

Certification Scheme for Welders and Welding Operators in accordance with ISO 17024

1. Foreword

The purpose of this scheme is to test a Welders competence to produce welds compliant with a pre-defined specification under examination conditions. This scheme is operated and managed by SGS UK Ltd accordance with ISO 17024:2012 and holds accreditation to this standard, administered by the United Kingdom Accreditation Service (UKAS)

2. Scope of certification

(ISO 17024 8.2 a)

The scheme certifies persons in order to be able to carry out Welding activities in accordance with ISO 17024:2012 and a variety of national and international Welding specifications and standards i.e BS EN ISO 9606, ASME IX & BS EN ISO 14732 to a pre-qualified manufacturers Welding Procedure.

The range of qualification for each welding position is given in Tables 9 and 10 of BS EN ISO 9606 as shown in Appendix A. The welding positions and symbols refer to ISO 6947.

The test pieces shall be welded in accordance with the testing positions specified in ISO 6947 or ASME IX as appropriate

3. Job and Task Description

(ISO 17024 8.2 b)

To be able to carry out unsupervised welding activities against British and/or International Standards as qualified

4. Required competence

(ISO 17024 8.2 c)

The following competence is required:

- The welder's ability manually to manipulate the electrode, welding torch or welding blowpipe, thereby producing a weld of acceptable quality.
- Welding of an item in the position required by either ISO 6947 or ASME IX in relation to the positional qualification required
- Basic welding and cutting safety requirements in order to demonstrate the proper use of equipment.
- Knowledge of safety requirements

5. Abilities

(ISO 17024 8.2 d)

In order to be able to qualify for certification you must have

- Physically able to carry out welding activities
- Eye sight – Sufficient to carry out welding activities

6. Pre-requisites

(ISO 17024 8.2 e)

Personnel who are wanting apply for certification through this must meet the following minimum requirements:-

- The ability to meet the requirements of Section 4 and 5 of this document.
- A valid form of photo ID

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- Welding plant and shielding gas (where applicable) for welding process(es) being used during examination.
- Welding test pieces material.
- Welding consumables.
- pWPS / WPS.
- Suitable area for joining of test pieces.
- PPE applicable to carry out welding activities.
- Other equipment such as angle grinder and applicable disks, power leads, anti-flash screens, work bench and jig for positioning of test piece.
- A suitable area to undertake functional knowledge test.

7. Application process

Upon application, SGS UK Ltd will perform a tender review to ascertain the requirements of Certification. On completion and agreement of the tender review, an application form shall be sent to the applicant's manufacturer (or welder or welding operator if self-employed).

The application form shall direct the applicant to the location of the particulars of this certification scheme on the company's website.

Fees or a quotation shall have been sent to the applicants sponsor prior to the booking.

The application form TEMP 011- (WELD-02) Revision 007. It shall contain:

- Each applicants' name, date of birth, place of birth, and chosen method of identification (initials or welder I.D).
- The test standard to be applied.
- An agreement indicating the candidate's commitment not to participate in fraudulent test-taking practices and to comply with the SGS Code of conduct IND-UK-002 (To be signed by the candidate) (ISO 17024 8.2 f)
- Pre-agreed time, date and location of examination

8. Assessment Process

(ISO 17024 8.3 a & b)

- The Applicant shall complete the functional knowledge test.
- The Applicant shall set up and produce a weld in accordance with the employers Welding Procedure Qualification Record
- The Invigilator shall be present during the set-up and welding process
- The invigilator shall record all relevant test parameters
- The Invigilator shall confirm the test requirements by reference to the application form and the Manufacturer's WPQR
- The invigilator shall confirm the identity of the candidate by the supplied official photo ID i.e. Passport, Photo ID Driving licence, or equivalent
- The candidate shall work in a safe manner. Failure to do so will cause the invigilator to halt the test
- Once the welder has completed the test the invigilator shall ensure the test piece is appropriately marked for identification and shall remove it for testing
- The completed weld will be subjected to a series of Non-Destructive & Destructive tests as defined by the applied test standard
- Pass/Fail decisions will be made based on the criteria outlined in the specified standard and not subject to the opinion of the Examiner

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- A results notice by way of an endorsed certificate of competence or a failure notice will be issued by SGS within 28 days of the test.

9. Surveillance

(ISO 17024 8.3c)

The qualifications of a welder for a process shall be confirmed every 6 months by employer or their delegated representative. This can also be achieved by an SGS Welding Invigilator witnessing an appropriate weld being successfully completed and confirmed as acceptable by the appropriate NDT and/or mechanical test techniques. This is the responsibility of the Employer to maintain.

10.Revalidation of Welder qualification.

The skill of the welder shall be periodically verified in accordance with the code or specification under which the original certification was issued.

When the revalidation method allows, the validity of the welder qualification certificate can be prolonged for the period stated in the qualification specification or code. It is the certificate holder's responsibility to review the requirements of the standard and submit the welded test piece(s) for volumetric NDT or mechanical testing prior to the certificate expiration date.

The certificate can then be prolonged providing the volumetric NDT or mechanical testing results are acceptable, the welding manager will review the welder qualification certificate and volumetric NDT / mechanical testing results to ensure the qualification standard requirements have been met and sign the certificate to extend the validity period of the certificate.

If the revalidation method shown on the certificate does not allow the certificate to be prolonged the certificate will expire on the date shown on the certificate and the welder will have to re-test.

Suspension or Withdrawal of certification

(ISO 17024 8.3 d)

Certificates may be withdrawn or suspended, where a welder has contravened the SGS Code of conduct. The Technical managers decision based upon their investigation can be appealed through the below process

Criteria for change of scope or level of certification

(ISO 17024 8.3e)

None

Complaints or appeals

All participants have the right to complaint, or to appeal decisions. In these instances participants should work through their SGS Point of Contact. Upon receipt of the complaint or appeal, the Welding Manager shall begin the complaints and appeals process, and SGS will make contact with you immediately after completing our initial investigation.

Appendix A

Extract from BS EN ISO 9606

