1,5mm – 2mm

Responsible Welding Coordinator:
William Barr IEng MWeldI, European / International Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, European / International Welding Technologist, HNC Mechanical & Manufacturing Engineering, CSWIP Welding Inspector, NVQ Level 3 Fabrication & Welding, Level A

Wayland Sutton, CSWIP Welding Inspector, Level C

Certificate Number: **CWRVC/059/GB**

Valid Until: 11 May 2026
(subject to satisfactory periodic surveillance)

Issued On: 23 October 2024

Head of Manufacturer Certification Body, TWI Certification Ltd

Issued by: TWI Certification Ltd, Granta Park, Great Abington, Cambridge, CB21 6AL, UK

Welding of Railway Vehicles and Components according to EN 15085-2

The Company: Welding Engineering (Part of WEC Group)

Welding Manufacturing Sites: N/A

Address: Spring Vale Road, Darwen, Lancashire, BB3 2ES

Is certified to perform welding under classification level CL 1 according to EN 15085-2

Types of activities performed. P = Production

Field of application: EN 15085 CL1, CL2 and CL3 products, C-Mn steels, Cr-Mo steels, Q and T steels, stainless steels, nickel-chromium alloys and aluminium alloys.

Range of Qualification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for Fillet and Butt welds
111: MMA	Group 1 C-Mn steels	Fillet welds: 5mm & above Butt welds: 3mm – 90mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 7,6mm
	Group 8 Austenitic stainless steels	Butt welds: 3mm – 30mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 5mm & above Butt welds: 3mm – 20mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Butt welds: 3mm – 11,1mm
121: SAW	Group 1 C-Mn steels	Fillet welds: 3mm – 20mm Butt welds: 3mm – 20mm
	Group 8 Austenitic stainless steels	Fillet welds: 6mm – 15,6mm Butt welds: 6mm – 15,6mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 3mm – 20mm Butt welds: 3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	Fillet welds: 3mm – 31,7mm Butt welds: 3mm – 20mm
	Group 43 Nickel Chromium alloys	Fillet welds: ≥ 5mm Butt welds: 6mm – 32mm
135: MAG	Group 1 C-Mn steels	Fillet welds: 1,4mm & above Butt welds: 1,4mm – 80mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm & above Butt welds: 3mm – 30mm
	Group 7 Ferritic stainless steels	Fillet welds: 1,4mm – 4mm
	Group 8 Austenitic stainless steels	Fillet welds: 1,4mm & above Butt welds: 1mm – 60mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 3mm & above Butt welds: 3mm – 60mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 5mm & above
136: FCAW	Group 1 C-Mn steels	Fillet welds: 3mm & above

		Butt welds: 3mm - 120mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 30mm Butt welds: 5mm – 20mm
	Group 5 Cr Mo steels	Fillet welds: 30mm – 120mm
	Group 8 Austenitic stainless steels	Fillet welds: 5mm & above Butt welds: 20mm – 80mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 5mm & above Butt welds: 3mm – 70mm
141: TIG	Group 1 C-Mn steels	Fillet welds: 1,5mm – 50mm Butt welds: 1,5mm – 50mm
	Group 3 Quenched and tempered steels	Fillet welds: 3mm – 12mm Butt welds: 7,5mm – 16,5mm
	Group 8 Austenitic stainless steels	Fillet welds: 0,75mm & above Butt welds: 0,75mm – 40mm
	Group 10 Austenitic ferritic stainless steels	Fillet welds: 1,6mm & above Butt welds: 1,6mm – 58,5mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	Fillet welds: 1,9mm & above Butt welds: 1,9mm – 11,1mm
	23.1 Heat treatable alloys: Al-Mg-Si alloys	Fillet welds: 1mm – 30mm Butt welds: 1mm – 30mm
	22.1 to 22.1 Aluminium-manganese alloys	
	22.2 to 22.2[a] Aluminium-magnesium alloys with Mg ≤ 1.5%	
	22.3 to 22.3[a] Aluminium-magnesium alloys with Mg > 1.5% ≤ 3.5%	
	22.4 to 22.4[a] Aluminium-magnesium alloys with Mg > 3.5%	
	23.1 Heat treatable alloys: Al-Mg-Si alloys welded to Non-heat-treatable alloy combinations of 22.1, 22.2[a], 22.3[a], 22.4[a]	
	Group 43 Nickel-Chromium alloys	Butt welds: 3mm – 20mm
[a] Provided Al-Mg filer material is used		

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for LAP Joints
212: Spot-Resistance Weld	Group 1 C-Mn steels	3mm
	Group 8 Austenitic stainless steels	1,5mm – 2mm

Responsible Welding Coordinator:
William Barr IEng MWeldI, European / International Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, European / International Welding Technologist, HNC Mechanical & Manufacturing Engineering, CSWIP Welding Inspector, NVQ Level 3 Fabrication & Welding, Level A

Wayland Sutton, CSWIP Welding Inspector, Level C

Certificate Number: CWRVC/027/GB

Valid Until: 11 May 2026
(subject to satisfactory periodic surveillance)

Issued On: 23 October 2024

Head of Manufacturer Certification Body, TWI Certification Ltd

Issued by: TWI Certification Ltd, Granta Park, Great Abington, Cambridge, CB21 6AL, UK

0025

Welding of Railway Vehicles and Components according to EN 15085-2

The Company: HTA Group Ltd (Part of WEC Group)

Welding Manufacturing Sites: N/A

Address: 7040-7060, Middlemarch Business Park, Siskin Pkwy E, Coventry, CV3 4PE

Is certified to perform welding under classification level CL 1 according to EN 15085-2

Types of activities performed. P = Production

Field of application: EN 15085 CL1, CL2 and CL3 products, C-Mn steels, Cr-Mo steels, Q and T steels, stainless steels, nickel-chromium alloys and aluminium alloys.

Range of Qualification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Thickness range for Fillet welds and Butt welds
131 MIG	Group 22 Non heat treatable alloys	Fillet Welds: 1,5mm – 31mm Butt Welds: 3mm – 20mm
	Group 23.1 Al-Mg-Si heat treatable alloys	
	Group 43 Nickel Chromium alloys Ni ≥ 40%	Fillet welds: ≥ 5mm Butt welds: 6mm – 32mm
135: MAG solid wire	Group 1 C-Mn Steels R_{eH} ≤360N/mm²	Fillet welds: ≥1,4mm Butt welds 0,8mm – 80mm
	Group 3 Quenched & Tempered steels	Fillet welds: 2,1mm – 32mm Butt welds: 3mm – 32mm
	Group 8 Austentic stainless steels with Cr ≤19%	Fillet welds: ≥1,5mm Butt welds: 1,5mm – 40mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%	Fillet welds: ≥3mm Butt welds: 3mm – 60mm
136: MAG with flux cored wire	Group 1 C-Mn Steels R_{eH} ≤360N/mm²	Fillet welds: ≥3mm Butt welds: 3mm – 64mm
	Group 3 Quenched & Tempered steels	Fillet welds: 3mm – 18mm Butt welds: 5mm – 20mm
	Group 8 Austentic stainless steels with Cr ≤19%	Fillet welds: ≥5mm Butt welds: 20mm – 90mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%	Fillet welds: ≥5mm Butt welds: 3mm – 70mm