

CERTIFICATE

Welding of railway vehicles and components according to
EN 15085-2:2020+A2:2025

ZE-16083-01-00-EN15085-2019.0070.008

DVS ZERT GmbH hereby certifies that the welding company

**Przedsiębiorstwo Usług Technicznych
"FIRMUS" sp. z o.o.
Ul. Wspólna 21
32-300 Olkusz
Poland**

fulfills the requirements
for the scope according to

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

in the range indicated in the annex.

validity: 2026-06-19 until 2028-06-26

Düsseldorf, 2026-06-19
Place and date of issue

Lead auditor: M.Eng. SWIDER



Dipl.-Ing. GURSCHKE
Head of certification body

Scope of the certificate

ZE-16083-01-00-EN15085-2019.0070.008

Scope:

Welding process according to EN ISO 4063	Material group according to EN ISO 15608	Dimensions	Remarks
111	1.2	$t \geq 5 \text{ mm}$	FW
135/111	1.2	$t = 3 - 32 \text{ mm}$ $D \geq 24.15 \text{ mm}$	BW
135	1.2	$t \geq 1.4 \text{ mm}$	FW, FW
		$t = 1.4 - 32 \text{ mm}$ $D \geq 10 \text{ mm}$	FW, FW
		$t = 1.75 - 60 \text{ mm}$	BW, BW
		$t = 2.1 - 400 \text{ mm}$ $D \geq 50 \text{ mm}$	T Stoß BW
		$t = 3 - 12 \text{ mm}$ $D \geq 25 \text{ mm}$	BW, BW
		$t = 3 - 40 \text{ mm}$	FW, FW
	3.1	$t = 7.5 - 120 \text{ mm}$	BW, BW
	8.1	$t = 1.75 - 40 \text{ mm}$	BW, BW
		$t = 3 - 20 \text{ mm}$ $D \geq 10 \text{ mm}$	FW for rod
136	1.2	$t \geq 3 \text{ mm}$	FW, EN ISO 15614-1
138	1.2	$t \leq 5 \text{ mm}$ $D \geq 35 \text{ mm}$	FW
		$t = 2 - 50 \text{ mm}$ $D \geq 10 \text{ mm}$	FW, FW
		$t \geq 3 \text{ mm}$	FW, FW
	1.2, 1.2/2.1	$t = 3 - 50 \text{ mm}$	BW, BW
	1.2	$t = 3 - 120 \text{ mm}$	TBW
		$t = 15 - 60 \text{ mm}$ $D \geq 50 \text{ mm}$	BW, BW
	1.2/1.3	$t \geq 5 \text{ mm}$	FW, FW
		$t = 15 - 60 \text{ mm}$	BW, BW
		$t = 20 - 160 \text{ mm}$	TBW
	1.2/2.1	$t = 7.5 - 30 \text{ mm}$	BW, BW
	3.1	$t = 3 - 40 \text{ mm}$ $D \geq 25 \text{ mm}$	BW
		$t = 3 - 50 \text{ mm}$ $D \geq 25 \text{ mm}$	FW, EN ISO 15613
	3.1/2.2	$t = 3 - 40 \text{ mm}$	BW, EN ISO 15614-1
		$t = 30 \text{ mm}$ $D \geq 15 \text{ mm}$	TBW; EN ISO 15613
141/135	1.2	$t = 3 - 33.2 \text{ mm}$ $D \geq 11 \text{ mm}$	BW

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Welding process according to EN ISO 4063	Material group according to EN ISO 15608	Dimensions	Remarks
141	1.1/1.2	t = 2.1 - 16 mm D ≥ 3 mm	FW, EN ISO 15613
	1.2	t = 1 - 24 mm D ≥ 12.65 mm	FW, FW
		t = 1.4 - 24 mm	FW, FW
		t = 3 - 12 mm	BW, EN ISO 15614-1
		t = 3 - 160 mm	TBW; EN ISO 15614-1
	2.2/3.1	t ≥ 3 mm	FW, EN ISO 15614-1
		t = 3 - 40 mm D ≥ 20 mm	FW, EN ISO 15613
		t = 1 - 13 mm D ≥ 10 mm	BW, EN ISO 15613
	8.1	t = 1 - 30.8 mm D ≥ 28 mm	BW, EN ISO 15613
		t ≥ 1.4 mm	FW, FW
		t = 1.4 - 20 mm D ≥ 16.85 mm	FW, FW
		t = 1.5 - 100 mm	TBW; EN ISO 15614-1
		t = 3 - 20 mm	BW, EN ISO 15614-1
142/141	8.1	t = 1.5 - 16 mm	TBW
521	2.1/2.2	t = 4.8 - 12 mm	FW, EN ISO 15614-11
	3.1/1.3	t = 4.8 - 12 mm	FW
	8.1/1.2	t = 2.25 - 7.5 mm	FW, EN ISO 15614-11

Area of Application:

- New build of components for railway vehicles

Responsible welding coordinator(s):

Mariusz Chmiest, Level A (IWE)

born: 1978-05-11

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

Wojciech Tomal, Level A (IWE)

born: 1992-01-26

Others deputies:

Lukasz Kabat, Level C

born: 1982-05-08

Remarks:

Register no.:

DVSZERT/15085/CL1/070/19/2A1

General provisions:

The General Terms and Conditions of the DVS ZERT GmbH apply in the currently valid version.