

Certification Body No.3110 accredited by ČIA according to ČSN EN ISO/IEC 17065:2013
issued a

CERTIFICATE

No. C1-144/2405 R4 Z1

for the welding process according to EN 15085-2
for company

KASPER KOVO s.r.o.

Headquarters: Žitná 476, 541 03 Trutnov - Poříčí

ID: 465 08 465

Workshop Žitná, Žitná 476, 541 03 Trutnov - Poříčí

Workshop Elektrářenská, Elektrářenská 322, 541 03 Trutnov - Poříčí

The company has demonstrated compliance with the standard

EN 15085-2:2020+A1:2023

Classification level: CL 1

Type of activity: D, P, S

An integral part of the certificate is Appendix No. 1 to 3

Certification validity: from 11.04.2024 until 10.04.2027

Place and date of issue: Prague, 25.04.2025




Dipl.-Ing. Pavel Flégel
Deputy head of CB

The result of the certification concerns only the subject of the assessment, with the application of the certification scheme NKV-CS-001.
The validity of the certificate is subject to regular surveillance.

This document replaces the issue dated of 11.04.2024 and may be reproduced only in its entirety.

Appendix No. 1 to Certificate No. C1-144/2405 R4 Z1 - applies to workshop Žitná

1.	Type / Product type:		Railway vehicles and their components		
2.	Product standards:		EN 15085 part 1 – 6		
3.	Classification level	Type of activity	Type of welded components		Location of activity
	CL 1	D	Calculation, design and documentation for the production of welded components of RWV.		Žitná 476, 541 03 Trutnov - Poříčí
		P	Manufacturing, modification and testing of welded components of RWV, including replacement parts.		
		S	Purchase and supply of welded components for new fabrication activities without carrying out welding operations.		
4.	Welding coordination personnel				
Name		Birthdate	Qualification/ Diploma	Function / level of knowledges acc. to EN 15085-2:2020+A1:2023 art. 5.3.1	
Adam Teplý		11.06.1987	IWT/CZ 14035	Responsible welding coordinator / A	
Petr Dadok		07.04.1984	CZ/IWT/21007	1st deputy of the responsible WC / A	
Michal Krumpholz		23.12.1972	IWP/CZ 04003	Deputy of welding coordinator / C	
5.	Scope of the certificate				
acc. to documented WPQR and welders/operators certificates with the test acc. to EN ISO 9606 part 1 and 2/EN ISO 14732					
Welding process acc. to EN ISO 4063		Material group acc. to CEN ISO/TR 15608	Dimensions: range of thicknesses t and diameters D /mm/		Type of weld and remarks
135		1.2	t 1,75 – 24; D > 30,15		BW
			t 2 – 21,6; D > 30,15		FW
		8.1	t 1,5 – 1,82		plug weld
141		8.1	t 1,5 – 6		BW
			t 1,4 – 12		FW
			t ₁ 2,1 – 6 / t ₂ 3 – 6		FW
			t ₁ 3 – 10 / t ₂ 1,05 – 3		FW
			t ₁ 3 – 6,4 / t ₂ 1,4 – 4; D ≥ 16,85		FW
		10.1	t 3 – 10		BW
			t 3 – 6		FW
		22		t 3 – 24; D ≥ 25	
23.1		t 1,5 – 6		BW, FW	
141/135		8.2	t 8 – 32		BW
212		8.1	t 1,5 + 1,5		spot weld
			t 1,5 + 2,0		spot weld
			t 1,5 + 2,5		spot weld
			t 1,5 + 3,0		spot weld
		22	t 2,0 + 2,0		spot weld
			t 2,0 + 3,0		spot weld
232		8.1	t 1,5 + M3; M4; M5; M6; M8		projection weld
			t 2,0 + M4; M5; M6; M8; M10		projection weld
			t 3,0 + M4; M6; M8; M10		projection weld
786		8.1	t ≥ 0,5 / D 3 – 10		plate / bolt
		21, 22	t ≥ 0,5 / D 3 – 5		plate / bolt

Certification validity: from 11.04.2024 until 10.04.2027
Place and date of issue: Prague, 25.04.2025



[Signature]
Dipl.-Ing. Pavel Flégl
Deputy head of CB

Appendix No. 2 to Certificate No. C1-144/2405 R4 Z1 - applies to workshop Elektrárenská

1.	Type / Product type:	Railway vehicles and their components		
2.	Product standards:	EN 15085 part 1 – 6		
3.	Classification level	Type of activity	Type of welded components	Location of activity
	CL 1	D	Calculation, design and documentation for the production of welded components of RWV.	Elektrárenská 322, 541 03 Trutnov - Poříčí
		P	Manufacturing, modification and testing of welded components of RWV, including replacement parts.	
		S	Purchase and supply of welded components for new fabrication activities without carrying out welding operations.	
4.	Welding coordination personnel			
Name		Birthdate	Qualification/ Diploma	Function / level of knowledges acc. to EN 15085-2:2020+A1:2023 art. 5.3.1
Dipl.-Ing. Jan Erlebach		22.05.1969	IWE/CZ 10073	Responsible welding coordinator / A
Petr Dadok		07.04.1984	CZ/IWT/21007	1st deputy of the responsible WC / A
Radek Cinka		08.01.1974	CZ/IWP/20004	Deputy of welding coordinator / C
5.	Scope of the certificate			
acc. to documented WPQR and welders/operators certificates with the test acc. to EN ISO 9606 part 1 and 2/EN ISO 14732				
Welding process acc. to EN ISO 4063		Material group acc. to CEN ISO/TR 15608	Dimensions: range of thicknesses t and diameters D /mm/	Type of weld and remarks
111		1.1	$t_1\ 3 - 24; D_1 > 500 / t_2\ 12,5 - 50; D_2 \geq 90$	BW+FW
		1.2	$t\ 3 - 24; D \geq 25$	BW, FW
			$t\ 3 - 4; D\ 10,5 - 42$	FW
135		1.1	$t\ 3 - 24; D \geq 57,15$	BW, FW
			$t_1\ 2,1 - 6; D_1 \geq 138 / t_2\ 6,25 - 25; D_2 \geq 43,25$	FW
			$t_1\ 3 - 8; D_1 \geq 190 / t_2\ 5 - 20; D_2\ 5 - 20$	FW
			$t_1\ 16 - 64; D_1 \geq 150 / t_2\ 3 - 36; D_2 \geq 500$	BW
		1.2	$t\ 1,75 - 36; D > 150$	BW
			$t\ 3 - 17,4; D \geq 30,15$	BW, FW
			$t\ 3 - 20; D \geq 25$	BW, FW
			$t\ 1,75 - 21,6; D > 150$	FW
			$t_1\ 1,7 - 5; D_1 \geq 30,15 / t_2\ 1,8 - 9,6; D_2 \geq 10,6$	FW
		1.2/1.1	$t_1\ 1,7 - 5; D_1 \geq 200 / t_2\ 3 - 10; D_2 \geq 25$	FW
		8.1	$t\ 1,75 - 20; D \geq 150$	BW, FW
		8.2	$t_1\ 3 - 20; D_1 \geq 150 / t_2\ 3 - 17,48; D_2 \geq 30,15$	FW
135/121		1.2	$t\ 3 - 32; D > 150$	BW
		8.1	$t\ 3 - 20; D > 150$	BW

Certification validity: from 11.04.2024 until 10.04.2027

Place and date of issue: Prague, 25.04.2025




Dipl.-Ing. Pavel Flégl
Deputy head of QS

Appendix No. 3 to Certificate No. C1-144/2405 R4 Z1 - applies to workshop Elektrárenská

5. Scope of the certificate - continued			
acc. to documented WPQR and welders/operators certificates with the test acc. to EN ISO 9606 part 1 and 2/EN ISO 14732			
Welding process acc. to EN ISO 4063	Material group acc. to CEN ISO/TR 15608	Dimensions: range of thicknesses t and diameters D /mm/	Type of weld and remarks
141	1.1	t 2 – 5; D ≥ 18	BW, FW
		t ₁ 1,4 – 4; D ₁ ≥ 25 / t ₂ 11 – 44; D ₂ > 500	FW
	1.2	t ₁ 2 – 4; D ₁ 10,6 – 42,6 / t ₂ 3 – 12,6; D ₂ ≥ 25	BW, FW
	8.1	t 1,6 – 4,6; D 10,6 – 42,6	BW, FW
		t 1,4 – 2,6; D ≥ 25	BW, FW
		t 3 – 6,4; D ≥ 25	BW, FW
		t ₁ 10 – 40; D ₁ ≥ 25 / t ₂ 1,8 – 5,2; D ₂ ≥ 25	FW
		t ₁ 3 – 9; D ₁ ≥ 57,15 / t ₂ 3 – 12; D 10 – 40	FW
	8.2	t ₁ 3 – 32; D ₁ ≥ 30,15 / t ₂ 3 – 17,48; D ₂ ≥ 16,65	FW
		t 3 – 17,48; D ≥ 16,85	BW, FW
		t ₁ 9 – 36; D ₁ ≥ 150 / t ₂ 3 – 17,48; D ₂ ≥ 30,15	BW, FW
	1.1/8.1	t 3 – 4,6; D ≥ 30,2	BW
	1.2/8.1	t 2,3 – 4,6; D 21,3 – 42,6	BW
	22	t 3 – 24; D ≥ 25	BW, FW
141/135	8.1/1.1	t ₁ 3 – 20; D ₁ ≥ 150 / t ₂ 8,75 – 35; D ₂ ≥ 37,5	BW, FW
141/142	8.1	t ₁ ≥ 12; D ₁ ≥ 12 / t ₂ 2 – 4; D ₂ ≥ 12	tube plates / tube
142	1.1	t ₁ ≥ 18; D ₁ ≥ 12 / t ₂ 0,5 – 2; D ₂ ≥ 12	tube plates / tube
	8.2	t ₁ ≥ 16; D ₁ ≥ 12 / t ₂ 0,75 – 3; D ₂ ≥ 12	tube plates / tube
786	8.1	t ≥ 0,5 / D 3 – 10	plate / bolt
	21, 22	t ≥ 0,5 / D 3 – 5	plate / bolt

Certification validity: from 11.04.2024 until 10.04.2027

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