

# C E R T I F I C A T E

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

TÜVNORD/15085/CL1/202/14/4

TÜV NORD Systems GmbH & Co. KG hereby certifies that the welding company

**Spaleck GmbH & Co. KG**  
**Robert-Bosch-Straße 15**  
**46397 Bocholt**  
**Germany**

meets the requirements of the TNS-EN15085 certification scheme for the scope specified.  
The scope of application can be found on the following page.

**EN 15085-2 classification level CL1**  
**in the type of activity D, P**

validity: 2022-07-20 until 2025-07-20

date of issue: 2022-07-20  
File number: 8120601983  
Customer number: TN3836

Lead auditor: Dipl.-Ing. GRÖNING

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Dipl.-Ing. (FH) ROHARDT  
certification body



# Scope of the certificate

TÜVNORD/15085/CL1/202/14/4

## Scope:

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Remarks
135	1.2 1.2 1.2 1.2 1.2/8.1 1.2/8.1 3.1 8.1 8.1 8.1 8.1	t = 1.3 - 5.2 mm D ≥ 25 mm t ≥ 1.4 mm t = 1.4 - 30 mm t ≥ 3 mm t = 10 - 40 mm t = 3 - 24 mm t = 3 - 80 mm t = 2 - 24 mm t = 1.5 - 6 mm t ≥ 2 mm t = 3 - 10 mm t = 4 - 16 mm	BW, automatic FW BW FW, automatic, sl, ml BW, automatic BW FW BW BW, automatic FW, automatic BW FW
136	10.1	t = 5 - 10 mm	FW
141	1.2 1.2 1.2/8.1 10.1 22 22 23.1/22.4 23.1 8.1 8.1	t = 1 - 24 mm t = 1.4 - 8 mm t = 3 - 8 mm t = 3 - 40 mm t = 1 - 3 mm t = 1 - 4 mm t = 1.5 - 6 mm t = 1.5 - 6 mm t = 1 - 20 mm t = 1.5 - 10 mm	BW FW FW BW FW BW FW BW/FW BW FW
783	1.2, 8.1	-	stud diameter 8 - 16 mm

## Area of Application:

- New build of components for railway vehicles

## Responsible welding coordinator(s):

Sebastian Kock, Level A (IWT)

born: 1992-12-17

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

Thomas Rolke, Level A (IWT)

born: 1996-04-17

## Others deputies:

Tobias Bennink, Level C (IWS)

born: 1992-01-30

Simon Sanders, Level C (IWS)

born: 1990-08-07

## Remarks:

The welding coordinators Sebastian Kock, Thomas Rolke are authorised, within the scope of this certificate, to test welders/operators in accordance with the relevant standards.

## General provisions:

The General Terms and Conditions of the TÜV NORD Systems GmbH & Co. KG apply in the currently valid version. To verify the validity of the digital signature of the TÜV NORD Systems employee, the installation of the TÜV NORD Group master certificate is necessary: <https://www.tuev-nord.de/en/customer-login/digital-signature/>

