



0025

Welding of Railway Vehicles and Components according to EN 15085-2

The Company: Lordgate Engineering Limited

Welding Manufacturing Sites: N/A

Address: 1 Stonehill, Huntingdon, PE19 6ED

Is certified to perform welding under classification level CL 1 according to EN 15085-2

Types of activities performed. D = Design, P = Production

Field of application: Design and manufacture (fabrication & welding) of components for internal / external application on railway vehicles in Carbon-manganese steels, Stainless steels and Aluminium / Aluminium alloys "WITH DESIGN". Small manufacturer.

Range of Qualification:

| Welding Process according to EN ISO 4063 | Material Group according to CEN ISO/TR 15608 | Dimension |
|--|---|--|
| 131: MIG - Solid Wire | Group 22 Non heat treatable alloys | Butt Weld: 3mm – 12mm |
| | Group 23.1 - Al-Mg-Si Heat treatable alloys | |
| 135: MAG - Solid Wire | Group 1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$ | Butt Weld: 3mm – 12mm Fillet Weld: 3mm – 25mm |
| | Group 1.2 Steels with a specified minimum yield strength $275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$ | |
| | Group 1.4 Steels with improved atmospheric corrosion resistance | |
| | Group 3.1 Quenched and tempered fine-grain steels with a specified minimum yield strength $360 \text{ N/mm}^2 < R_{eH} \leq 690 \text{ N/mm}^2$ | Fillet Weld: 3mm - 25mm |
| | Group 8.1 Austenitic stainless steels with Cr $\leq 19\%$ | Butt Weld: 3mm – 10mm |

| Welding Process according to EN ISO 4063 | Material Group according to CEN ISO/TR 15608 | Dimension |
|--|--|--|
| 141: TIG - Solid Wire | Group 1.1 Steels with a specified minimum yield strength $R_{eH} \leq 275 \text{ N/mm}^2$ | Butt Weld: 1mm – 4mm Fillet Weld: 3mm – 12mm |
| | Group 1.2 Steels with a specified minimum yield strength $275 \text{ N/mm}^2 < R_{eH} \leq 360 \text{ N/mm}^2$ | |
| | Group 1.4 Steels with improved atmospheric corrosion resistance | |
| | Group 8.1 Austenitic stainless steels with $\text{Cr} \leq 19\%$ | Butt Weld: 1mm – 4mm Fillet Weld: 1,4mm – 4mm |
| | Group 22 – Non heat treatable alloys | Butt & Fillet Weld: 1,5mm – 6mm |
| | Group 23.1 - Al-Mg-Si Heat treatable alloys | |
| | Group 22 Non heat treatable alloys | Butt Weld 1mm – 4mm |

Responsible Welding Coordinator:

Phil Reynolds MSc, BSc, MWeldI, European / International Welding Engineer, Level A

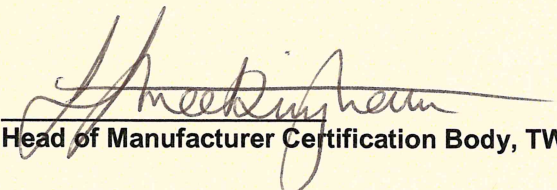
Deputy responsible Welding Coordinator:

John Crompton BEng (Hons) Integrated Engineering, Level C

Certificate Number: CWRVC/016/GB

Valid Until: 20 March 2027
(subject to satisfactory periodic surveillance)

Issued On: 21 March 2024


Head of Manufacturer Certification Body, TWI Certification Ltd

Issued by: TWI Certification Ltd, Granta Park, Great Abington, Cambridge, CB21 6AL, UK