



AC 161



Polska

CERTIFICATE

WELDING OF RAILWAY VEHICLES AND COMPONENTS acc. PN-EN 15085-2:2021

Manufacturer: **Stadler Środa Sp. z o.o.**
 ul. Brodowska 38C
 63-000 Środa Wielkopolska, Poland

fulfills the requirements to perform welding work within the range

Classification level CL1 according to PN-EN 15085-2:2021

Type of activity: P, M, S
Type of components: Manufacturing of:
 - rail vehicles and their components
 - non-pressurised containers without special test pressure
 Purchase and assembly of components of railway vehicles.

Range of approval:

Welding process acc. PN-EN ISO 4063	Material group acc. ISO/TR 15608	Dimensions	Notes
131	22.3	1,0 – 4,0	---
131	22.3	1,0 – 4,0	FW
135	1.2	3,0 – 120,0 / Ø ≥ 44,4	---
135	1.2	2,1 – 120,0	FW

Continuation of the range of approval on the subsequent page

Welding coordinator: Arkadiusz Osowski, IWE
Deputy of welding coordinator: Tobiasz Dolata, IWE
Additional coordinators: See reverse
Certificate no.: TSP-15085-202.00
Valid: From 28.11.2022 to 27.11.2025
Next surveillance audit: until 13.10.2023
Date of issue: 28.11.2022
Auditor: Piotr Wereszczyński



(PP05-F03-15085 issue.5 valid from 01-09-2021)


 Artur Labus
 Director of Certification Centre

TÜV SÜD Polska Sp. z o.o.
ul. Podwale 17
00 – 252 Warszawa

Range of approval (continuation):

Welding process acc. PN-EN ISO 4063	Material group acc. ISO/TR 15608	Dimensions	Notes
135	1.2	8,0 – 42,0	cast
135	1.3	1,0 – 6,0	--
135	1.3	1,4 – 6,0	FW
135	1.2 + 1.4	1,4 – 4,0	---
135	1.2 + 1.4	1,4 – 4,0	FW
135	1.2 + 7.1	4,0 – 9,6	FW
135	1.4	1,0 – 40,0 / $\varnothing \geq 44,4$	---
135	1.4	1,4 – 24,0	FW
135	1.4 + 7.1	1,0 – 12,0	---
135	1.4 + 7.1	1,4 – 9,6	FW
135	2.2	3,0 – 20,0	---
135	2.2	5,0 – 20,0	FW
135	2.2 + 1.,2	3,0 – 20,0	---
135	2.2 + 1.2	5,0 – 20,0	FW
135	5.1 + 2.1	3,0 – 20,0	---
135	5.1.+ 2.1	2,1 – 20,0	FW
135	7.1	1,4 – 24,0	---
135	7.1	0,7 – 24,0	FW
135	7.1 + 1.2	1,0 – 20,0	---
135	7.1 + 1.2	1,4 – 20,0	FW
135	7.2 + 1.2	3,0 – 10,0	---
135	7.2 + 1.2	3,0 – 10,0	FW
135	7.2 + 7.1	3,0 – 10,0	---
135	7.2 + 7.1	3,0 – 10,0	FW
135	8.1	1,4 – 45,5	---
135	8.1	1,4 – 24,0	FW
135	8.1 + 7.1	1,4 – 20,0	---
135	8.1 + 7.1	1,4 – 60,0	FW
135	8.1 + 1.2	1,4 – 20,0	---
135	8.1 + 1.2	1,4 – 20,0	FW
135	8.1 + 1.3	1,5 – 6,0	---
135	8.1 + 1.3	2,1 – 6,0	FW
135	8.1 + 1.4	1,0 – 4,0	---
135	8.1 + 1.4	1,4 – 4,0	FW
135	10.1	1,75 – 24,0	---



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135	10.1	1,25 – 24,0	FW
135	10.1 + 1.4	3,0 – 24,0	---
135	10.1 + 1.4	3,0 – 24,0	FW
135	10.1 + 3.1	3,0 – 24,0	---
135	10.1 + 3.1	≥ 3,0	FW
135	10.1 + 8.1	1,4 – 4,0	FW
141	1.2	3,0 – 8,0	---
141	1.2	3,0 – 8,0	FW
141	22.3	1,0 – 4,0	---
141	22.3	3,0 – 10,0	FW
141	10.1	0,75 – 5,0	---
141	10.1	1,4 – 4,0	FW
141	10.1 + 8.1	1,4 – 4,0	FW
141	10.1 + 8.2	1,4 – 4,0	FW
141	10.1	0,75 – 10,0	plug weld
212	7.1	2,5	spot welding
212	10.1	1,5	spot welding
212	10.1	1,5 + 2,0	spot welding
212	10.1	1,5 + 2,5	spot welding
212	10.1	1,5 + 3,0	spot welding
212	10.1	2,0 + 3,0	spot welding
783	1.4 + 8.1	---	M8
141 + 135	1.2	3,0 – 24,0	---
141 + 135	1.2	6,0 – 24,0	FW

Additional welding coordinators:

Leszek Socha, IWP

General regulations

according to PN-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.

Notes on certificate / extensions:

The certification was granted in accordance with the certification program PR15085 as at 05.05.2021.

The validity of the certificate may be confirmed by scanning the QR code or visit the web address:

<https://www.tuvsud.com/pl-pl/resource/wyszukiwarka-certyfikatow>

Warsaw, 28.11.2022




Artur Labus
Director of Certification Centre