

Welding Procedure

Complete

- Fabricator shall establish a welding procedure and list applicable parameters in a Welding Procedure Qualification Record (WPQR or PQR), which shall be held as a record and shall be available for examination
- The welding procedures may be approved on the welding procedure sheets by a representative of the principal, who shall have the minimum qualification of welding supervisor or welding inspector.

Qualifications of Welders

- Welders should be suitably qualified to carry out the welding for which they are employed. The fabricator shall provide evidence acceptable to the principal that the welders are suitably qualified.
- AS1796; 2980; AS/NZ 3992; 4711; AS1554 or ISO 9606-1 shall be deemed to be qualified.
- Welders not qualified for process and position shall be required to demonstrate an ability to comply by means of a macro test.
- The names of the welders qualified, together with their particulars, shall be recorded and made available for perusal by an inspector for the duration of the job.
- *If a welder repeatedly produces welds not complying with this standard, further welding by the welder shall be discontinued until the welder carries out additional tests and the welds so produced comply to this standard.*
- *Reapproval shall be required if:*
 - (a) 6 months or more have passed since the welder was employed on the relevant process
 - (b) The welder changes employment subject to some conditions
 - (c) There is a question on the welder's ability.

Supervision

- Welding shall be carried out under the supervision of a welding supervisor or a welding coordinator employed by the fabricator.
- The welding supervisor shall ensure that all welding is carried out as specified in the standard.
- The supervisor must have completed AS 1796 Certificate 10 or AS 2214; or have served an apprenticeship in relevant metal trade with 5 years experience in welded steel structures; or have 7 years satisfactory experience in fabrication of welded steel structures; or hold a Certificate, Diploma, Degree or above in Engineering or Metallurgy with 3 years experience

Inspection

- The inspector shall have access at all reasonable times to all relevant phases, and be given reasonable notice in advance of the start of welding operations.
- The inspector must hold a WTIA Certificate of Welding Inspector or Structural Welding Supervisor, or equivalent.
- The inspector shall not be involved in the supervision of the welded fabrication.