

# CERTIFICATE

Welding of railway vehicles and  
components according to EN 15085-2

TÜVNORD/15085/CL1/065/06/6

TÜV NORD Systems GmbH & Co. KG hereby certifies that the welding company

**Hoedtke GmbH & Co. KG**  
**Industriestr. 2 - 6**  
**25421 Pinneberg**  
**Germany**

meets the requirements of the TNS-EN15085 certification scheme for the scope specified.  
The scope of application can be found on the following page.

**EN 15085-2 classification level CL1**  
**in the type of activity P**

validity: 2022-11-15 until 2025-11-14

date of issue: 2022-11-15  
File number: 8120936958  
Customer number: TN0844

Lead auditor: Dipl.-Ing. (FH) BREMER



Digitally  
signed by  
Rohardt Sven

Dipl.-Ing. (FH) ROHARDT  
certification body



# Scope of the certificate

TÜVNORD/15085/CL1/065/06/6

## Scope:

| Welding process according to EN ISO 4063 | Material group according to CEN ISO/TR 15608 | Dimensions  | Remarks  |
|--|--|---|--|
| 131                                      | 23   | t = 3 - 12 mm<br>D ≥ 500 mm   | FW, a-Maß 2 - 8 mm   |
| 135                                      | 1.1<br>2.1<br>2.1<br>8<br>8<br>8             | t = 2 - 8 mm<br>t = 3 - 8 mm<br>t = 3 - 8 mm<br>D ≥ 25 mm<br>t = 0.7 - 1.3 mm<br>t = 2 - 4 mm<br>t = 7 - 20 mm  | BW/FW<br>BW/FW<br>FW<br>BW<br>BW/FW<br>BW  |
| 141                                      | 1.1<br>2.1<br>23<br>8<br>8<br>8.2<br>8.2     | t = 1 - 6 mm<br>D ≥ 500 mm<br>t = 3 - 8 mm<br>D ≥ 500 mm<br>t = 3 - 12 mm<br>t = 0.8 - 5 mm<br>D ≥ 5 mm<br>t = 1.8 - 3 mm<br>D = 25 - 115 mm<br>t = 0.75 - 3 mm<br>t = 1.05 - 3 mm<br>D ≥ 50 mm | BW/FW<br>BW/FW<br>BW/FW<br>BW/FW<br>TIG- Orbital<br>BW<br>FW, Pipe branches 60-90° |
| 141/135                                  | 8  | t = 7 - 20 mm   | BW, HV/V(T-Stoß), t2=3-8 mm  |
| 521                                      | 8  | t = 0.8 - 4.8 mm  | BW   |
| 522                                      | 1.2<br>8                                     | t = 3.5 - 5 mm<br>t = 0.8 - 10 mm   | BW<br>BW/FW  |

## Area of Application:

- New build of components for railway vehicles

## Responsible welding coordinator(s):

Ingo Frithjoff Schollbach, Level A (IWE)

## 1st deputy(ies) of the responsible welding coordinator(s):

Detlef Brümmer, Level B (EWS)

## Others deputies:

Björn Heitmann, Level C (EWS)  
Andreas Gühlke, Level C (EWS)  
Christoph Sieck, Level C (EWS)

## Remarks:

The welding coordinators Ingo Frithjoff Schollbach, Detlef Brümmer, Andreas Gühlke are authorised, within the scope of this certificate, to test welders/operators in accordance with the relevant standards.

## General provisions:

The General Terms and Conditions of the TÜV NORD Systems GmbH & Co. KG apply in the currently valid version. To verify the validity of the digital signature of the TÜV NORD Systems employee, the installation of the TÜV NORD Group master certificate is necessary: <https://www.tuev-nord.de/en/customer-login/digital-signature/>

