

# CERTIFICATE

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

TÜVNORD/15085/CL1/106/09/4A1

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

**AQ Electric AD**  
**Rajko Daskalov 68**  
**2400 Radomir**  
**Bulgaria**

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: 2022-09-09 until 2024-12-16

date of issue: 2022-09-09  
File number: 8120630530  
Customer number: TN2430

Lead auditor: Dipl.-Ing. ZABROCKI

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Dipl.-Ing. (FH) ROHARDT  
certification body



# Scope of the certificate

TÜVNORD/15085/CL1/106/09/4A1

## Scope:

Welding process according to EN ISO 4063	Material group according to CEN ISO/TR 15608	Dimensions	Remarks
131	1 1 8/1.1	t = 1 - 2 mm t = 1 - 3 mm t = 3 - 12 mm	BW, (on Zink surface) FW, (on Zink surface) FW
135	1.1 1.2, 8 1.2 1.2 1.2/8.1 8	t = 0.7 - 24 mm t = 3 - 12 mm t = 3 - 16 mm t = 3 - 20 mm t = 3 - 20 mm t = 1 - 12 mm	BW/FW FW BW FW, robotic FW BW
138	1.2	t = 3 - 16 mm	FW, robotic
141	1 1.1 1.1 1.2 1.2 22/23 22.3 23.1 8.1 8.1 8.1 8.1	t = 2 - 6 mm t = 1.4 - 2.6 mm t = 3 - 5.2 mm t = 3 - 12 mm t = 3 - 12 mm t = 3 - 10 mm t = 0.5 - 6 mm t = 1.5 - 6 mm t = 0.7 - 18 mm t = 1 - 2 mm t = 1.4 - 3 mm t = 3 - 6.5 mm	FW BW BW BW FW BW/FW BW/FW BW/FW FW BW BW BW
21	1.1, 8 1.1 22.3 8.1	t = 0.3 - 2 mm t = 1 - 2 mm t = 2 - 3 mm t = 1 mm	TECNA TE 90 TECNA TYP 4625N SVGP 658 SNP + EK 61/M 109.401 TECNA 7913
23	8 8 8	t ≤ 2 mm t ≤ 2 mm t ≤ 3 mm	M5 SVGP 658 SNP + EK 61/M 109.401 M6 SVGP 658 SNP + EK 61/M 109.401 M10 SVGP 658 SNP + EK 61/M 109.401
783	1.1	t ≥ 3 mm	M12
784	8.1	-	M4 x 16 mm, M6 x 10 mm stud, SOYER Stud Welder BMS-8N
786	1, 8.1	t ≤ 2 mm	LBS + PKM - 1B

## Area of Application:

- New build of components for railway vehicles

## Responsible welding coordinator(s):

Ivan Yordanov Mariyanov, Level A (IWE)

born: 1975-10-04

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

Aneta Welinowa-Metodiewa, Level A (IWE)

born: 1979-08-16

## Others deputies:

Lyubomir Tanyov Lyubchov, Level C (IWS)

born: 1983-02-16

Viktor Yordanov Borisov, Level C (IWS)

born: 1974-10-19

## Remarks:

## 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/>

