



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

The Company: MTL Advanced Ltd

Welding Manufacturing Sites: Rotherham Factory

Address: Grange Lane, Brinsworth, Rotherham, S60 5AE, United Kingdom

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

Field of application: Fabrication and welding of carbon-manganese steels and aluminium/aluminium alloys in conjunction with new build of railway vehicles and rail components to existing drawings and customer specifications without design.

Range of Certification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Dimensions
111: MMA	1.1 Steels $R_{eH} \leq 275N/mm^2$	3mm-32mm
	1.2 Steels $R_{eH} > 275N/mm^2 \leq 360N/mm^2$	
131: MIG	22.1, 22.2*, 22.3*, 22.4* Non heat treatable alloys Combinations between 22.1, 22.2*, 22.3* and 22.4*	3mm – 20mm
	23.1 Heat treatable alloys: Al Mg Si alloys	
135: MAG solid wire	1.1 Steels $R_{eH} \leq 275N/mm^2$	3mm – 60mm
	1.2 Steels $R_{eH} > 275N/mm^2 \leq 360N/mm^2$	3mm – 20mm
	2.2 Thermomechanically treated fine grade steels and cast steels with a specified minimum yield strength $R_{eH} > 460N/mm^2$	3mm – 120mm
	3.2 Quench and tempered fine grained steels with specific minimum yield strength $> 690N/mm^2$	3mm – 40mm
136: MAG flux-cored	8.1 Austenitic stainless steels with Cr $\leq 19\%$	3mm – 120mm
	1.1 Steels $R_{eH} \leq 275N/mm^2$	3mm – 40mm
	1.2 Steels $R_{eH} > 275N/mm^2 \leq 360N/mm^2$	3mm – 40mm
141: TIG	3.2 Quench and tempered fine grained steels with specific minimum yield strength $> 690N/mm^2$	3mm – 25mm
	1.1 Steels $R_{eH} \leq 275N/mm^2$	1.5mm – 6mm
	1.2 Steels $R_{eH} > 275N/mm^2 \leq 360N/mm^2$	3mm – 12mm
	21 Pure aluminium $\leq 1\%$ impurities or alloy content	3mm – 20mm
	23.1 Aluminium-magnesium silicon alloys	3mm – 20mm
	22.1, 22.2*, 22.3*, 22.4* Non heat treatable Al alloys combinations between 22.1, 22.2*, 22.3* and 22.4*	3mm – 20mm
	3.2 Quench and tempered fine grained steels with specific minimum yield strength $> 690N/mm^2$	3mm – 20mm
	8.1 Austenitic stainless steels with Cr $\leq 19\%$	3mm – 40mm
10.1 Austenitic ferritic stainless steels with Cr $\leq 24\%$	3mm – 40mm	

*Provided Al-Mg Filler material is used

Responsible Welding Coordinator: Vasyi Kruk (d.o.b 10th January 1980) (Level A) EngTech MWeldI, Certified European/International Welding Engineer.

Deputy Responsible Welding Coordinator: John George Cheetham (d.o.b 9th December 1963) (Level B) PCN Level 3 Welding Inspector

Certificate Number: CWRVC/011/GB

Valid Until: 7 August 2022
(subject to satisfactory periodic surveillance)

Issued On: 8 August 2019


TWI Certification Ltd, Chief Executive

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