



025

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

The Company: HTA Group Limited

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	Thickness range for fillet welds	Thickness range for butt welds
131: MIG	Group 22.1 Al-Mg alloys	1.5mm – 31mm	3mm – 20mm
	Group 22.2 Al-Mg alloys with Mg ≤ 1.5%		
	Group 22.3 Al-Mg alloys with 1.5% < Mg ≤ 3.5%		
	Group 22.4 Al-Mg alloys with Mg > 3.5%		
	Group 23.1 Al-Mg-Si heat treatable alloys		
135: MAG solid wire	Group 1 C-Mn Steels $R_{eH} \leq 360N/mm^2$	≥1.4mm	0.8mm – 80mm
	Group 3 Quenched & Tempered steels	2.1mm – 32mm	3mm – 32mm
	Group 8 Austenitic stainless steel with Cr ≤19%	≥1.5mm	1.5mm – 40mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%	≥3mm	3mm – 60mm
	Group 43 Nickel Chromium alloys		6mm – 24mm
136: MAG with flux cored wire	Group 1 C-Mn Steels $R_{eH} \leq 360N/mm^2$	3mm – 18mm	3mm – 64mm
	Group 3 Quenched & Tempered steels		5mm – 20mm
	Group 8 Austenitic stainless steels with Cr ≤19%		20mm – 90mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%		3mm – 70mm
	Group 11 C-Mn steels with 0.30 < C ≤ 0.35		1.9mm – 11.08mm
141: TIG solid wire	Group 1 C-Mn Steels $R_{eH} \leq 360N/mm^2$	1.4mm – 50mm	3mm – 6mm
	Group 3 Quenched & Tempered steels	3mm – 12mm	N/A
	Group 8 Austenitic stainless steel with Cr ≤19%	≥0.7mm	0.75mm – 20mm
	Group 10 Austenitic ferritic stainless steels with Cr ≤24%	1.6mm – 6mm	1.6mm – 90mm
	Group 22.1 Al-Mg alloys	0.75mm – 10mm	1mm – 10mm
	Group 22.2 Al-Mg alloys with Mg ≤ 1.5%		
	Group 22.3 Al-Mg with 1.5% < Mg ≤ 3.5%		
	Group 22.4 Al-Mg with Mg > 3.5%		
Group 23.1 Al-Mg-Si heat treatable alloys			
784: Short cycle drawn arc stud welding	Group 1 C-Mn Steels $R_{eH} \leq 360N/mm^2$	≥2.5mm	
	Group 8 Austenitic stainless steels with Cr ≤19%	1.5mm – 6mm	
212: Direct spot welding	Group 1 C-Mn Steels $R_{eH} \leq 360N/mm^2$	3mm	

Responsible Welding Coordinator: Mr Vasy Kruck, European/International Welding Engineer (d.o.b 10th January 1980) Level A

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

Deputy Responsible Welding Coordinator: Tyler Atkinson AWeldI, NVQ Level 3 Diploma in Fabrication and Welding (d.o.b 29th August 1999) Level C

Certificate Number: CWRVC/024/GB

Valid Until: 18 May 2023
(subject to satisfactory periodic surveillance)

Issued On: 27 May 2020


TWI Certification Ltd, Scheme Manager

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