

CERTIFICATE

Welding of railway vehicles and
components according to EN 15085-2:2020

TÜVRh/15085/CL1/665/20/1A1

TÜV Rheinland Industrie Service GmbH hereby certifies that the welding company

Astra Rail Industries S.A.
a GREENBRIER Europe Company
Calea Aurel Vlaicu Nr. 41-43
310141 Arad
Romania

fulfills the requirements
for the scope according to


EN 15085-2:2020 classification level CL1
in the type of activity D, P, M

in the range indicated in the annex.

validity: 2024-02-13 until 2026-03-26

Cologne, 2024-02-13
Place and date of issue

Lead auditor: MIHAI-VLADIMIR


Dipl.-Ing. MAKOWKA
Head of certification body



TÜV Rheinland Industrie Service GmbH, Am Grauen Stein, 51105 Köln, Germany

Scope of the certificate

TÜVRh/15085/CL1/665/20/1A1

Scope:

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Remarks
111	1.2, 5.1/1.2 1.3 2.2 7.1 8 X120Mn12/1.2	t = 3 - 180 mm D ≥ 25 mm t = 3 - 30 mm t = 3 - 16 mm t = 3 - 10 mm t = 2 - 14 mm D ≥ 25 mm t = 2 - 30 mm	BW/FW, manually BW/FW, manually BW/FW, manually FW, manually BW/FW, manually FW, manually
121	1.2 1.3 7.1	t = 3 - 50 mm t = 3 - 24 mm t = 3 - 8 mm	BW/FW, fully mechanized BW, fully mechanized BW, fully mechanized
135	1.2 1.2 1.2/1.3 1.2/11 1.3 2.2 3.1 3.1 5.1/1.2 7.1 8/1.2 X120Mn12/1.2	t = 1 - 120 mm D ≥ 25 mm t = 3 - 50 mm D ≥ 100 mm t = 6 - 100 mm D ≥ 95 mm t = 8 - 18 mm D ≥ 25 mm t = 3 - 24 mm t = 3 - 20 mm t = 3 - 8 mm t = 3 - 55 mm t = 13 - 32 mm D ≥ 25 mm t = 2 - 6 mm t = 0.7 - 7 mm D = 3 - 12 mm t = 2 - 30 mm	BW/FW, partly mechanized BW/FW, robotic BW, partly mechanized BW, partly mechanized BW/FW, partly mechanized BW, partly mechanized FW, robotic BW/FW, partly mechanized BW, robotic FW, partly mechanized BW/FW, partly mechanized FW, partly mechanized
136	1.2 10 7.1 7.1/1.2, 7.2/1.2 8 8/1.2	t = 2 - 100 mm D ≥ 25 mm t = 3 - 16 mm t = 3 - 30 mm t ≥ 5 mm D ≥ 25 mm t = 2 - 24 mm t = 2 - 20 mm D ≥ 25 mm	BW/FW, partly mechanized BW, partly mechanized BW/FW, partly mechanized FW, partly mechanized BW, partly mechanized BW/FW, partly mechanized
138	1.2 3.1	t = 2 - 100 mm D ≥ 25 mm t = 3 - 30 mm	BW/FW, partly mechanized BW/FW, partly mechanized

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Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Remarks
138			
141	1.2 8 8/1.2	t = 2 - 6 mm t = 2 - 16 mm t = 5 - 20 mm D ≥ 25 mm	BW/FW, manually BW/FW, manually FW, manually
142	1.2	t = 5 - 32 mm	BW/FW, manually
24	1.2, 11/1.2	D ≥ 50 mm	BW, fully mechanized

Area of Application:

- New build, conversion and repair of rail vehicles and their components, Classification level CL 1 according to EN 15085-6 for repairing

Responsible welding coordinator(s):

Cristian Popa, Level A (IWE) born: 1972-03-12

1st deputy(ies) of the responsible welding coordinator(s):

Cristian Ciontutiu, Level A (IWE) born: 1979-07-19

Others deputies:

Narcis Valer Maxim, Level C (IWS) born: 1977-02-26
Flavius Marcut, Level C (IWS) born: 1973-02-20
Mihai Incicau, Level C born: 1971-07-23

Remarks:

Independent execution, evaluation and acceptance of welder/operator qualification performed by following welding coordinator: Cristian Popa, Cristian Ciontutiu

Register no.:

TÜVRh/15085/CL1/665/20/1A1

General provisions:

The General Terms and Conditions of the TÜV Rheinland Industrie Service GmbH apply in the currently valid version.

TÜV Rheinland Industrie Service GmbH, Am Grauen Stein, 51105 Köln, Germany