



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

The Company: Impressive Welding Limited

Welding Manufacturing Sites: N/A

Address: Ryton Industrial Estate, Newburn Bridge Road, Blaydon-on-Tyne, NE21 4SQ

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 of railway vehicle components

Range of Qualification:

| Welding Process according to EN ISO 4063 | Material Group according to CEN ISO/TR 15608                                                                                                    | Dimensions                                                |
|------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------|
| MIG (131)                                | Group 22 Non heat treatable alloys                                                                                                              | Fillet welds: 3mm – 40mm                                  |
|                                          | Group 23.1 Al-Mg-Si alloys                                                                                                                      |                                                           |
| MAG (135)                                | Group 1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$                                                       | Butt welds: 3mm – 40mm<br>Fillet welds: $\geq 3\text{mm}$ |
|                                          | Group 1.2 Steels with a specified minimum yield strength $275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$                                  |                                                           |
|                                          | Group 3.1 Quenched and tempered fine-grain steels with a specified minimum yield strength $360 \text{ N/mm}^2 < R_{eH} \leq 690 \text{ N/mm}^2$ | Fillet welds: $\geq 5\text{mm}$                           |
|                                          | Group 8.1 Austenitic stainless steels with Cr $\leq 19 \%$                                                                                      | Fillet welds: 3mm – 30mm                                  |
| MAG (136)                                | Group 1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$                                                       | Butt welds: 15mm – 80mm                                   |
|                                          | Group 1.2 Steels with a specified minimum yield strength $275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$                                  |                                                           |

| Welding Process according to EN ISO 4063 | Material Group according to CEN ISO/TR 15608                                                                   | Dimensions                                                  |
|------------------------------------------|----------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------|
| TIG (141)                                | Group 1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$                      | Butt welds: 3mm – 32mm<br>Fillet welds: $\geq 3\text{mm}$   |
|                                          | Group 1.2 Steels with a specified minimum yield strength $275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$ |                                                             |
|                                          | Group 8.1 Austenitic stainless steels with $\text{Cr} \leq 19 \%$                                              | Butt welds: 2,1mm – 24mm<br>Fillet welds: $\geq 3\text{mm}$ |
|                                          | Group 22 Non heat treatable alloys                                                                             | Butt & Fillet welds:<br>3mm – 12mm                          |
|                                          | Group 23.1 Al-Mg-Si alloys                                                                                     |                                                             |
|                                          | Group 34 Cu-Ni alloys                                                                                          | Butt welds: 3mm – 16mm                                      |
|                                          | Group 35 Cu-Al alloys                                                                                          |                                                             |

**Responsible Welding Coordinator:**

Keith Temperley MWeldI, CSWIP Welding Inspector, HNC Mechanical Engineering, Level A

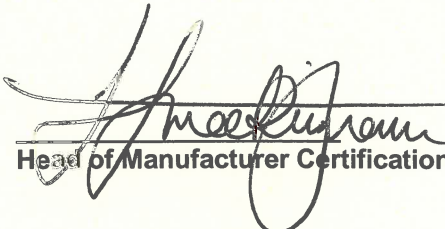
**Deputy responsible Welding Coordinator:**

Michael Errington, HNC Fabrication & Welding, Level C  
Michael Emberson, NVQ Level 2 Fabrication & Welding, Level C

**Certificate Number:** CWRVC/082/GB

**Valid Until: 19 November 2027**  
(subject to satisfactory periodic surveillance)

**Issued On: 20 November 2024**



Head of Manufacturer Certification Body, TWI Certification Ltd

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