



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

The Company: HTA Group (Coventry)

Welding Manufacturing Sites:

Address: Units 7040 – 7060, Middlemarch Business Park, Siskin Parkway East, Coventry, CV3 4PE

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

Field of application: EN 15085-2 CL1, CL2 and CL3 products, C-Mn steels, Cr-Mo Steels, Q and T steels, Stainless steels, Nickel-Chromium alloys and Aluminium alloys without design.

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 – 20mm
	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	3mm – 7.8mm	5mm – 90mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	N/A	3mm – 11.08mm
121: SAW	Group 1 C-Mn steel	N/A	3mm – 20mm
	Group 8 Austenitic stainless steels	N/A	6mm – 15.6mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	N/A	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31.7mm	N/A
135: MAG	Group 1 C-Mn steels	1.4mm - above	1.4mm – 80mm
	Group 3 Quenched and tempered steels	3mm – 20mm	2.8mm – 30mm
	Group 8 Austenitic stainless steels	1.4mm & above	3mm – 40mm
	Group 10 Austenitic ferritic stainless steels	3mm & above	12.5mm – 50mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	N/A	3mm – 83mm
	Group 43 Nickel-Chromium alloys	N/A	3mm – 8mm
136: FCAW	Group 7 Ferritic stainless steels	1.4mm – 4mm	N/A
	Group 1 C-Mn steels	3.1mm & above	3mm – 120mm
	Group 3 Quenched and tempered steels	3mm – 30mm	5mm – 20mm
	Group 5 Cr Mo steels	N/A	30mm – 120mm
	Group 8 Austenitic stainless steels	N/A	20mm – 80mm
141: TIG	Group 10 Austenitic ferritic stainless steels	N/A	3mm – 70mm
	Group 1 C-Mn steels	1.4mm – 32mm	2.8mm – 25mm
	Group 3 Quenched and tempered steels	3mm – 12mm	7.5mm – 16.5mm
	Group 8 Austenitic stainless steels	0.7mm – 30mm	1.65mm – 40mm
	Group 10 Austenitic ferritic stainless steels	N/A	1.6mm – 58.5mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	1.9mm – 11.08mm	1.9mm – 83mm
	Group 22 & 23 Aluminium alloys	1.5mm – 12mm	3mm – 30mm
Group 43 Nickel-Chromium alloys	N/A	3mm – 16mm	

Responsible Welding Coordinator: Vasyi Kruk EngTech MWeldI (d.o.b 10th January 1980), Certified International/European Welding Engineer (Level A)

Deputy Responsible Welding Coordinator: William Barr AWeldI (d.o.b 2nd March 1985), CSWIP Senior Welding Inspector 3.2.1 (Level B)

Certificate Number: CWRVC/024/GB

Valid Until: 12 February 2020
(subject to satisfactory periodic surveillance)

Issued On: 24 February 2017

TWI Certification Ltd, Chief Executive

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