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 certification level CL 1 according to EN 15085-2

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 Certification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for fillet welds	Material thickness range for butt welds
111: MMA	Group 1 C-Mn steels	5mm & above	3mm – 90mm
	Group 3 Quenched and tempered steels	3mm – 7,6mm	N/A
	Group 8 Austenitic stainless steels	N/A	3mm – 30mm
	Group 10 Austenitic ferritic stainless steels	5mm & above	3mm – 20mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	N/A	3mm – 11,1mm
121: SAW	Group 1 C-Mn steels	3mm – 20mm	3mm – 20mm
	Group 8 Austenitic stainless steels	6mm – 15,6mm	6mm – 15,6mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	3mm – 20mm	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31,7mm	3mm – 20mm
	Group 43 Nickel Chromium alloys	≥ 5mm	6mm – 32mm
135: MAG	Group 1 C-Mn steels	1,4mm & above	1,4mm – 80mm
	Group 3 Quenched and tempered steels	3mm & above	3mm – 30mm
	Group 7 Ferritic stainless steels	1,4mm – 4mm	N/A
	Group 8 Austenitic stainless steels	1,4mm & above	1mm – 60mm
	Group 10 Austenitic ferritic stainless steels	3mm & above	3mm – 60mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	5mm & above	N/A
136: FCAW	Group 1 C-Mn steels	3mm & above	3mm – 120mm
	Group 3 Quenched and tempered steels	3mm – 30mm	5mm – 20mm
	Group 5 Cr Mo steels	30mm – 120mm	N/A
	Group 8 Austenitic stainless steels	5mm & above	20mm – 80mm
	Group 10 Austenitic ferritic stainless steels	5mm & above	3mm – 70mm

141: TIG	Group 1 C-Mn steels	1,5mm – 50mm	1,5 mm – 50mm
	Group 3 Quenched and tempered steels	3mm – 12mm	7,5mm – 16,5mm
	Group 8 Austenitic stainless steels	0,75mm & above	0,75mm – 40mm
	Group 10 Austenitic ferritic stainless steels	1,6mm & above	1,6mm – 58,5mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	1,9mm & above	1,9mm – 11,1mm
	23.1 Heat treatable alloys: Al-Mg-Si alloys	1mm – 30mm	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	N/A	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, International / European Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP 3.2.1 Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, International / European Welding Technologist, HNC Mechanical and Manufacturing Engineering, CSWIP 3.1 Welding Inspector, NVQ Level 3 Fabrication and Welding, Level A

Wayland Sutton, CSWIP 3.1 Welding Inspector, Level C

Certificate Number: **CWRVC/027/GB**

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

Issued On: 12 May 2023

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 certification level CL 1 according to EN 15085-2

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 Certification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for fillet welds	Material thickness range for butt welds
111: MMA	Group 1 C-Mn steels	5mm & above	3mm – 90mm
	Group 3 Quenched and tempered steels with a minimum yield strength R_{eH}>360 N/mm^2	3mm – 7,6mm	N/A
	Group 8 Austenitic stainless steels	N/A	3mm – 30mm
	Group 10 Austenitic ferritic stainless steels	5mm & above	3mm – 20mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	N/A	3mm – 11,1mm
121: SAW	Group 1 C-Mn steels	3mm – 20mm	3mm – 20mm
	Group 8 Austenitic stainless steels	6mm – 15,6mm	6mm – 15,6mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	3mm – 20mm	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31,7mm	3mm – 20mm
	Group 43 Nickel-Chromium alloys	≥ 5mm	6mm – 32mm
135: MAG	Group 1 C-Mn steels	1,4mm & above	1,4mm – 80mm
	Group 3 Quenched and tempered steels with a minimum yield strength ReH>360 N/mm2	3mm & above	3mm – 30mm
	Group 7 Ferritic stainless steels	1,4mm – 4mm	N/A
	Group 8 Austenitic stainless steels	1,4mm & above	1mm – 60mm
	Group 10 Austenitic ferritic stainless steels	3mm & above	3mm – 60mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	5mm & above	N/A
136: FCAW	Group 1 C-Mn steels	3mm & above	3mm – 120mm
	Group 3 Quenched and tempered steels with a minimum yield strength ReH>360 N/mm2	3mm – 30mm	5mm – 20mm
	Group 5 Cr Mo steels	30mm – 120mm	N/A
	Group 8 Austenitic stainless steels	5mm & above	20mm – 80mm
	Group 10 Austenitic ferritic stainless steels	5mm & above	3mm – 70mm

141: TIG	Group 1 C-Mn steels	1,5mm – 50mm	15 mm – 50mm
	Group 3 Quenched and tempered steels with a minimum yield strength ReH>360 N/mm2	3mm – 12mm	7,5mm – 16,5mm
	Group 8 Austenitic stainless steels	0,75mm & above	0,75mm – 40mm
	Group 10 Austenitic ferritic stainless steels	1,6mm & above	1,6mm – 58,5mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	1,9mm & above	1,9mm – 11,1mm
	23.1 Heat treatable alloys: Al-Mg-Si alloys	1mm – 30mm	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	N/A	3mm – 20mm
[a]Provided Al-Mg filler material is used			

Responsible Welding Coordinator:
William Barr IEng MWeldI, International / European Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP 3.2.1 Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, International / European Welding Technologist, HNC Mechanical and Manufacturing Engineering, CSWIP 3.1 Welding Inspector, NVQ Level 3 Fabrication and Welding, Level A

Wayland Sutton, CSWIP 3.1 Welding Inspector, Level C

Certificate Number: CWRVC/058/GB

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

Issued On: 12 May /2023

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: 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 certification level CL 1 according to EN 15085-2

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 Certification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Material thickness range for fillet welds	Material thickness range for butt welds
111: MMA	Group 1 C-Mn steels	5mm & above	3mm – 90mm
	Group 3 Quenched and tempered steels	3mm – 7.6mm	N/A
	Group 8 Austenitic stainless steels	N/A	3mm – 30mm
	Group 10 Austenitic ferritic stainless steels	5mm & above	3mm – 20mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	N/A	3mm – 11,1mm
121: SAW	Group 1 C-Mn steels	3mm – 20mm	3mm – 20mm
	Group 8 Austenitic stainless steels	6mm – 15,6mm	6mm – 15,6mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	3mm – 20mm	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31,7mm	3mm – 20mm
	Group 43 Nickel Chromium alloys Ni ≥ 40%	≥ 5mm	6mm – 32mm
135: MAG	Group 1 C-Mn steels	1,4mm & above	1,4mm – 80mm
	Group 3 Quenched and tempered steels	3mm & above	3mm – 30mm
	Group 7 Ferritic stainless steels	1,4mm – 4mm	N/A
	Group 8 Austenitic stainless steels	1,4mm & above	1mm – 60mm
	Group 10 Austenitic ferritic stainless steels	3mm & above	3mm – 60mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	5mm & above	N/A
136: FCAW	Group 1 C-Mn steels	3mm & above	3mm – 120mm
	Group 3 Quenched and tempered steels	3mm – 30mm	5mm – 20mm
	Group 5 Cr Mo steels	30mm – 120mm	N/A
	Group 8 Austenitic stainless steels	5mm & above	20mm – 80mm
	Group 10 Austenitic ferritic stainless steels	5mm & above	3mm – 70mm

141: TIG	Group 1 C-Mn steels	1,5mm – 50mm	1,5 mm – 50mm
	Group 3 Quenched and tempered steels	3mm – 12mm	7,5mm – 16,5mm
	Group 8 Austenitic stainless steels	0,75mm & above	0,75mm – 40mm
	Group 10 Austenitic ferritic stainless steels	1,6mm & above	1,6mm – 58,5mm
	Group 11 Carbon steels with 0,25% < C ≤ 0,35%	1,9mm & above	1,9mm – 11,1mm
	23.1 Heat treatable alloys: Al-Mg-Si alloys	1mm – 30mm	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	N/A	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, International / European Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP 3.2.1 Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, International / European Welding Technologist, HNC Mechanical and Manufacturing Engineering, CSWIP 3.1 Welding Inspector, NVQ Level 3 Fabrication and Welding, Level A

Wayland Sutton, CSWIP 3.1 Welding Inspector, Level C

Certificate Number: CWRVC/059/GB

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

Issued On: 12 May 2023

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: 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 certification level CL 1 according to EN 15085-2

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 Certification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Thickness range for fillet welds	Thickness range for butt welds
131: MIG	Group 22.1 Al-Mg alloys	1,5mm – 31mm	3mm – 20mm
	Group 22.2 Al-Mg alloys with Mg ≤ 1.5%		
	Group 22.3 Al-Mg alloys with 1.5% < Mg ≤ 3.5%		
	Group 22.4 Al-Mg alloys with Mg > 3.5%		
	Group 23.1 Al-Mg-Si heat treatable alloys		
	Group 43 Nickel Chromium alloys Ni ≥ 40%	≥ 5mm	6mm – 32mm
135: MAG solid wire	Group 1 C-Mn Steels R_{eH} ≤360N/mm²	≥1,4mm	0,8mm – 80mm
	Group 3 Quenched & Tempered steels	2,1mm – 32mm	3mm – 32mm
	Group 8 Austentic stainless steels with Cr ≤19%	≥1,5mm	1,5mm – 40mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%	≥3mm	3mm – 60mm
136: MAG with flux cored wire	Group 1 C-Mn Steels R_{eH} ≤360N/mm²		3mm – 64mm
	Group 3 Quenched & Tempered steels	3mm – 18mm	5mm – 20mm
	Group 8 Austentic stainless steels with Cr ≤19%	≥5mm	20mm – 90mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%		3mm – 70mm

141: TIG solid wire	Group 1 C-Mn Steels R_{eH} ≤360N/mm²	1,4mm – 50mm	3mm – 6mm
	Group 3 Quenched & Tempered steels	3mm – 12mm	N/A
	Group 8 Austentic stainless steels with Cr ≤19%	≥0,7mm	0,75mm – 20mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%	1,6mm – 6mm	1,6mm – 90mm
	Group 11 C-Mn steels with 0.30<C≤0.35	1,9mm – 11,08mm	
	Group 22.1 Al-Mg alloys	0,75mm – 10mm	1mm – 10mm
	Group 22.2 Al-Mg alloys with Mg ≤ 1.5%		
	Group 22.3 Al-Mg with 1.5% < Mg ≤ 3.5%		
	Group 22.4 Al-Mg with Mg > 3.5%		
	Group 23.1 Al-Mg-Si heat treatable alloys		
784: Short cycle drawn arc stud welding	Group 1 C-Mn Steels R_{eH} ≤360N/mm²	≥2,5mm	
	Group 8 Austentic stainless steels with Cr ≤19%	1,5mm – 6mm	
212: Direct spot welding	Group 1 C-Mn Steels R_{eH} ≤360N/mm²	3mm	

Responsible Welding Coordinator:
William Barr IEng MWeldI, International / European Welding Engineer, HNC Mechanical & Manufacturing Engineering, CSWIP 3.2.1 Senior Welding Inspector, Level A

Deputy responsible Welding Coordinator:
Tyler Atkinson EngTech TechWeldI, International / European Welding Technologist, HNC Mechanical and Manufacturing Engineering, CSWIP 3.1 Welding Inspector, NVQ Level 3 Fabrication and Welding, Level A

Wayland Sutton, CSWIP 3.1 Welding Inspector, Level C

Certificate Number: CWRVC/024/GB

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

Issued On: 12 May 2023

Head of Manufacturer Certification Body, TWI Certification Ltd

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