



**SLOVENSKA  
AKREDITACIJA**  
SIST EN ISO/IEC 17065  
CP-010



Q TECHNA, Institut za zagotavljanje in kontrolo kakovosti d.o.o.  
Cvetkova ulica 27, 1000 Ljubljana

## SPRIČEVALO O ODOBRTVI VARJENJA ŽELEZNIŠKIH VOZIL IN ELEMENTOV PO SIST EN 15085-2:2020

CERTIFICATE OF APPROVAL FOR WELDING OF RAILWAY VEHICLES AND COMPONENTS  
ACCORDING TO SIST EN 15085-2:2020

**Podjetje / The company:**

**SŽ-Vleka in tehnika d.o.o., Center Ljubljana**

**in njegov varilni obrat na lokaciji:**

**Zaloška 217, 1000 Ljubljana**

(naslov obrata ki izvaja varilska dela)

and its welding manufacturer in:

(Location site - postal address of welding manufacturer)

**je certificiran za stopnjo CL 1 na področju dejavnosti P, V po SIST EN 15085-2:2020**

is certified for classification level CL 1 in the field of activity P, M according to SIST EN 15085-2:2020

**Področje  
uporabe:**

**Proizvodnja in vzdrževanje železniških vozil in delov skladno z nacionalnimi  
standardi brez nabave zvarjencev in brez konstruiranja**

Field of application:

Production and maintenance of railway vehicles and components according to the national  
rules without procurement of welded components and without design

**Obseg certifikacije / Scope of certification:**

| Varilni proces po<br>Welding process<br>according to<br>EN ISO 4063 | Material skupine po<br>Material group according to<br>CEN ISO / TR 15608 | Dimenzija / Dimension<br>[mm] | Opombe / Remarks |
|---|--|-------------------------------|------------------|
| 111 (E), 135 (MAG)  | 1.2  | 3-20 mm BW; 5-20 mm FW        | /                |
| 141 (TIG)   | 8.1  | 2-4 mm FW                     | a=1,5-3,0 mm     |
| 141 (TIG)   | 8.1  | 2,0-2,6 mm - BW               | /                |
| 131 (MIG)   | 22   | 3-6 mm BW; 3-20 mm FW         | /                |
| 135 (MAG)   | 1.2  | 6,4-12 mm osnovni material    | 1,0-2,0 mm navar |
| 135 (MAG)   | 11   | ≥25 mm osnovni material       | 1,0-2,0 mm navar |
| 135 (MAG)   | 1.2  | ≥5 mm FW                      | /                |
| 111 (E)   | 1.2  | 8-15 mm osnovni material      | 1,0-2,0 mm navar |
| 111 (E)   | 1.2  | 5-20 mm FW                    | a= 3,75-7,5 mm   |
| 141 (TIG)   | 23.1   | 3-8 mm - BW, FW               | a= 3,7 - 7,5 mm  |

**Odgovorni varilni koordinator / Responsible welding coordinator:**

**g. / Mr.: Josip GRUM, EWE (zunanji)**

**rojen / born: 14.04.1958**

**Namestnik varilnega koordinatorja / Deputy to responsible welding coordinator:**

**g. / Mr.: Janez BABŠEK, IWT**

**rojen / born: 07.02.1996**

**Nadaljnji varilni koordinatorji / Additional welding coordinators:**

**Opombe/Razširitve / Remarks/Extensions:**

glej hrbtno stran spričevala / see certificate back  
glej hrbtno stran spričevala / see certificate back

**Spričevalo / Certificate No.:**

**Q Techna /15085/CL1/005/3/14**

**Presojevalec / Auditor:**

**Tamara Tomše Mavser**

**Začetek veljavnosti – prvič izdan / Begin of validity – first issue:**

**09.10.2014**

**Veljavno do / Valid until:**

**18.09.2026**

**Naslednja presoja do: / Next surveillance until:**

**18.09.2024**

**Izdano v Ljubljani / Issued in Ljubljana on:**

**15.11.2023**



**mag. Amrož Božman, univ. dipl. ing., IWE**

Predstavnik certifikacijskega organa / Certification body representative

**Spričevalo št. / Certificate No.:**

**Q Techna /15085/CL1/005/3/14**

Pristojni varnostni organ ali certifikacijski organ lahko prekličeta to spričevalo, če:  
*Safety regulatory authority or certification body may revoke this certificate:*

- obstaja sum, da se zahteve izpolnjevanja omenjene norme ob izvajanju varilskih del ne upoštevajo / *in case of suspicion that requirements for meeting the above norms during welding are not considered,*
- obstaja sum, da se zahteve navedenih standardov o varilni koordinaciji in nadzoru ob izvajanju varilskih del ne upoštevajo / *in case of suspicion that requirements covering standards for welding coordination and inspection are ignored,*
- je podjetje ostalo brez varilnega koordinatorja / *if the company no longer has a welding coordinator,*
- je podjetje ostalo brez veljavnih spričeval varilcev in operaterjev po zahtevah omenjenih standardov / *if the company no longer has valid certificates of welders and operators in compliance with governing standards,*
- je podjetje ostalo brez atestiranih varilcev in operaterjev po zahtevah omenjenih norm / *if the company no longer has certified welders and operators in accordance with related norms,*
- če preostale zahteve navedenih norm niso izpolnjene / *should other requirements for the stated norms not be met,*
- če je le to poteklo / *the certificate has expired.*

Certifikacijski organ mora spričevalo odpoklicati v pisni obliki in o tem obvestiti pristojni varnostni organ.  
*A Certification body is to revoke the certificate in a written form, as well as notify a safety regulatory authority.*

Najmanj 2 (dva) meseca pred iztekom veljave spričevala mora proizvajalec poslati vlogo za podaljšanje certifikacijskemu organu.

*The manufacturer is to file the application for certificate extension to a certification body, at least two months prior to certificate expiry.*

**Opombe / Remarks:** ./.

**Dodatni varilni koordinatorji / Additional welding coordinators:**

**g. / Mr.:** /

**rojen / born:**

**Dostaviti / Distribute:**

1. Prosilec / Applicant – 1x (original)
2. Arhiv podjetja / Records – 1x