



BSI Standards Publication

# Railway applications — Welding of railway vehicles and components

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Part 2: Requirements for welding manufacturer

This is a preview of BS EN 15085-2:2020+A2:2025. [Click here to purchase the full version from the ANSI store.](#)

## National foreword

This British Standard is the UK implementation of EN 15085-2:2020+A2:2025. It supersedes BS EN 15085-2:2020+A1:2023, which is withdrawn.

The start and finish of text introduced or altered by amendment is indicated in the text by tags. Tags indicating changes to CEN text carry the number of the CEN amendment. For example, text altered by CEN amendment A1 is indicated by A1 A1.

The UK participation in its preparation was entrusted to Technical Committee RAE/3/-/11, Railway Applications - Structural requirements and Welding.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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Published by BSI Standards Limited 2025

ISBN 978 0 539 38067 5

ICS 25.160.01; 25.160.10; 45.060.01

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 30 November 2023.

### Amendments/corrigenda issued since publication

Date	Text affected
31 October 2020	Implementation of CEN amendment A1:2023
30 November 2025	Implementation of CEN amendment A2:2025

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**EUROPÄISCHE NORM**

July 2025

ICS 25.160.01; 45.060.01

Supersedes EN 15085-2:2020+A1:2023

English Version

## Railway applications - Welding of railway vehicles and components - Part 2: Requirements for welding manufacturer

Applications ferroviaires - Soudage des véhicules et des composants ferroviaires - Partie 2 : Exigences de qualité du constructeur

Bahnanwendungen - Schweißen von Schienenfahrzeugen und -fahrzeugteilen - Teil 2: Anforderungen an Schweißbetriebe

This European Standard was approved by CEN on 24 August 2023 and includes Amendment 2 approved by CEN on 2 April 2025.

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**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN 15085-2:2020+A2:2025) has been prepared by Technical Committee CEN/TC 256 “Railway applications”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2026, and conflicting national standards shall be withdrawn at the latest by January 2026.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document includes Amendment 1 approved by CEN on 2023-08-24.

This document includes Amendment 2 approved by CEN on 2025-04-02.

This document supersedes A2 EN 15085-2:2020+A1:2023 A2.

A1 *deleted text* A1

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A2 A2.

This series of European Standards EN 15085 “*Railway applications - Welding of railway vehicles and components*” consists of the following parts:

- *Part 1: General;*
- *Part 2: Requirements for welding manufacturers;*
- *Part 3: Design requirements;*
- *Part 4: Production requirements;*
- *Part 5: Inspection, testing and documentation;*
- *Part 6: Maintenance welding requirements.*

A1 This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users’ national standards body. A complete listing of these bodies can be found on the CEN website. A1

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

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## Introduction

**A1** Welding is a special process in the manufacture of railway vehicles and their parts. The required provisions for this process are laid down in the standards series EN ISO 3834. The basis of these provisions is the basic technical welding standards with respect to the special requirements for the construction of railway vehicles.

This series of documents applies to welding of metallic materials in the manufacture and maintenance of railway vehicles and their parts.

It describes the control for the welding process for railway vehicles and their components for new manufacture and maintenance.

With respect to the railway environment, this series of standards defines the quality requirements for the welding manufacturer to undertake new building and repair work.

Components, parts and subassemblies are assigned a classification level, based on their safety relevance. According to these levels, qualifications for welding personnel of the manufacturer are specified.

This series provides an essential link between the weld performance class defined during design, the quality of the weld, and the demonstration of the required quality by inspection.

This series of documents does not deal with product qualification.

NOTE This series of documents can also be used by internal and external parties, including certification bodies, to assess the organization's ability to meet customer, regulatory and the organization's own requirements. **A1**

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## 1 Scope

This document defines the classification levels for welded components, the types of activity typically undertaken and the requirements to be fulfilled to demonstrate conformance.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 15085-1:2023, *Railway applications — Welding of railway vehicles and components — Part 1: General*

EN 15085-3:2022+A1:2023, *Railway applications — Welding of railway vehicles and components — Part 3: Design requirements*

EN 15085-4:2023, *Railway applications — Welding of railway vehicles and components — Part 4: Production requirements*

EN 15085-5:2023, *Railway applications — Welding of railway vehicles and components — Part 5: Inspection, testing and documentation*

EN 15085-6:2022, *Railway applications — Welding of railway vehicles and components — Part 6: Maintenance welding requirements* <sup>A1</sup>

EN ISO 3834 (all parts), *Quality requirements for fusion welding of metallic materials*

EN ISO 14554 (all parts), *Quality requirements for welding - Resistance welding of metallic materials*

EN ISO 14731:2019, *Welding coordination - Tasks and responsibilities (ISO 14731:2019)*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 15085-1:2023 <sup>A1</sup> and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>