



**Výzkumný ústav pozemních staveb
Certifikační společnost, s.r.o.**

Certifikační orgán pro výrobky, procesy, kvalifikaci a EPD č.3013 akreditovaný ČIA

issues

CERTIFICATE

No. 3013P-11-0344

**IMPLEMENTATION OF STEEL STRUCTURES ACCORDING TO ČSN EN
1090-2,
SPECIFIC REQUIREMENTS OF TKP 19 SŽDC AND CHAPTER 19 OF TKP
MD ČR INCLUDING PRODUCTION AND ASSEMBLY FOR THE VERSION
CLASS
EXC4**

Manufacturer: **Hutní montáže, a.s.** Ident No. 15504140
Company address: Ostrava , Vítkovice, Ruská 1162/60, PSČ 703 83
Locality delimitation: Headquarters, center-Assembly mechanisms Sviadnov and localities of buildings implemented
Identification and scope of certified process: Implementation of steel welded structures of the version class to EXC4 inclusive, according to ČSN 1090-2:2009 of steels of groups 1.1, 1.2, 1.3, 1.4, 4, 5, 6 and 8 according to TNI CEN ISO/TR 15608 by welding methods 111, 121, 135, 136, 141 and 783 according to ČSN EN ISO 4063:2010.

The certification body for products and production processes accredited by Český institut pro akreditaci, o.p. s (Czech institute for accreditation) reviewed the documents submitted by the manufacturer, checked the production and assembly processes in the place of production and installation and certifies that methods of steel structures implementation are in compliance with the requirements specified in ČSN EN 1090-2:2009 with concretization of requirements of Správa železniční dopravní cesty - SŽDC (Management of railway traffic roads) for implementation of railway steel bridges according to the Chapter 19 TKP of the state railways buildings – Steel bridges and structures and specific requirements of the Czech Department of Transport, the division of infrastructure for implementation of steel road bridges according to Chapter 19 TKP – Steel bridges and structures - Part A.

The Certificate is issued on the basis of the Certification Report no. P - 3013P-11-0344 of (date) 17.10.2011.

Validity of this Certificate is connected with fulfilment of conditions stated in the Certification Report and positive findings / observations of regular supervisions

Frequency of supervision above the certified process for implementation of steel structures is specified once a year at least

Certification diagram: initial review of documents, review of the production process and installation reliability performance, evaluation of the determination results, verification of compliance with requirements specified

Enclosures nos. 1, 2 and 3 specifying the scope of its operation form an integral part of this Certificate

Date of issue: 17.10.2011

Validity till: 16.10.2014 and is connected to fulfilment of conditions specified in the Certificate Report



Ing. Lubomír Keim
Ing. Lubomír Keim, CSc.

Manager of Certification Body for products and processes



Issue: 1
At 11380

Výzkumný ústav pozemních staveb - Certifikační společnost, s.r.o. 102 21 Praha 10 - Hostivař, Pražská 810 / 16
Id. No. 25052063 Tax Id. No. CZ25052063 Tel. 00420271751148, Fax: 00420281017241, E-mail: info@vups.cz www.vups.cz



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ENCLOSURE NO. 1

To the Certificate No. 3013P-11-0344

**PROCESS SPECIFICATION OF IMPLEMENTATION OF STEEL
STRUCTURES ACCORDING TO EN 1090-2 INCLUDING ASSEMBLY**

Manufacturer:	Hutní montáže, a.s.	Version class:	EXC4
Steel structures groups:	<ul style="list-style-type: none"> - surface building structures stressed statically and dynamically - unspecified railway and road bridges and structures similar to bridges - railway bridges within the Enclosure no.2, Road bridges within the Enclosure no. 3 - manufacture of auxiliary structures and plant used for the assembly 		
Mechanical joints:	<ul style="list-style-type: none"> - bolt joints with non-pre-stressed bolts - bolt joints with pre-stressed bolts 		
Welding:	Welding method according to ČSN EN ISO 4063	Material group according to TNI ČEN ISO/TR 15608:	Dimensions
	111	1.1, 1.2, 1.3, 1.4	BW t=8-80, FW t _≥ 5
	121	1.1, 1.2, 1.3, 1.4	BW t=12,5-50
	135	1.1	BW t=8-16, FW t=4-9,6
	136	1.1, 1.2, 1.3, 1.4	BW t=3-60, FW t _≥ 5
	141	1.1, 1.2, 4, 5, 6, 8	BW t=3-15
	783	1.1, 1.2	D=10-22
Quality in process of welding:	<p>The Manufacturer is a holder of the Quality certificate for fusion welding of metals according to EN ISO 3834-2. Fulfilment of requirements for quality in welding according to EN ISO 3834-2:2006 is shown in the Certification report no. 624 434/300 of 20th 2.2010, issued by the Certification body TÜV NORD CERT GmbH</p>		
Quality management system:	<p>The Manufacturer is a holder of the Quality management system certificate according to EN ISO 9001. Fulfilment of the standard EN ISO 9001 2009 requirements is shown in the Final report on certification no. 624 434/300 of 20th 2 2010 issued by the Certifying body TÜV NORD CERT GmbH.</p>		
Options of handling in production:	Max. Weight of structure. 900 tons		
Methods of erection:	<p>Assembly of parts through welding, mechanical linkage Implementation of erection through direct mounting, drawing out, cantilever method of construction</p>		
Welding supervision:	Ing Jiří Papež	EWE/CZ 02016	
Supervisor's representative:	Ing Milan Szemek	EWE/CZ 02017	
Supervisor's representative:	Ing Petr Štefaňák	IWE/CZ 04023	



o.s. Keim

Ing. Lubomír Keim, CSc.

Manager of Certification Body for products and processes



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3013-CZ-V002-08-20-19070



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ENCLOSURE No. 2

To the Certificate No. 3013P-11-0344

**PROCESS SPECIFICATION OF STEEL STRUCTURE IMPLEMENTATION
ACCORDING TO ČSN EN 1090-2 INCLUDING ERECTION WITH
CONCRETIZATION OF SPECIFIC REQUIREMENTS OF SPRÁVA
ŽELEZNIČNÍ DOPRAVNÍ CESTY, (RAILWAY TRANSPORT ROAD
MANAGEMENT), TKP 19 STATE RAILWAYS BUILDINGS, STEEL
BRIDGES AND STRUCTURES**

Manufacturer:	Hutní montáže, a.s.	Version class:	EXC4
ČSN 73 2603	Implementation of steel bridge structures		
TKP 19 Issued by SŽDC	Technical qualitative conditions of state railway buildings – Chapter 19 Steel bridges and structures		
Groups of steel structures of railway bridges and accessories	<ul style="list-style-type: none">- main load-bearing parts of the bridge- bridge bearings- bridge closures- beams embedded in concrete according to MVL 511- secondary load-bearing parts including bracing- anti-noise /soundproofing screens and barriers- signal bridges and brackets		

SŽDC representative participating in the process of audit

Ing. Václav Podlipný	Technical Expert of SŽDC
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ENCLOSURE No. 3

To the Certificate No. 3013P-11-0344

**PROCESS SPECIFICATION OF STEEL STRUCTURE IMPLEMENTATION
ACCORDING TO ČSN EN 1090-2 INCLUDING ERECTION WITH
CONCRETIZATION OF SPECIFIC REQUIREMENTS OF MD ČR, CHAPTER
19 TKP SURFACE ROADS, STEEL BRIDGES AND STRUCTURES**

Manufacturer:	Hutní montáže, a.s.	Version class:	EXC4
ČSN 73 2603	Implementation of steel bridge structures		
Chapter 19 TKP Issued by MD ČR	Technical qualitative conditions of surface roads Chapter 19 TKP – Steel bridges and structures - Part A		
Groups of steel structures of road bridges and accessories.	<ul style="list-style-type: none">- main load-bearing parts of the bridge- bridge bearings- bridge closures- embedded beams in concrete- secondary load-bearing parts including bracing- road restraint/stopping systems on bridges- portals of traffic signs		



v.z. Jant

Ing. Lubomír Keim, CSc.

Manager of Certification Body for products and processes

