

CERTIFICATE

Welding of railway vehicles and components according to EN 15085-2

This is to certify that **ExTe Fabriks AB**

Grundbergsvägen 6, Box 18

SE-82041 Färila

is qualified to perform welding work within the range of certification of:

Certification level CL2 according to EN 15085-2

Field of application: • Fabrication of parts for railway vehicles(bunks, stakes, tensioners for securing cargo)

Range of certification

Welding process according to DIN EN ISO 4063	Material group according to GEN ISO/TR 15608	Dimensions	Comments
138	3.2	t = 1.2 - 1.8 mm	BW, manuell and semi-automatic FW
	2.2	t = 3 - 12 mm	

Responsible welding coordinator: Pär Olsson (IWS)

born: 01.08.1978

Deputy with equal rights: -

Deputy: see reverse


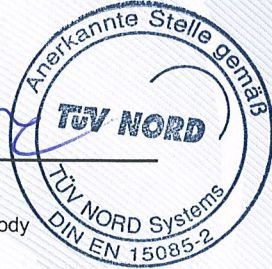
Comments: see reverse

Certificate no.: TÜVNORD/15085/CL2/028/1/02

Valid: from 15.12.2011 to 14.12.2014

Issued on: 02.11.2011

Auditor: Sturmhöwel
General regulations (see reverse)



 Neumann
 head of certification body



Report

on the certification / verification pursuant to DIN EN 15085-2 – Welding of railway vehicles and components

Welding manufacturer: **ExTe Fabriks AB**
Street, no.: **Box 18**
Postcode, town/city, state: **SE-820 41 Färila**

Date of the verification: 25 October 2011

Manufacturer certification body: TÜV NORD Systems GmbH & Co. KG
Auditor(s): H.-M. Sturmhöwel

Verification on the basis of the application dated: 10 October 2011

Participants from the welding manufacturer:

Pär Olsson, Lennart Wallström, Peter Skalberg, Leif Jonsson

- Welding coordinators:

Pär Olsson, Leif Jonsson

- Other participants:

Reason of the audit:

- Initial inspection
- Modification; reason
- Verification during the period of validity
- Recurrent inspection after the end of the period of validity
- _____

The verification covered:

- Information contained in the application and the description of the facility
- Availability and knowledge of generally accepted rules of technology
- (DIN EN 15085 series), the EN and ISO standards and other contractually agreed codes of practice and/or guidelines
- Project planning / design / technology
- Manufacture / production / ~~repair welding of railway vehicles~~, components or Subassemblies
- Quality assurance for the production and repair of railway vehicles, components or subassemblies
- Documentation
- Welder / welding operator qualification tests, production weld tests
- Evaluation of test specimens by the welding coordinators
- WPQRs, WPSs and other welding planning documents
- Purchase & resale or purchase & assembly of welded components and Subassemblies
- Compliance with the requirements of the DIN EN 15085 series of standards
- Compliance with the requirements of DIN 27201-6

1. Results:

- Welding coordinator(s):

The following welding coordinators were examined:

Responsible welding coordinator: Pär Olsson, 1978-08-01, EWS

First name, family name, date of birth, qualification

For an external welding coordinator, state the registered office of the primary employer.

Deputy with equal rights: Leif Jonsson, 1952-10-11, EWS

First name, family name, date of birth, qualification

Additional deputies: Anita Olsson, 1965-03-21, EWS

First name, family name, date of birth, qualification

1.1 Organizational integration of the welding coordinators:

Tasks and areas of competence of the welding coordinators:

Implementation of DIN EN ISO 14731: yes / \neq

Organization chart showing the independence of the welding coordinators: yes /

\neq

Implementation of DIN EN ISO 3834 Part(s) 2, ~~3~~, 4 (delete as applicable).

1.2 Evaluation of test specimens by the welding coordinator(s):

For the evaluation, no separate test specimens were welded but existing test specimens were examined (Macro examination). ¹⁾

The following tests were made under the guidance and supervision of the welding coordinator(s): (filled weld) ¹⁾

WPS no.	Test specimens	Kind of test	Evaluation by		
			Responsible welding coordinator	additional welding coordinator	inspector
ExTe201-4	FW	VT, break test	S	S	S
ExTe101	Double flanged butt weld	Macro examination	S	S	S

Comments:

List of welder / welding operator qualification test certificates is available: yes / \neq

List of WPQRs / WPSs is available: yes / \neq

Internal DIN EN 473 staff: yes / \neq

Production weld tests performed and documented: yes / \neq

¹⁾ Delete as applicable

2. Equipment:

- Basic equipment: conditions satisfied / ~~partly satisfied~~ / ~~not satisfied~~
- Additional equipment (e.g. turning devices, clamps and fixtures etc.): conditions satisfied / ~~partly satisfied~~ / ~~not satisfied~~.

Comments:

3. Additional requirements:

- Conformity of welding consumables with DIN EN 15085-4: yes / ~~no~~
- Conformity of parent materials with DIN EN 15085-4: yes / ~~no~~
- Self-inspection by welder or welding operator pursuant to DIN EN 15085-5: yes / ~~no~~
- Contractual agreements on non-conformances: yes / ~~no~~
- Traceability contractually required: yes / no

4. Technical knowledge of the welding coordinators (as applicable):

Field	Contents (terms and definitions, examples of other applicable standard)	Resp. welding coord.	Deputy	Add. deputy
General: DIN EN 15085-1	Changes, application, terms and definitions, requirements	s	s	
Quality requirements and certification: DIN EN 15085-2	Quality requirements, technical requirements, testing laboratories: DIN EN ISO 3834 ff, DIN EN ISO/IEC 17025 Staff requirements, organization: DIN EN 287-1 / DIN EN ISO 9606-2 / DIN EN 1418, DIN EN ISO 14731, DIN EN 473 Welding procedure specs.: DIN EN ISO 14555, DIN EN ISO 15607, DIN EN ISO 15609, DIN EN ISO 15620	s	s	
Design requirements: DIN EN 15085-3	Design requirements, drawing data, tolerances: DIN EN 22553 , DIN EN ISO 13920 Weld performance classes and weld inspection classes, quality levels: DIN EN ISO 5817, DIN EN ISO 10042 Material selection: CEN ISO/TR 15608, requirements on weld joints, joint preparation: DIN EN ISO 9692-1,-2	s	s	

Field	Contents (terms and definitions, examples of other applicable standard)	Resp. welding coord.	Deputy	Add. deputy
Production requirements: DIN EN 15085-4	Planning documents: see section 4.1 Evidence of welding procedure specifications: DIN EN ISO 15610, DIN EN ISO 15611, DIN EN ISO 15612, DIN EN ISO 15613, DIN EN ISO 15614 ff, DIN EN ISO 15620, DIN EN ISO 14555 Production weld tests: DIN EN ISO 14555, DIN EN ISO 15613, DIN EN ISO 15614-13 Requirements on the welding: DIN EN 1011ff , DIN EN ISO 13916, DIN EN ISO 9013 Consumables: DIN EN 13479, DIN EN 14532-1 to -2 Parent materials: DIN EN 10204, DIN EN 10025-1 to -6, DIN EN 10088-1-3, DIN EN 573-1 to -5 Welding procedures: DIN EN ISO 4063 Repair: DIN 27201-6	s	s	
Special issues	Special issues Subcontracted welding coordinators: DIN EN 15085-2, section 5.1.3 Certification: DIN EN 15085-2, section 6 Verification: DIN EN 15085-2, section 7 Part allocations: DIN EN 15085-2, Annex A Finishing welding: DIN EN 15085-4, section 5.4. Self-inspection by the welder or welding operator: DIN EN15085-5, section 4.4.2 Subcontracting: DIN EN 15085-5, section 8 Traceability: DIN EN 15085-5, section 10 Inspection and testing of welded joints: DIN EN 15085-5, Annex A	s	s	
Total result:		s	s	

Evaluation: s = satisfied, ns = not satisfied, ./ = not applicable *: tested at the manufacturer

Comments:

The regulations are available in a language that the welding coordinators understand:

yes / ~~no~~

The interview was an extended interview (welding coordinator without qualification according to IIW / EWF guidelines): yes / no

The need to comply with applicable national rules and regulations on occupational health and safety (e.g. BG rules) was pointed out: yes / ~~no~~

5. Range of certification:

Welding process according to DIN EN ISO 4063	Material group according to CEN ISO/TR 15608 and other materials	Range of certification WPS: $t_{min} - t_{max}$	Range of certification Welder / welding operator: $t_{min} - t_{max}$	Comments
136 (138)	2.2	3 – 12 mm	≥ 3 mm	FW
136 (138)	3.2	1,2 – 1,8 mm	----	Double flanged butt weld manual and semi-automatic

Field of application:

New manufacture of parts for rail vehicles according certification level CL2
 Bunks, Stakes, Tensioners for securing cargo

6. Overall evaluation:

The conditions for issuing the certificate are satisfied / ~~partly satisfied~~ / not satisfied.

Certification level: CL2

Required weld performance class: CPC2

weld inspection class: CT3

Field(s) of application: with / ~~without design~~

Declaration of conformity: according to DIN EN 10204 yes / no

Customer: Green Cargo, AAE Ahaus, Alstätter Eisenbahn, Transwaggon, Net rail,
Hecto Rail, TX- Logistik, Kiwi Rail

Subcontractors: Safe Control

Comments: No production in this time for railway

Conditions: Before starting new productions according railways components,
Requalification of welder performance and welding operator tests for material group
No. 3 and production test for material group No. 2 and 3, welding process 136 for butt
and fillet weld.

Place, date: Färila, 25 October 2011



Recognized auditor(s), name(s) and signature(s): H.- M. Sturmhöwel

Noted:

Place, date: Färila, 25 October 2011

Responsible welding coordinator of the welding manufacturer, name and signature:

Pär Olsson



Checkend / supplement:

Lennart Wallström



Place, date: Hamburg, 1. 11. 2011

Head / deputy of head of certification body, name(s) and signature(s):

