

**DIN EN 15085-5**

ICS 25.160.10; 45.060.01

Supersedes: see below

**Railway applications –  
Welding of railway vehicles and components –  
Part 5: Inspection, testing and documentation  
English version of DIN EN 15085-5:2008-01**

Bahnanwendungen –  
Schweißen von Schienenfahrzeugen und -fahrzeugteilen –  
Teil 5: Prüfung und Dokumentation  
Englische Fassung DIN EN 15085-5:2008-01

Together with DIN EN 15085-3:2008-01 and DIN EN 15085-4:2008-01 supersedes DIN 6700-6:2000-08;  
together with DIN EN 15085-3:2008-01, supersedes DIN 6700-5:2002-05

Document comprises 17 pages



## **National foreword**

This standard has been prepared by Technical Committee CEN/TC 256 “Railway applications” (Secretariat: DIN, Germany) in collaboration with Technical Committee CEN/TC 121 “Welding and allied processes”.

The responsible German body involved in its preparation was the *Normenausschuss Fahrweg und Schienenfahrzeuge* (Railway Standards Committee), Technical Committee NA 087-04-13 AA *Schweißen im Schienenfahrzeugbau*.

The EN 15085-1 to EN 15085-5 series of European Standards replaces the DIN 6700-1 to DIN 6700-6 series of German national standards, with European Standard EN 15085-5 replacing the German national standard DIN 6700-6 and parts of DIN 6700-5.

### **Welding coordination**

At his discretion, the responsible welding coordinator may delegate tasks to a deputy coordinator designated by him, in which case the specifications of Annex B of DIN EN 15085-2:2008-01 are to be taken into account.

### **Visual examination**

In Germany, the visual examination of class CT 3 and CT 4 welds may be performed by a visual inspector who has been designated by the responsible welding coordinator as being qualified for such.

### **Amendments**

This standard differs from DIN 6700-5:2002-05 and DIN 6700-6:2000-08 as follows:

- a) The content has been updated to reflect the current state of technology and harmonized with European and international standardization.
- b) EN 15085-5 describes the inspection and testing of welded joints before, during and after welding. The scope of testing and the test methods to be used are specified in Table 1 for each inspection class.
- c) EN 15085-5 gives precise specifications as to when certified personnel are to carry out the inspections (required for inspection classes CT 1 and CT 2).
- d) EN 15085-5 gives precise specifications as to when inspections/tests are to be documented. Documentation is expressly required for inspection classes CT 1 and CT 2, and recommended for inspection class CT 3.
- e) The means of dealing with non-conformities is described.
- f) Annex A lists which welding related tasks as described in DIN EN ISO 14731 are to be performed during which manufacturing phases.

### **Previous editions**

DIN 6700-5: 2002-05

DIN 6700-6: 2000-08

English Version

## Railway applications - Welding of railway vehicles and components - Part 5: Inspection, testing and documentation

Applications ferroviaires - Soudage des véhicules  
ferroviaires et des pièces - Partie 5: Vérification, contrôles  
et documentations

Bahnanwendungen - Schweißen von Schienenfahrzeugen  
und -fahrzeugteilen - Teil 5: Prüfung und Dokumentation

This European Standard was approved by CEN on 26 August 2007.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**Management Centre: rue de Stassart, 36 B-1050 Brussels**

## Contents

Page

Foreword.....	3
Introduction .....	4
1 Scope .....	5
2 Normative references .....	5
3 Terms and definitions .....	6
4 Inspection and testing of welded joints .....	6
4.1 General.....	6
4.2 Inspection and testing before welding .....	6
4.3 Inspection and testing during welding.....	6
4.4 Inspection and testing after welding .....	7
5 Test planning and test criteria.....	8
5.1 Test planning.....	8
5.2 Test criteria.....	9
6 Documentation.....	9
7 Non-conformance and corrective actions.....	9
7.1 General.....	9
7.2 Management of non-conformance .....	10
7.3 Additional tests .....	11
8 Sub-contractors .....	11
9 Declaration of conformity .....	12
10 Traceability .....	12
Annex A (normative) Inspection and testing of welded joints .....	13

## Tables

Table 1 — Tests which have to be performed during production .....	8
Table A.1 — Relationship between essential welding related tasks and the manufacturing phases to be performed.....	13