



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

The Company: WEC Group

Welding Manufacturing Sites: Laser Engineering UK

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 $0,25\% < C \leq 0,35\%$	N/A	3mm – 11.1mm
121: SAW	Group 1 C-Mn steel	3mm – 20mm	3mm – 20mm
	Group 8 Austenitic stainless steels	6mm – 15.6mm	6mm – 15.6mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	3mm – 20mm	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31.7mm	3mm – 20mm
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 $0,25\% < C \leq 0,35\%$	5mm & above	N/A
	Group 43 Nickel-Chromium alloys	3mm – 8mm	3mm – 8mm

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 22.1 to 22.1 Aluminium-manganese alloys	1mm – 30mm	1mm – 30mm
	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	

^aProvided 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:
Mr Vasyi Kruk, IWE (d.o.b 10th January 1980) Level A

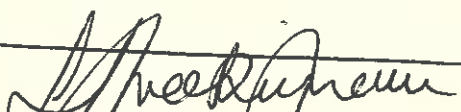
Deputy Responsible Welding Coordinator:
Mr William Barr, HNC, CSWIP Senior Welding Inspector, (d.o.b 2nd March 1985) Level A

Deputy Responsible Welding Coordinator:
Mr Tyler Atkinson, NVQ Level 3 (d.o.b 29th August 1999) Level C

Certificate Number: CWRVC/027/GB

Valid Until: 15/09/2023
(subject to satisfactory periodic surveillance)

Issued On: 01/10/2020


TWI Certification Ltd, Scheme Manager

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: WEC Group

Welding Manufacturing Sites: Welding Engineering

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 $0,25\% < C \leq 0,35\%$	N/A	3mm – 11.1mm
121: SAW	Group 1 C-Mn steel	3mm – 20mm	3mm – 20mm
	Group 8 Austenitic stainless steels	6mm – 15.6mm	6mm – 15.6mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	3mm – 20mm	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31.7mm	3mm – 20mm
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 $0,25\% < C \leq 0,35\%$	5mm & above	N/A
	Group 43 Nickel-Chromium alloys	3mm – 8mm	3mm – 8mm

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	

^aProvided 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:

Mr Vasyi Kruk, IWE (d.o.b 10th January 1980) Level A

Deputy Responsible Welding Coordinator:

Mr William Barr, HNC, CSWIP Senior Welding Inspector, (d.o.b 2nd March 1985) Level A

Deputy Responsible Welding Coordinator:

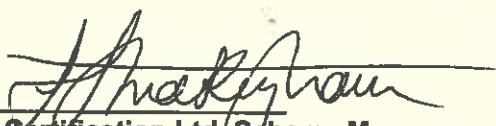
Mr Tyler Atkinson, NVQ Level 3 (d.o.b 29th August 1999) Level C

Certificate Number: CWRVC/027/GB

Valid Until: 15/09/2023

(subject to satisfactory periodic surveillance)

Issued On: 01/10/2020



TWI Certification Ltd/ Scheme Manager

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: WEC Group

Welding Manufacturing Sites: Special Projects

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 $0,25\% < C \leq 0,35\%$	N/A	3mm – 11.1mm
121: SAW	Group 1 C-Mn steel	3mm – 20mm	3mm – 20mm
	Group 8 Austenitic stainless steels	6mm – 15.6mm	6mm – 15.6mm
	Group 11 Carbon steels with $0,25\% < C \leq 0,35\%$	3mm – 20mm	3mm – 20mm
131: MIG	Group 22 & 23 Aluminium alloys	3mm – 31.7mm	3mm – 20mm
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 $0,25\% < C \leq 0,35\%$	5mm & above	N/A
	Group 43 Nickel-Chromium alloys	3mm – 8mm	3mm – 8mm

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	

^aProvided 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:

Mr Vasyk Kruk, IWE (d.o.b 10th January 1980) Level A

Deputy Responsible Welding Coordinator:

Mr William Barr, HNC, CSWIP Senior Welding Inspector, (d.o.b 2nd March 1985) Level A

Deputy Responsible Welding Coordinator:

Mr Tyler Atkinson, NVQ Level 3 (d.o.b 29th August 1999) Level C

Certificate Number: CWRVC/027/GB

Valid Until: 15/09/2023

(subject to satisfactory periodic surveillance)

Issued On: 01/10/2020



TWI Certification Ltd, Scheme Manager

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