

# Certificate

**TÜVNORD/15085/CL1/065/06/6A1**

Report no. / Manufacturer no. / Validity notice: 8122978397 / 10844 / 2024-10-28 - 2025-11-14

## **Welding of railway vehicles and components according to EN 15085-2:2020+A1:2023**

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

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

fulfills the requirements of the TNS-EN15085 certification scheme  
for the scope

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

in the range indicated in the annex.

Lead auditor:  
Dipl.-Ing. HOFFMANN

Hamburg, 2024-10-28

**TÜVNORD** Digitally  
signed by  
Rohardt Sven

certification body, Dipl.-Ing. (FH) ROHARDT

**TÜV NORD Systems GmbH & Co. KG**  
Große Bahnstraße 31, 22525 Hamburg  
tuev-nord.de | certifications@tuev-nord.de



## Scope of the certificate

### TÜVNORD/15085/CL1/065/06/6A1

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#### Scope:

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Remarks
131	23	t = 3 - 12 mm D ≥ 500 mm	FW, a-Maß 2 - 8 mm
135	1.1 2.1 2.1 8 8 8	t = 2 - 8 mm t = 3 - 8 mm t = 3 - 8 mm D ≥ 25 mm t = 0.7 - 1.3 mm t = 2 - 4 mm t = 7 - 20 mm	FW, BW FW, BW FW BW FW, BW BW
141	1.1 2.1 23 8 8 8.2 8.2	t = 1 - 6 mm D ≥ 500 mm t = 3 - 8 mm D ≥ 500 mm t = 3 - 12 mm t = 0.8 - 5 mm D ≥ 5 mm t = 1.8 - 3 mm D = 25 - 115 mm t = 0.75 - 3 mm t = 1.05 - 3 mm D ≥ 50 mm	FW, BW FW, BW FW, BW FW, BW TIG- Orbital BW 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 8	t = 3.5 - 5 mm t = 0.8 - 10 mm	BW FW, BW

#### Area of Application:

- New build of components for railway vehicles

#### Responsible welding coordinator(s):

Feidhlim Gardian, Level A (IWE)

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

Toste Hoop, Level A (IWE) [external]

#### Others deputies:

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

#### Remarks:

The welding coordinators Feidhlim Gardian, Toste Hoop, Detlef Brümmer are authorised, within the scope of this certificate, to test welders/operators in accordance with the relevant standards.

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Scope of the certificate