



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

SPRIČEVALO O ODOBREDITVI VARJENJA ŽELEZNIŠKIH VOZIL IN ELEMENTOV PO SIST EN 15085-2:2020+A1:2024

CERTIFICATE OF APPROVAL FOR WELDING OF RAILWAY VEHICLES AND COMPONENTS
ACCORDING TO SIST EN 15085-2:2020+A1:2024

Podjetje / The company:

SŽ-Vleka in tehnika d.o.o.
Sekcija za vzdrževanje Ptuj
Osojnikova cesta 6, 2250 Ptuj

in njegov varilni obrat na lokaciji:

(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+A1:2024

is certified for classification level CL 1 in the field of activity P, M according to SIST EN 15085-2:2020+A1:2024

Področje
uporabe:

Novogradnja železniških vozil in elementov klase CL 1 brez projektiranja
Vzdrževanje železniških vozil in njihovih elementov

Field of application:

Manufacturing of railway vehicles and components quality level CL 1 without design

Maintenance of railway vehicles and components

Obseg certifikacije / Scope of certification:

Varilni proces po Welding process according to EN ISO 4063	Material skupine po Material group according to CEN ISO / TR 15608	Dimenzija / Dimension [mm]	Opombe / Remarks
111 (E)	1.2	5-20 mm FW	a= 3,75-7,5 mm
111 (E), 135 (MAG)	1.2	3-20 mm BW; 5-20 mm FW	/
111 (E)	1.2	8-15 mm osnovni material	t nav=1-2 mm
111 (E), 135 (MAG)	1.1/X120Mn12	3-20 mm FW	a= 4,5-9,0 mm (MAG)
135 (MAG)	1.2	6,4-12 mm osnovni material	1,0-2,0 mm navar
135 (MAG)	W.Nr. 1.3401/72.2	t ₁ =3-8 mm, t ₂ =10-40 mm	/
131 (MIG)	1.2/X120Mn12	t ₁ =3-8 mm, t ₂ =10-40 mm	a= 2,25-4,5 mm
131 (MIG)	23.1	3-10 BW	/
131 (MIG)	23.1	3-12 FW	a= 6,0-12,0 mm
141 (TIG)	8.1	2,0-2,6 BW; 2-4 FW	/

Odgovorni varilni koordinator / Responsible welding coordinator:

g. / Mr.: Robert PETROVIČ, IWT

rojen / born: na originalu/on original

Prvi namestnik odgovornega varilnega koordinatorja / 1st deputy to responsible welding coordinator:

g. / Mr.: Robert STRNAD, IWE (zunanji/external)

rojen / born: na originalu/on original

Nadaljnji namestniki / Others deputies:

glej hrbtno stran spričevala / see certificate back

Opombe/Razširitve / Remarks/Extensions:

glej hrbtno stran spričevala / see certificate back

Spričevalo / Certificate No.:

Q Techna /15085/CL1/008/3/14

Presojevalec / Auditor:

Andrej Weiss

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

11.10.2014

Veljavno do / Valid until:

12.06.2026

Naslednja presoja do: / Next surveillance until:

12.06.2026

Izdano v Ljubljani / Issued in Ljubljana on:

09.10.2025



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zagotavljanje in kontrolo
kakovosti d.o.o.
Cvetkova ulica 27, 1000 Ljubljana

mag. Ambrož Rožman, univ. dipl. ing., IWE
Predstavnik certifikacijskega organa / Certification body representative

Spričevalo št. / Certificate No.:

Q Techna /15085/CL1/008/3/14

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: ./.

Nadaljnji namestniki / Others deputies:
g. / Mr.: /

rojen / born: /

Dostaviti / Distribute:

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