



PRVÁ ZVÁRAČSKÁ, a. s.
FIRST WELDING, Inc.



CERTIFICATE

Welding of railway vehicles and components
according to the standard STN EN 15085-2:2021

PZ 0002 15085 002 P0002 SK

PRVÁ ZVÁRAČSKÁ, a. s. hereby confirms that the company

SAG Slovakia s.r.o.
Chocholná – Velčice 999
913 04 Chocholná – Velčice, Slovakia
ID: 36323985

fulfills requirements
according to

STN EN 15085-2
classification level CL1 in the type of activity
P(production)

in the range indicated in the annex.

Validity: 12.12.2022 until 23.08.2025
Certified since: 22.07.2010



In Bratislava on 12.12.2022
Place and date of issue

Lead auditor: Ing. Andrea Ľubiščáková, PhD.

Ing. Vladimír Simonides, IWE
Head of certification body





ANNEX TO THE CERTIFICATE

PZ 0002 15085 002 P0002 SK

Scope of certificate:

WPQR number (standard)	Welding process (EN ISO 4063)	Material groups (CEN ISO/TR 15608)	Range of qualification (mm)
SK04/89486/2020 (EN ISO 15614-2)	131	22.1, 22.2, 22.3, 22.4 and their combinations	T/FW: t: 3 - 8 a: 2,25 - 4,5 D: ≥ 500
WPQR-CI-CZO-17-ALT 38 (EN ISO 15614-2)	131	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations	P/FW: t ₁ : ≥ 20 a: 2,25 - 4,5 D: >500 t ₂ : 3 - 10 D: >150 rot.:PA,PC
WPQR-CZO-11-ALT 02 (EN ISO 15614-2)	131	22.1, 22.2, 22.3, 22.4 and their combinations	P/FW: t ₁ : 3 - 30 a: 3 - 6 D: >500 t ₂ : 1,5 - 6 D: >150 rot.:PA,PC
WPQR-CZO-11-ALT 06 (EN ISO 15614-2)	131	22.1, 22.2, 22.3, 22.4 and their combinations	P/FW: t ₁ : ≥ 20 a: ≥ 7,5 D: >500 t ₂ : ≥ 24 D: >150 rot.:PA,PC
WPQR-CZO-11-ALT 07 (EN ISO 15614-2)	131	22.1, 22.2, 22.3, 22.4 and their combinations	P/BW: t: 1,5 - 6 D: >500 P/FW: t: 1,5 - 6 a: 2,25 - 4,5 D: >150 rot.:PA,PC D: >500 D: >150 rot.:PA,PC
WPQR-CZO-11-ALT 08 (EN ISO 15614-2)	131	22.1, 22.2, 22.3, 22.4 and their combinations	P/FW: t ₁ : 3 - 12 a: ≥ 7,5 D: >500 t ₂ : 3 - 30 D: >150 rot.:PA,PC
WPQR-CZO-11-ALT 09 (EN ISO 15614-1)	131	8 ^c -1 ^a	P/FW: t ₁ : 3 - 4,8 a: 3 - 6 D: >500 t ₂ : 12,5 - 30 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 10 (EN ISO 15614-1)	131	8 ^c -1 ^a	P/FW: t: 1,4 - 4 a: 2,25 - 4,5 D: >500 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 13 (EN ISO 15614-1)	131	8 ^c -1 ^a	P/FW: t ₁ : 1,4 - 4 a: 2,25 - 4,5 D: >500 t ₂ : 5 - 12 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 14 (EN ISO 15614-1)	131	8 ^c -1 ^a	P/FW: t ₁ : 1,4 - 4 a: 2,25 - 4,5 D: >500 t ₂ : 7,5 - 18 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 16 (EN ISO 15614-1)	131	8 ^c -1 ^a	P/BW: t: 1,4 - 2,6 D: >500 P/FW: t: 1,4 - 4 a: 1,5 - 3 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC

a Test piece material qualify the equal or lower specified minimum yield strength steels

b Test piece material qualify steels in the same sub-group and any lower sub-group within the same group

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x provided Al-Mg filler material is used

In Bratislava on 12.12.2022

Place and date of issue



Ing. Vladimír Simonides, IWE
Head of certification body

General provisions:

The General Terms and Conditions of the PRVÁ ZVÁRAČSKÁ, a. s. apply in the currently valid version.



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WPQR-CZO-11-ALT 18 (EN ISO 15614-1)	131	8 ^c -1 ^a	P/BW: t: 3 - 7,8 P/FW: t: 3 - 7,2 a: 4,5 - 9	D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC	
WPQR-PZ-300-10-448 (EN ISO 15614-2)	131	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	T/BW: t: 1 - 4	D: 12,5-50	
WPQR-PZ-300-10-472 (EN ISO 15614-2)	131	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	P/FW: t: 1,5 - 6 a: 2,25 - 4,5	D: >500 D: >150 rot.:PA,PC	
Z-EU-SK-BRA-0201/50/18-01 (EN ISO 15614-2)	131	22.1, 22.2, 22.3, 22.4 and their combinations	T/FW: t: 3 - 7 a: 2,63 - 5,25	D: ≥ 103,75	
WPQR-CI-CZO-17-ALT 36 (EN ISO 15614-1)	135	2 ^a -2, 2 ^a -1, 1-1	P/T/BW: t: 2,1 - 3,9	D: ≥ 500	
WPQR-CI-CZO-17-ALT 37 (EN ISO 15614-1)	135	2 ^a -2, 2 ^a -1, 1-1	P/T/FW: t: 2,1 - 6 a: 2,25 - 4,5	D: ≥ 500	
WPQR-CZO-11-ALT 01 (EN ISO 15614-1)	135	2 ^a -2, 2 ^a -1, 1-1	P/FW: t ₁ : 2,1 - 6 t ₂ : 3 - 7,2 a: no rest.	D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-11-ALT 05 (EN ISO 15614-1)	135	1 ^a -1	P/BW: t: 3 - 12 P/FW: t: 3 - 7,2 a: no rest.	D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-11-ALT 12 (EN ISO 15614-1)	135	8 ^c -1 ^a	P/FW: t ₁ : 1,4 - 4 t ₂ : 5 - 12 a: 3 - 6	D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-11-ALT 15 (EN ISO 15614-1)	135	1 ^a -1	P/FW: t: 1,4 - 4 a: 3 - 6	D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-11-ALT 17 (EN ISO 15614-1)	135	1 ^a -1	P/BW: t: 1,4 - 2,6 P/FW: t: 1,4 - 4 a: 1,5 - 3	D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC	

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WPQR-CZO-11-ALT 19 (EN ISO 15614-1)	135	1 ^a -1	P/FW: t ₁ : 1,4 - 4 t ₂ : 7,5 - 18 a: 3 - 6 D: >500 D: >150 PA, rot.:PC
WPQR-CZO-14-ALT 34 (EN ISO 15614-1)	135	1 ^a -1	T/BW: t: 3 - 7,8 D: 12,5-50
WPQR-CZO-15-ALT 35 (EN ISO 15614-1)	135	1 ^a -1	T/BW: t: 5 - 13 D: ≥ 33,5
0036-NLSK-1271/50/2016-01 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1-23.2	T/BW: t: 1,5 - 6 D: ≥ 500
0036-NLSK-1271/50/2016-02 (EN ISO 15614-2)	141	22.1, 22.2, 22.3, 22.4 and their combinations	T/FW: t: 1,5 - 6 a: 1,5 - 3 D: ≥ 500
WPQR-CZO-11-ALT 03 (EN ISO 15614-2)	141	22.1, 22.2, 22.3, 22.4 and their combinations	P/FW: t ₁ : 3 - 30 t ₂ : 1,5 - 6 a: 3 - 6 D: >500 D: >150 rot.:PA,PC
WPQR-CZO-11-ALT 04 (EN ISO 15614-1)	141	1 ^a -1	P/BW: t: 3 - 12 P/FW: t: 3 - 7,2 a: no rest. D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 11 (EN ISO 15614-1)	141	8 ^c -1 ^a	P/BW: t: 1,4 - 2,6 P/FW: t: 1,4 - 4 a: 1,5 - 3 D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 20 (EN ISO 15614-1)	141	8 ^c -1 ^a	P/BW: t: 3 - 7,8 P/FW: t: 3 - 7,2 a: 4,5 - 9 D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 21 (EN ISO 15614-1)	141	1 ^a -1	P/BW: t: 1,4 - 2,6 P/FW: t: 1,4 - 4 a: 1,5 - 3 D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC
WPQR-CZO-11-ALT 22 (EN ISO 15614-1)	141	8 ^c -1 ^a	P/FW: t: 0,7 - 2 a: 1,5 - 3 D: >500 D: >150 PA, rot.:PC

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WPQR-CZO-11-ALT 23 (EN ISO 15614-1)	141	8 ^c -1 ^a	P/BW: t: 0,7 - 1,3 P/FW: t: 0,7 - 2 a: 0,75 - 1,5	D: >500 D: >150 PA, rot.:PC D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-11-ALT 24 (EN ISO 15614-1)	141	8 ^c -1 ^a	P/FW: t ₁ : 3 - 4,8 t ₂ : 0,7 - 2 a: 1,5 - 3	D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-11-ALT 25 (EN ISO 15614-1)	141	8 ^c -1 ^a	P/FW: t ₁ : 0,7 - 2 t ₂ : 5 - 12 a: 2,25 - 4,5	D: >500 D: >150 PA, rot.:PC	
WPQR-CZO-12-ALT 26 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	P/FW: t: 3 - 40 a: 2,25 - 4,5	D: >500 D: >150 rot.:PA,PC	
WPQR-CZO-12-ALT 27 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	P/BW: t: 3 - 40	D: >500 D: >150 rot.:PA,PC	
WPQR-CZO-12-ALT 28 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	P/FW: t: 1 - 4 a: 0,75 - 1,5	D: >500 D: >150 rot.:PA,PC	
WPQR-CZO-13-ALT 32 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	T/BW: t: 3 - 8	D: ≥ 70	
WPQR-CZO-14-ALT 33 (EN ISO 15614-1)	141	8 ^c -8	T/BW: t: 0,7 - 1,3	D: 4-16	
WPQR-PZ-300/21/2190 (EN ISO 15614-1)	141	8 ^b -8	T/BW: t: 1 - 4 T/FW: t: 1,4 - 4 a: 1,5 - 3	D: ≥ 25 D: ≥ 25	
WPQR-PZ-300-10-449 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations	T/BW: t: 1 - 4	D: 12,5-50	
WPQR-PZ-300-10-471 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1	P/FW: t: 1,5 - 6 a: 2,25 - 4,5	D: >500 D: >150 rot.:PA,PC	

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Z-EU-SK-BRA-0201/50/18-02 (EN ISO 15614-2)	141	22.1, 22.2 ^x , 22.3 ^x , 22.4 ^x and their combinations, 23.1-23.2	T/FW: t: 3 - 7 a: 2,63 - 5,25 D: ≥ 25
WPQR-CI-CZO-20-ALT 42 (EN ISO 15614-12)	21	1.2	P/Spot weld: t: 1,5
WPQR-CI-CZO-20-ALT 43 (EN ISO 15614-12)	21	1.1	P/Spot weld: t: 2
WPQR-CZO-12-ALT 29 (EN ISO 15614-13)	24	23.1/23.1 (22.1, 22.2, 22.3, 22.4 and their combinations)	P/BW: t: 3
WPQR-CZO-12-ALT 30 (EN ISO 15614-13)	24	23.1/23.1 (22.1, 22.2, 22.3, 22.4 and their combinations)	P/BW: t: 3
WPQR-CZO-12-ALT 31 (EN ISO 15614-13)	24	23.1/23.1 (22.1, 22.2, 22.3, 22.4 and their combinations)	P/BW: t: 3 - 5

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Area of application:

The manufacturer is proven and qualified for the production of sheet metal and structural profiles from aluminum and steel alloys: applications, parts of frames, thermal insulation, covers, casing, non-pressurized vessels for fuels and oils.

Welding personal:

Responsible welding coordinator	1st deputy of the responsible welding coordinator	Others deputies
Ing. Martin Drexler (IWE)	Ing. Róbert Marušinec (IWE)	Vladimír Karas (IWS) Josef Žilka (EWS)

Notes: The condition to carry out the welder test and operator test according to ISO 9606-1 and ISO 14732 for Mr. Martin Drexler exist.

Register No.: PZVAR/15085/CL1/002/10/4A1

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