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

The Company: Hydram Engineering Ltd

Welding Manufacturing Sites: N/A

Address: Avenue 1, Chilton Industrial Estate, Chilton, Co. Durham, DL17 0SG

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

Types of activities performed. P = Production

Field of application: Fabrication and welding of carbon-manganese steels, stainless steels and aluminium alloys in conjunction with new build of railway vehicles and rail components to existing drawings and customer specifications "WITHOUT DESIGN". Small welding manufacturer with a single welding shop.

Range of Qualification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Dimensions
135: MAG solid wire	1.1 Steels $R_{eH} \leq 275N/mm^2$	1,4mm - 6mm
	1.2 Steels $R_{eH} > 275N/mm^2 \leq 360N/mm^2$	3mm - 40mm
	1.4 Steels with improved atmospheric corrosion resistance whose analysis may exceed the requirements for the single elements as indicated in Group 1	1mm - 4mm Butt welds 1mm - 3mm Fillet welds
141: TIG solid wire	1.2 Steels $R_{eH} > 275N/mm^2 \leq 360N/mm^2$	1,4mm – 9,6mm
	7.1 Ferritic stainless steels	0,75mm – 3mm Butt welds 1,05mm – 3mm Fillet welds
	8.1 Austenitic stainless steel with Cr ≤ 19%	1,75mm – 3mm Fillet weld
		1,4mm - 4mm

141: TIG solid wire	22.1 to 22.1 Aluminium-manganese alloys	1,5mm - 6mm
	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	
	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]	
[a] Provided Al-Mg filler material is used		

Responsible Welding Coordinator:
Jeff Garner CEng FWeldI, MSc, Certified European / International Welding Engineer, Level A

Deputy responsible Welding Coordinator:
Alan Bailey, CSWIP 3.1 Welding Inspector, PCN II UT & MPI, Level C

Certificate Number: **CWRVC/029/GB**

Valid Until: 14 September 2026
(subject to satisfactory periodic surveillance)

Issued On: 15 September 2023

Head of Manufacturer Certification Body, TWI Certification Ltd

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

EUROPEAN FEDERATION FOR WELDING, JOINING AND CUTTING

Schedule Revision Date 15/09/2023 **Rev.** 6

Related to Certificate Number 160148/GB **Rev.** 1

Product/Construction standard(s)
EN 15085

Alternative Standard(s) (refer to EN ISO 3834-5, clause 4.1 b)

Welding Process(es) (EN ISO 4063)
MAG (135) / TIG (141)

Parent Material Group(s) (CEN ISO/TR 15608)
Group 1 / Group 7 / Group 8 / Group 11 / Group 22 / Group 23

Responsible Welding Coordination Personnel

Scheme	Name (Qualification)	Job Title	Technical knowledge
ISO 3834	J. Garner CEng FWeldI, MSc Certified European / International Welding Engineer	RWC	Comprehensive
	A. Bailey, CSWIP 3.1 Welding Inspector, PCN II UT & MPI	DRWC	Basic

ANBCC Certification Scheme Committee Representative
George Gair

George Gair

TWI Certification Ltd, United Kingdom

Scheme Manager

Emma Freckingham

INTERNATIONAL INSTITUTE OF WELDING

Schedule Revision Date 15/09/2023 **Rev.** 6

Related to Certificate Number 160148/GB **Rev.** 1

Product/Construction standard(s)
EN 15085

Alternative Standard(s) (refer to ISO 3834-5, clause 4.1 b)

Welding Process(es) (ISO 4063)
MAG (135) / TIG (141)

Parent Material Group(s) (ISO/TR 15608)
Group 1 / Group 7 / Group 8 / Group 11 / Group 22 / Group 23

Responsible Welding Coordination Personnel

Name (Qualification)	Job Title	Technical knowledge
J. Garner CEng FWeldI, MSc Certified European / International Welding Engineer	RWC	Comprehensive
A. Bailey, CSWIP 3.1 Welding Inspector, PCN II UT & MPI	DRWC	Basic

ANBCC Certification Scheme Committee Representative
George Gair

George Gair

TWI Certification Ltd, United Kingdom

Scheme Manager

Emma Freckingham