



0025

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

The Company: MTL Advanced Ltd & DNA Metalwork

Welding Manufacturing Sites: N/A

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

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"

Range of Qualification:

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Dimensions
111: MMA	1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$	3mm – 32mm
	1.2 Steels with a specified minimum yield strength $\leq 275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$	
131: MIG	22 Non heat treatable alloys	3mm – 20mm
	23.1 Aluminium-magnesium-silicon alloys	
135: MAG solid wire	1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$	Butt and Fillet Weld 1,5mm – 60mm
	1.2 Steels with a specified minimum yield strength $\leq 275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$	
	2 Thermomechanically treated fine-grain steels and cast steels with a specified minimum yield strength $R_{eH} > 360 \text{ N/mm}^2$	Butt and Fillet Weld 1,5mm – 20mm
	3 Quenched and tempered fine-grain steels except stainless steels with a specified minimum yield strength $R_{eH} > 360 \text{ N/mm}^2$	Butt and Fillet Weld 1,5mm – 120mm
	8.1 Austenitic stainless steels with $\text{Cr} \leq 19 \%$	3mm – 40mm

Welding Process according to EN ISO 4063	Material Group according to CEN ISO/TR 15608	Dimensions
136: MAG flux cored	1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$	3mm – 120mm
	1.2 Steels with a specified minimum yield strength $\leq 275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$	
	3.2 Quenched and tempered fine-grain steels with a specified minimum yield strength $R_{eH} > 690 \text{ N/mm}^2$	3mm – 40mm
141: TIG	1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$	3mm – 25mm
	1.2 Steels with a specified minimum yield strength $\leq 275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$	
	3.2 Quenched and tempered fine-grain steels with a specified minimum yield strength $R_{eH} > 690 \text{ N/mm}^2$	3mm – 12mm
	8.1 Austenitic stainless steels with Cr $\leq 19 \%$	3mm – 20mm
	10.1 Austenitic ferritic stainless steels with Cr $\leq 24 \%$ and Ni $> 4 \%$	3mm – 40mm
	21 Pure aluminium $\leq 1 \%$ impurities or alloy content	1,5mm – 6mm
	22 Non heat treatable alloys	3mm – 12mm
23.1 Aluminium-magnesium-silicon alloys		

Responsible Welding Coordinator:
Vasyl Kruk, European / International Welding Engineer, Level A

Deputy responsible Welding Coordinator:
William Barr, European / International Welding Engineer, Level A
John Cheetham, PCN Level 3 Senior Welding Inspector, Level B

Certificate Number: CWRVC/011/GB

Valid Until: 28 September 2025
(subject to satisfactory periodic surveillance)

Issued On: 9 August 2024



Head of Manufacturer Certification Body, TWI Certification Ltd

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