

CERTIFICAT



CERTIFICADO



СЕРТИФИКАТ



認證證書



CERTIFICATE



ZERTIFIKAT



Italia

CERTIFICATO CERTIFICATE

**Saldatura dei veicoli ferroviari e dei relativi componenti in accordo a
EN ISO 15085-2:2020 e alle LINEE GUIDA ANSFISA**
*Welding of railway vehicles and components according to UNI EN 15085-2:2020 and
ANSFISA Guidelines*

Certificato No.: 523-424-2015 Rev.5

Certificate No.: 523-424-2015 Rev.5

Si certifica che

This is to certify that

CO.MEC.EL Costruzioni Meccaniche Elettroniche S.r.l
Sede legale: Piazza Roma 18, 04011 Aprilia (LT)
Sede operativa: Via Nettunense Km 23, 04011 Aprilia (LT)

opera nelle attività di saldatura, con livello di classificazione **CL1**, in conformità alla norma
*works in welding with classification level **CL1** in accordance with standard*

EN ISO 15085-2:2020
LINEE GUIDA ANSFISA (protocollo 0000100.03.01.2022)

Per il tipo di attività: ☐ Progettazione ☒ Produzione ☐ Manutenzione ☐ Acquisto e
Fornitura

Types of activity : ☐ Design ☒ Production ☐ Maintenance ☐ Purchase and Supply

per il seguente campo di applicazione:

for the following scope of approval:

**Fabbricazione ed assemblaggio di componenti strutturali saldati per
il settore ferroviario**

Construction and assembly of structural welded components for rail sector

Campo di validità / Validity range: Vedi Allegato / See Annex

Data emissione / Issue date: 17/01/2024

Data 1° emissione / First issue date: 12/01/2015

Data scadenza / Expiry date: 13/01/2027

Auditor / Auditor: Davide Tonini

Per l'Organismo di Certificazione
For the Certification Body

TÜV Italia S.r.l.



PRD N° 081B

Membro degli Accordi di Mutuo Riconoscimento
EA, IAF e ILAC
Signatory of EA, IAF and ILAC Mutual
Recognition Agreements



Alberto Carelli
**Industry Service – Real Estate &
Infrastructure
Managing Director**

**La validità del presente certificato è subordinata a sorveglianza periodica a 12 mesi e al riesame completo
del sistema di gestione aziendale con periodicità Triennale - Lo stato di validità del presente certificato deve
essere accertata sulla banca dati Accredia**

*The validity of the present certificate depends on the annual surveillance every 12 months and on the complete
review of company's management system after three-years -The Validity of the present certificate must be verified on
the Accredia database*



Allegato al Certificato n° 523-424-2015 Rev.5
Annex to Certificate n° 523-424-2015 Rev.5

Campo di validità: <i>Scope of approval:</i> per il sito di Via Nettunense Km 23, 04011 Aprilia (LT)				
Processi in accordo alla EN ISO 4063 / Processes according to EN ISO 4063	Materiali in accordo alla CEN ISO/TR 15608 / Materials according to CEN ISO/TR 15608	Spessori (mm) / Thicknesses (mm)	Diametri (mm) / Diameters (mm)	Note / Remarks
141	23.1	0.75 ÷ 10.0	>150 in PC or in PA-PF Rotated position >500 all position	BW-TW-FW Branch connection sl-ss-nb-mb;bs
141	23.2	3.0 ÷ 20.0	>150 in PC or in PA-PF Rotated position >500 all position	FW: ml-ss-mb
141	8.1	1.4 ÷ 16.0	≥10.5	FW: sl-ss-mb
141	8.1	3.0 ÷ 22.17	≥30.15	FW: ml-ss-mb
141	8.1	1.5 ÷ 3.0	>150 in PC or in PA-PF Rotated position >500 all position	BW: sl-ss-mb
141	8.1	2.1 ÷ 10.16	≥25	BW: ml-ss-gb;mb
141	1.2	3.0 ÷ 24.0	>150 in PC or in PA-PF Rotated position >500 all position	BW: ml-ss-mb;nb
135	1.2	3.0 ÷ 12.0	≥25	FW: sl-ss-mb
135	1.2	4 ≤T1≤ 16 10 ≤T2≤ 40	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ss-mb with and without PWHT
135	1.2	6.0 ÷ 24.0	>150 in PC or in PA-PF Rotated position >500 all position	FW: ml-ss-mb with and without PWHT
135	1.2	3.0 ÷ 24.0	>150 in PC or in PA-PF Rotated position >500 all position	BW-TW: ml-ss-mb with and without PWHT
135	1.2	3.0 ÷ 7.8	>150 in PC or in PA-PF Rotated position >500 all position	BW: sl-ss-mb with and without PWHT
135	1.2	3.0 ÷ 12.0	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ss-mb with and without PWHT
135	1.2	10.0 ÷ 40.0	>150 in PC or in PA-PF Rotated position >500 all position	FULLY MECHANIZED BW: sl-ss-nb;mb
135	1.2	10.0 ÷ 40.0	>150 in PC or in PA-PF Rotated position >500 all position	FULLY MECHANIZED FW: sl-ss-mb



135	1.2	2.1 ÷ 3.9	>150 in PC or in PA-PF Rotated position >500 all position	BW-TW: sl-ds-bs-gg
135	1.2	2.1 ÷ 6	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ds-mb
135	8.1	2.1 ÷ 24.0	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ss-mb;gb
135	8.1	1.96 ≤T1≤ 22.14 3 ≤T2≤ 12	≥25	FW: sl-ss-mb;gb
135	8.1	3.0 ÷ 6.6	≥25	BW: sl-ss-mb;gb
135	1 TO 9	4.8 ÷ 6.6	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ss-mb
135	72.2 X120Mn12	3.0 ÷ 40.0	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ss-mb
135	1.2	3 ≤T1≤ 40 3 ≤T2≤ 10	10 ≤Ø ₁ ≤ 40 Ø ₂ ≥ 10	FW: sl-ds-mb
136	1.2	8 ÷ 32	>150 in PC or in PA-PF Rotated position >500 all position	BW: ml,ss,nb,mb;bs,ng,gg TW: ml,ss,nb,mb;bs,ng,gg FW: P&T
131	23.2	3.0 ÷ 20.0	>150 in PC or in PA-PF Rotated position >500 all position	FW: sl-ss-mb
131	22.3	3.0 ÷ 10.0	>500; >150	BW ss nb sl auto
131	23.2	3.0 ÷ 16.00	>500; >150	Fw SL auto
912	A-A;B-B; A-B	0.5 ÷ 2.0 h≤ 10	≤12	Overlap Joint All flow directions
912	D-D	1.5 ≤T1≤ 8 1.5 ≤T2≤ 16	N.A.	Overlap Joint All flow directions
912	D-D	1.25 ≤T1≤ 5 1.5 ≤T2≤ 8	≤40	Overlap Joint Horizontal Flow Vertical down-flow
912	D-D	1.25 ≤T1≤ 5 1.5 ≤T2≤ 16 L≤2.3	≤40	Overlap Joint All flow directions
916	D-D	1.5 ≤T1≤ 10 1.5 ≤T2≤ 6 L≤ 32	≤40	Overlap Joint All flow directions
916	D-A; D-B	1.5 ≤T1≤ 9 5 ≤T2≤ 21 h≤ 2.5	≤5	Overlap Joint All flow directions
916	D-D	5≤T1≤ 74 1.5 ≤T2≤ 8 L≤ 29	≤29	Overlap Joint Horizontal Flow Vertical down-flow
916	D- D	1.5 ≤T1≤ 9 5 ≤T2≤ 21 L≤16	≤16	Overlap Joint All flow directions



Italia

Allegato al Certificato n° 523-424-2015 Rev.5
Annex to Certificate n° 523-424-2015 Rev.5

Coordinatori di Saldatura / Welding Coordinators
RWC: Ennio Cardilli (Livello A)
DWC: Pasquale Cristini (Livello A);

Disposizioni generali rif. norma EN ISO 15085-2:2020 e Linee Guida ANSFISA
(protocollo 0000100.03.01.2022)

General provisions ref. EN ISO 15085-2:2020 and ANSFISA Guidelines

Revoca del certificato

Revocation of certificate

L'Ente che ha rilasciato al fabbricante il certificato, può revocarlo qualora:

- esistano dubbi giustificabili per l'esecuzione dei processi di saldatura, per il rispetto delle norme;
- esistano dubbi giustificabili circa l'autorità di vigilanza sui processi di saldatura secondo le norme di cui al presente certificato
- le qualifiche dei saldatori non siano più valide
- i saldatori non fossero qualificati secondo i processi nel contesto delle norme di cui al presente certificato
- i requisiti di tali norme non siano rispettati
- non sia consentita la possibilità di un monitoraggio annuale presso il fabbricante

The body that issued the certificate to the manufacturer, may withdraw it if:

- *there are justifiable doubts as to the execution of welding processes, for compliance with the rules;*
- *there are justifiable doubts about the supervisor on welding processes in accordance with standards referred to in this certificate*
- *welders' qualifications are no longer valid*
- *welders were not qualified according to the processes in the context of the standards referred to in this certificate*
- *the requirements of these rules are not respected*
- *annual monitoring was not allowed by the manufacturer*

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