



CERTIFICATION SCHEME FOR PERSONNEL

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Requirements for the Certification of Thermal Cutting Operators

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Issued under the authority of the Governing Board for Certification
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CSWIP is administered by TWI Certification Ltd

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Accreditation Certificate No 25

FOREWORD

The Certification Scheme for Personnel (CSWIP) is a comprehensive scheme which provides for the examination and certification of individuals seeking to demonstrate their knowledge and/or competence in their field of operation. The scope of CSWIP includes Welders, all levels of Welding Inspectors, Welding Supervisors, Welding Instructors, Welding Examiners, Welding Quality Control Co-ordinators, Heat Treatment Operatives, Cathodic Inspection personnel, Plant Inspectors, NDT personnel, Plastics Welders and Underwater Inspection personnel.

CSWIP is managed by the Certification Management Board, which acts as the Governing Board for Certification, in keeping with the requirements of the industries served by the scheme. The Certification Management Board, in turn, appoints specialist Management Committees to oversee specific parts of the scheme. All CSWIP Boards and Committees comprise member representatives of relevant industrial and other interests. TWI Certification Ltd is accredited by UKAS to BS EN ISO/IEC 17024 for certification of personnel.

TWI Certification Ltd understands the importance of impartiality in carrying out its certification activities, managing conflict of interest and ensuring the objectivity of all its certification activities, in accordance with BS EN ISO/IEC 17024.

ACCESS TO CERTIFICATION

Access to certification schemes is not improperly restricted. The sole criteria for certification are given in the document (and any subsequent amendments) and no other criteria will be applied. Certification is not conditional on the candidate applying for other services or membership from TWI Certification Ltd, its parent, or any other groups or associations.

1. Objectives

The quality of thermal cut material is critically dependent on the skill of individual operator. In order to ensure that Thermal Cutting Operators are working at the required level, a scheme for certifying the operatives is essential, it also provides recognised status for the operative and the organisation employing him/her

2. Scope

The scheme identifies personnel who have relevant experience in thermal cutting and who have attained a satisfactory level of knowledge. This document sets out the minimum practical and job knowledge requirements, the procedures by which certification is sought, and the method by which competence is assessed.

3. Skill Requirements

Thermal cutting operators are required to have at least six months proven industry experience in the application of manual thermal cutting.

Operatives are required to have knowledge about the thermal cutting processes used, the types of defects and or imperfections that may be encountered and how to rectify them.

4. The Examination

4.1. WRITTEN PART

Candidates will be required to take sit multiple choice question paper covering 10 subject areas, designed to test the candidate's knowledge of Thermal Cutting. Pass mark is 60%.

4.2. PRACTICAL PART

Candidates are required to demonstrate their competence as shown in Section 6.

5. Required Experience

Candidates applying to be a Thermal Cutting Operator must have a practical thermal cutting background as listed in Section 3. Relevant experience or a recognised course of training covering some or all of the skills and knowledge required for the full range of thermal cutting as listed in Section 6 is also acceptable.

6. Thermal Cutting Practical Assessment

The practical assessment will be witnessed and assessed by an Examiner and shall be in accordance with the requirements of the relevant standard or client requirements.

It is the responsibility of the operator to:

- a) Ensure the base materials, material dimensions, joint type and any other criteria required by the test are in accordance with the requirements before the test commences.
- b) Produce a detailed shape by thermal cutting as per the provided examination sketch using one of the following techniques:
 1. Oxy Fuel cutting
 2. Plasma Cutting
- c) Ensure that the completed test piece is the correct dimensions and all cut edges are free from dross, grinding is permissible on the corners however no surface grinding of the cut face is allowed
- d) All test pieces are to be adequately identified.

7. Application for Examination and Fees

Candidates will be required to submit an application form. All the information requested must be on these forms. No applications can be considered confirmed until receipt of correctly completed documents. Application forms ask for specific details of experience and training and must be signed to the effect that these details are correct.

In the event of a false statement being discovered on forms any examination undertaken will be declared null and void. A certificate is automatically invalidated if there are any outstanding examination fees in respect of these certificates.

Candidates proved to have cheated, or found to have attempted to remove or found to have removed examination material in a CSWIP examination will not be accepted as a candidate for any CSWIP examination for a minimum period of five years from the date of the examination where cheating, attempt to remove or removal of examination material, was established to have taken place.

8. Certification

8.1. RESULTS NOTICES

All candidates will be sent a results notice. This notice will also be sent to the organisation paying the examination fee, if not paid by the candidate.

8.2. SUCCESSFUL CANDIDATES

Two copies of a certificate of proficiency will be issued to the organisation or person that pays the examination fees. Duplicate certificates to replace those lost or destroyed will be issued only after extensive enquiries.

8.3. UNSUCCESSFUL CANDIDATES

Candidates who fail to obtain a certificate may attempt one retest of those parts of the examination in which success was not achieved. The retest must be completed within one year of the initial test, otherwise candidates will have to repeat the complete examination. Candidates who fail the retest revert to initial status.

8.4. PERIOD OF VALIDITY

The certificate is valid for three years from the date of completion of the initial test and may be renewed for a further three years on application, provided evidence is produced in accordance with Clause 8.5.1. Certificates are only valid provided:

- a) they are within date.
- b) they are on standard cream CSWIP paper bearing the CSWIP logo in black on gold signed by an officer of CSWIP and embossed with the CSWIP stamp.
- c) they have been signed by the individual to whom the certificate is awarded.
- d) they are accompanied by a valid official CSWIP identity card.

Photocopies are unauthorised by CSWIP and should only be used for internal administrative purposes.

8.5. RENEWAL

8.5.1. Three year renewal

In order for the certificate to be renewed after three years, the holder has to demonstrate that he/she has maintained his/her competence by:

- i) providing evidence of continuous work activity using flame cutting
- ii) providing evidence that the holder has kept up to date in flame cutting safety requirements and technology

Renewal must take place not later than 21 days after the date of expiry of the certificate. It is the certificate holder's responsibility to ensure that renewal takes place at the appropriate time. Only under extreme circumstances will certificates be renewed up to a maximum of six calendar months from the date of expiry shown on the certificate and late renewal will be subject to a special fee.

8.5.2. Six year recertification

Certificates are renewed beyond six years from the initial examination (or from a previous six year recertification) by the holder successfully completing a recertification examination prior to the expiry of the certificate in addition to the renewal procedure given in Clause 8.5.1.

The 10 year examination will consist of the following:

- Multiple choice written paper
- Initial practical assessment

One retest, within six months of the six year recertification examination, will be allowed. Candidates who fail the retest will be required to undertake formal training before attempting the initial examination.

8.6. COMPLAINTS AND APPEALS

An aggrieved party in a dispute which considers itself to have reasonable grounds for questioning the competency of a CSWIP qualified person may petition the Governing Board for non-renewal of the certificate. Such a petition must be accompanied by all relevant facts, and if in

the opinion of the Board an adequate case has been presented, a full investigation of the circumstances under dispute will be initiated. If the petition is substantiated to the satisfaction of the Board, the certificate will not be renewed without further test.

Appeals against failure to certify or against non-renewal of the certificate may be made by the instructor or the employer upon application in writing to the Governing Board.

9. Records

TWI Certification Ltd maintains records of successful and unsuccessful candidates. These records are accessible to the Governing Board or its nominees at all reasonable times.

ADDRESSES

For further general information about the approval schemes covered in this document contact:

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