GSI SLV
SVV Praha

SVV Praha, s. r. o.
Certifikační orgán SVV Praha pro svařování

V 3110

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

C E R T I F I C A T E

No. C1-144/2104 R3 Z1

for the welding process according to ČSN 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 Elektrárenská: Elektrárenská 322, 541 03 Trutnov - Poříčí

The company has demonstrated compliance with the standard

ČSN EN 15085-2:2008

Certification level CL 1

An integral part of the certificate is Appendix No. 1 and No. 2

Certification validity: from 11.04.2021 until 10.04.2024
Place and date of issue: Prague, 05.04.2022

Dipl.-Ing. Pavel Flégl
Deputy head of CB

CERTIFIKAČNÍ ORGÁN č. 3110 GSI SLV SVV Praha SVV PRAHA

The result of the certification concerns only the subject of the assessment.
The validity of the certificate is subject to regular surveillance.
This document replaces the issue dated of 11.04.2021 and may be reproduced only in its entirety.

Appendix No. 1 to Certificate No. C1-144/2104 R3 Z1 – applies to workshop Žitná

1. Type / Product type: Railway vehicles
2. Product standards: EN 15085 part 1 – 5
   Certification level: CL 1
   Fields of application: manufacture of parts for railway vehicles, with design
3. Parent materials groups (according to CEN ISO/TR 15608): 1.2, 8.1, 10.1, 21, 22, 23.1
4. Welding processes and allied processes: (acc. ISO 4063): 135, 141, 212, 232, 786
5. Welding coordination personnel:

Name	Birthdate	Qualification	Function / Level of knowledges according ČSN EN 15085-2 art. 5.1.2
Dipl.-Ing. Petr Králík	26.02.1990	CZ/IWE/21027	Responsible welding coordinator / A
Heinz Kaufmann	13.09.1956	EWT/CZ 00173	Deputy of WC with equal rights / A
Michal Krumpholz	23.12.1972	IWP/CZ 04003	Deputy of welding coordinator / C
Radek Cinka	08.01.1974	CZ/IWP/20004	Deputy of welding coordinator / C

6. Permission ranges on the date of issue of the certificate – acc. to documented WPQR and welders'/operators´ certificates with the test acc. to EN ISO 9606-1,-2 / EN ISO 14732

Welding process acc. EN ISO 4063	Parent mater. group acc. CEN ISO/TR 15608	Dimensions: thickness t and diameter 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 – 4; D ≥ 31,65	BW
		t 1 – 1,3	FW
		t_1 2,1 – 6 / t_2 3 – 6	FW
	10.1	t 3 – 10	BW
		t 3 – 6	FW
	22	t 3 – 24; D ≥ 25	BW, FW
	23.1	t 1,5 – 6	BW, FW
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

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Appendix No. 2 to Certificate No. C1-144/2104 R3 Z1 - applies to workshop Elektrárenská

1. Type / Product type: Railway vehicles
2. Product standards: EN 15085 part 1 – 5
   Certification level: CL 1
   Fields of application: manufacture of parts for railway vehicles, with design
3. Parent materials groups (according to CEN ISO/TR 15608): 1.1, 1.2, 8.1, 21, 22
4. Welding processes and allied processes: (acc. ISO 4063): 111, 135, 135/121, 141, 786
5. Welding coordination personnel:

Name	Birthdate	Qualification	Function / Level of knowledges according ČSN EN 15085-2 art. 5.1.2
Dipl.-Ing. Jan Erlebach	22.05.1969	IWE/CZ 10073	Responsible welding coordinator / A
Dipl.-Ing. Josef Havelka	05.08.1959	IWE/CZ 04514	Deputy of WC with equal rights / A
Petr Dadok	07.04.1984	CZ/IWT/21007	Deputy of welding coordinator / B
Jiří Haken	23.04.1956	EWP/SK 00104	Deputy of welding coordinator / C
Radek Cinka	08.01.1974	CZ/IWP/20004	Deputy of welding coordinator / C

6. Permission ranges on the date of issue of the certificate – acc. to documented WPQR and welders'/operators´ certificates with the test acc. to EN ISO 9606-1,-2 / EN ISO 14732

Welding process acc. EN ISO 4063	Parent mater. group acc. CEN ISO/TR 15608	Dimensions: thickness t and diameter D /mm/	Type of weld and remarks
111	1.1	t_1 3 – 24; D_1 > 500 / t_2 12,5 – 50; D_2 ≥ 90	BW+FW
	1.2	t 3 – 24; D ≥ 25	BW, FW
		t 3 – 4; D 10,5 – 42	FW
135	1.1	t 3 – 24; D ≥ 57,15	BW, FW
		t_1 2,1 – 6; D_1 ≥ 138 / t_2 6,25 – 25; D_2 ≥ 43,25	FW
		t_1 3 – 8; D_1 ≥ 190 / t_2 5 – 20; D_2 5 – 20	FW
	1.2	t 1,75 – 36; D > 150	BW
		t 3 – 17,4; D ≥ 30,15	BW, FW
		t 3 – 20; D ≥ 25	BW, FW
		t 1,75 – 21,6; D > 150	FW
		t_1 1,7 – 5; D_1 ≥ 30,15 / t_2 1,8 – 9,6; D_2 ≥ 10,6	FW
	1.2/1.1	t_1 1,7 – 5; D_1 ≥ 200 / t_2 3 – 10; D_2 ≥ 25	FW
	8.1	t 1,75 – 20; D ≥ 150	BW, FW
135/121	1.2	t 3 – 32; D > 150	BW
	8.1	t 3 – 20; D > 150	BW
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
	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
786	8.1	t ≥ 0,5 / D 3 – 10	plate / bolt
	21, 22	t ≥ 0,5 / D 3 – 5	plate / bolt

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