



PRVA ZVARAČSKÁ, a. s.
FIRST WELDING Inc.

EN 15085 CERTIFICATION GUIDE

Requirements, Certification Levels, Process & Readiness Checklist

*A Practical Guide for Railway Vehicle &
Component Manufacturers*



First Welding Certification Pvt Ltd (PRVÁ ZVÁRAČSKÁ, a.s.)
EN 15085 Manufacturer Certification
pzvar.in

EN 15085 Certification: A Practical Guide

Introduction:

EN 15085 certification provides a structured framework for controlling welding activities in railway vehicle and component manufacturing.

For manufacturers, certification is not simply about having welding documents. It involves demonstrating that welding activities are properly planned, controlled, performed by competent personnel, inspected and supported by appropriate records.

This guide provides a practical overview of the main areas manufacturers should consider when preparing for EN 15085 certification.

What this guide covers

Scope & Classification

Understand what activities and products are covered.

Welding Control

Review welding coordination, personnel and procedures.

Traceability

Check materials, welding activities, inspection and records.

Certification

Prepare for assessment and identify potential gaps.

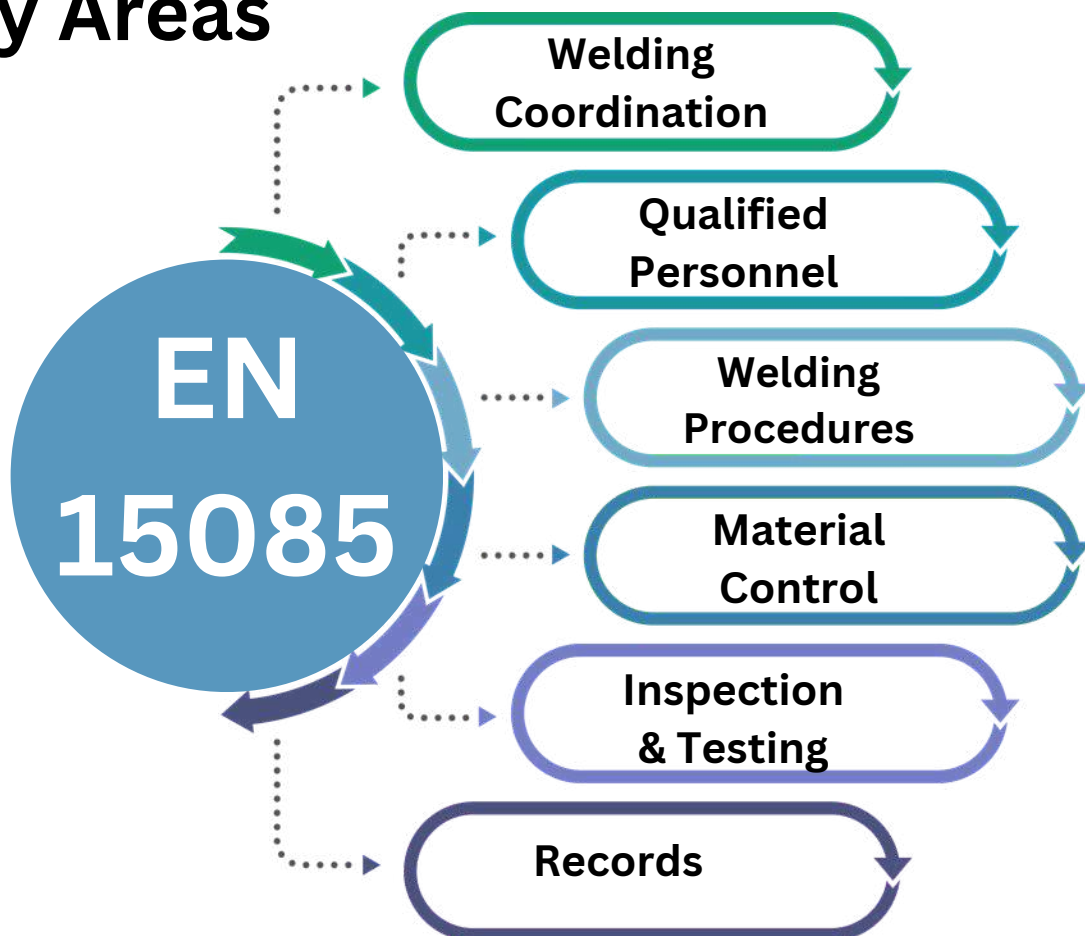


WHAT IS EN 15085?

EN 15085 Certification

EN 15085 is the European standard series addressing welding of railway vehicles and railway vehicle components. For manufacturers, the standard provides requirements for controlling welding-related activities throughout the manufacturing process. This includes areas such as welding coordination, qualified personnel, welding procedures, materials, production, inspection and documentation. The objective is to establish controlled and traceable welding activities appropriate to the railway application.

Key Areas



[Learn more about EN 15085 Certification](#)

The EN 15085 online register is maintained as a central resource for certification of welding companies in railway vehicle construction.

Who Needs EN 15085 Certification?

EN 15085 certification is relevant to organisations involved in welding railway vehicles and railway vehicle components where the applicable certification requirements call for conformity with the EN 15085 system.

Common Organisations



Railway Vehicle Manufacturers

Manufacturers of welded railway vehicles and rolling stock.



Railway Component Manufacturers

Manufacturers of welded components used in railway vehicles.



Welding Manufacturers

Manufacturers of welded components used in railway vehicles.

Railway Suppliers

Suppliers producing welded assemblies or components for railway customers.



Repair & Maintenance

Organisations performing applicable railway maintenance activities involving welding.



Design & Supply Activities

Organisations whose applicable scope includes relevant design activities.



The need for certification depends on the organisation's actual activities, products, responsibilities, applicable requirements and customer/project requirements.

EN 15085 Certification Levels

The classification level should be determined according to the applicable railway product/component and its safety relevance. EN 15085 certification uses three main classification levels for welded railway vehicles and components: CL1, CL2 and CL3.

Levels	Significance	Applications
CL1	High safety relevance	Welded railway vehicles and components with high safety significance
CL2	Medium safety relevance	Welded attachments/components with medium safety significance
CL3	Low safety relevance	Simple welded attachments/components with lower safety significance

The applicable classification should not be selected simply because a company prefers a particular level. It should be determined based on the applicable product, welding activities, safety relevance and requirements.

What Are the Main EN 15085 Certification Requirements?

Before requesting certification, manufacturers should review the areas that affect their welding system and certification scope.

Area	What to Check
Scope	Products, welding activities and production locations
Classification	Applicable certification level
Welding Coordination	Competence, responsibility and authority
Welding Personnel	Applicable welder/operator qualifications
WPS / WPQR	Welding procedures covering actual production
Materials	Identification and traceability
Production	Controlled welding conditions and processes
Inspection / NDT	Planned inspection and applicable testing
Records	Traceable evidence of production and welding activities

Having documents is not enough. The manufacturer should be able to demonstrate that the required controls are implemented in actual production.

[Detailed guide: EN 15085 Certification Requirements](#)

Welding Coordination & Personnel

EN 15085 certification places importance on the control and coordination of welding activities.

The manufacturer should establish appropriate responsibilities for welding coordination and ensure that personnel performing welding-related activities have the required competence and qualifications for their assigned work.

Welding Coordinator

Responsible for coordinating applicable welding activities and ensuring that required controls are established.

Welders

Personnel performing welding should hold applicable qualifications covering the work they perform.

Welding Operators

For mechanised or automatic welding activities, applicable operator qualifications should be considered.

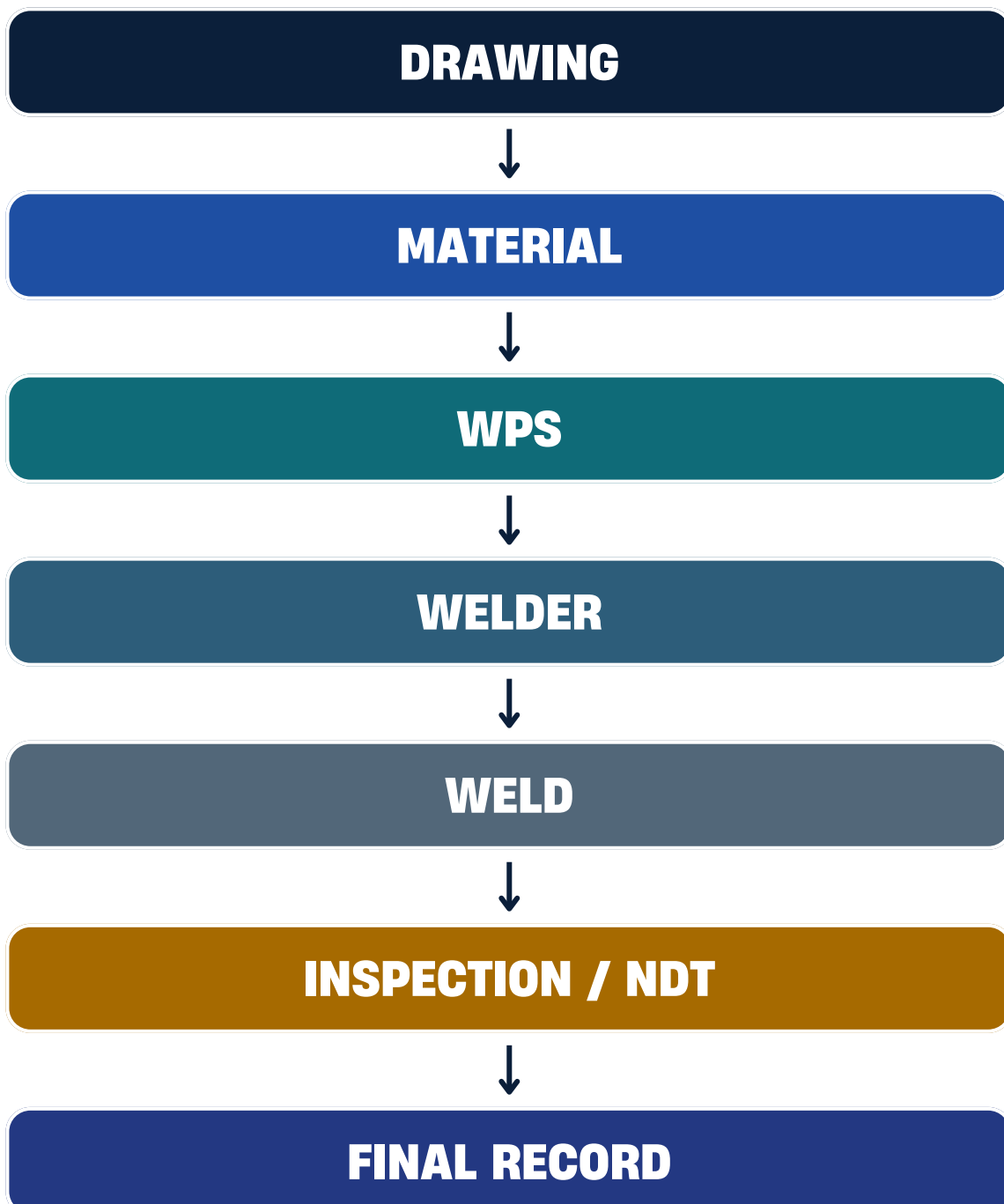
Responsibilities

The organisation should clearly define who is responsible for welding planning, qualification, production control, inspection and records.

WPS, WPQR, Materials & Traceability

Controlled welding requires more than having a welding procedure stored in a file. The applicable welding procedure should support the actual production activity and relevant qualification requirements.

Traceability flow



WPS

Welding Procedure Specification

Defines the applicable welding parameters and conditions for production.

WPQR

Welding Procedure Qualification Record

Provides evidence supporting qualification of the welding procedure where required.

Materials

Material identification and traceability should be maintained through the relevant production stages.

Records

Production and inspection records should provide evidence that the planned controls were followed.

The ECWRV guideline specifically addresses welding planning documents and requires welding procedures to be qualified/documentated according to the applicable requirements.

How Does EN 15085 Certification Work?

The certification process begins by defining what the manufacturer actually produces and which welding activities are included within the intended certification scope.

01 – Define Scope

Products, welding activities and locations.



02 – Determine Classification

Identify the applicable certification level.



03 – Review Welding System

Welding coordination, personnel, procedures and production controls.



04 – Prepare Documentation

WPS/WPQR, qualifications, material records, inspection and other applicable records.



05 – Certification Assessment

The certification body evaluates conformity against the applicable requirements.



06 – Certification Decision

Where requirements are fulfilled, certification is issued according to the applicable certification scheme.

Certification is not only a document review. The manufacturer should be able to demonstrate that applicable controls are implemented in practice.

EN 15085 Certification Readiness Checklist

Use this checklist as a preliminary internal review before starting the certification process.

Scope

- Products and components are clearly identified
- Welding activities are defined
- Production locations are identified
- Certification scope is documented

Classification

- Applicable classification has been evaluated
- Safety relevance has been considered
- Certification activities are clearly defined

Welding Personnel

- Welding coordination responsibilities are established
- Welders have applicable qualifications
- Welding operators have applicable qualifications where required

Welding Procedures

- Applicable WPS are available
- Required WPQR are available
- WPS cover actual production activities

Production

- Welding equipment is suitable and controlled
- Welding parameters are controlled
- Production records are maintained

Inspection & Traceability

- Inspection requirements are defined
- Applicable NDT arrangements are established
- Material traceability is maintained
- Welding records are traceable

EN 15085 Documentation: What Should You Prepare?

The exact documentation required depends on the certification scope, applicable requirements and the manufacturer's activities. The following list can be used as a preparation framework.

Company & Scope

- Organisation information
- Organisation chart
- Certification scope
- Production locations
- Description of welding activities

Personnel

- Welding coordinator information
- Welder qualifications
- Welding operator qualifications where applicable
- Competence records

Welding

- WPS
- WPQR
- Welding planning documentation
- Welding equipment information
- Applicable procedure controls

Materials

- Material certificates
- Identification records
- Traceability records

Inspection

- Inspection plans
- NDT arrangements
- Inspection/test records
- Nonconformity records where applicable

Production

- Welding records
- Production records
- Equipment/control records
- Relevant quality documentation

Prepare evidence that reflects actual production — not only documents created for the assessment.

Common EN 15085 Certification Preparation Issues

Many certification difficulties can be reduced by identifying gaps before the formal assessment.

01 — Unclear Scope

Problem: The manufacturer has not clearly defined which products, welding activities or locations are included.

Check: Start with the actual products and production activities.

02 — Qualification Gaps

Problem: Personnel qualifications do not cover the actual welding work.

Check: Compare qualifications against the welding processes, materials, positions and applicable scope.

03 — WPS Does Not Match Production

Problem: A procedure exists, but it does not adequately cover the actual production activity.

Check: Review WPS/WPQR against actual welding work.

04 — Incomplete Traceability

Problem: Materials, welding and inspection records cannot be connected.

Check: Follow the traceability chain from drawing to final record.

05 — Documentation Exists but Is Not Implemented

Problem: Procedures exist on paper but are not consistently followed in production.

Check: Compare documented procedures with actual shop-floor practice.

Certification readiness means demonstrating control in practice — not simply collecting documents.

Frequently Asked Questions - EN 15085 Certification

1. What is EN 15085 certification?

EN 15085 certification demonstrates conformity of applicable welding activities in railway vehicle and component manufacturing with the relevant certification requirements.

2. Who needs EN 15085 certification?

Organisations involved in relevant welding activities for railway vehicles or railway vehicle components may require certification depending on their scope and applicable requirements.

3. What are the EN 15085 certification levels?

The main classification levels for welded railway vehicles and components are CL1, CL2 and CL3. The applicable level depends on the relevant safety significance and certification scope.

4. What should manufacturers prepare?

Manufacturers should review their scope, classification, welding coordination, personnel qualifications, WPS/WPQR, materials, production controls, inspection and records.

5. Is documentation alone enough?

No. The manufacturer should demonstrate that applicable controls are implemented in actual production.

Preparing for EN 15085 Certification?

Selecting an appropriate certification route is an important step when preparing for EN 15085 certification.

Manufacturers should first define their products, welding activities, locations and intended certification scope. They can then prepare the applicable welding system, personnel qualifications, procedures, production controls and records for assessment.

First Welding Certification Pvt Ltd (PRVÁ ZVÁRAČSKÁ, a.s.)

First Welding Certification Pvt Ltd works as a Manufacturer Certification Body for EN 15085 certification.

Scope Review

Understand the applicable certification scope.

Technical Assessment

Evaluate the relevant welding activities and controls.

Certification

Assess conformity with applicable certification requirements.

Certification Support

Help manufacturers understand the certification route and preparation requirements.

Ready to Prepare for EN 15085 Certification?

EN 15085 certification preparation starts with understanding your actual products, welding activities, applicable classification and certification scope.

Before starting the assessment process, review your:

Scope → Classification → Personnel → WPS/WPQR → Materials → Production → Inspection → Records

[Request Certification ->](#)

Website
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This guide is provided for general informational purposes and is not a substitute for the applicable EN 15085 standard, certification scheme, contractual requirements or assessment by the relevant certification body.