



CERTIFICATION SCHEME FOR WELDING AND INSPECTION PERSONNEL

DOCUMENT NO. CSWIP-PED -1-99

Requirements for the Approval of Welding Procedures and Welders

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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

The use of the UKAS Accreditation Mark indicates accreditation in respect of those activities covered by Accreditation Certificate No 25

FOREWORD

The Certification Scheme for Welding and Inspection 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 Welding Engineers, Welding Technicians, Welding Inspectors, Welding Supervisors, Welding Instructors 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.

1 GENERAL

1.1 Scope

This document prescribes the requirements for the approval of welding procedures and welders for manufacturers seeking to comply with the Pressure Equipment Regulations ⁽¹⁾ or with any other relevant standard or client specification which require such approval.

1.2 Responsibilities

TWI Certification Ltd acts as the Certifying Body. It carries overall responsibility for ensuring that the requirements for approval testing are satisfied and that appropriate approval certificates are issued following successful approval tests.

The particular requirements for approval testing are given in the appropriate standard. It is the manufacturer's responsibility to select a standard from the list given in section 2. Approval testing and the issue of certificates can only be carried out to these standards and the rules covering testing and validity of approval certificates vary.

It is also the manufacturer's responsibility to ensure that the recognition and acceptance of approval certificates is appropriate to their requirements. For example, some standards state that the Examiner or Examining Body must be acceptable to the contracting parties. Whilst TWI Certification makes every effort to ensure that its approval certificates carry appropriate accreditation and that testing and certification activities are carried out in accordance with best practice, it can not guarantee acceptance by any particular customer or client.

In terms of compliance with the Pressure Equipment Regulations⁽¹⁾, TWI Certification Ltd is a Recognised Third Party Organisation for the approval of welding procedures and welders. It is not authorised or notified to assess or establish conformity with the whole of the Directive.

Testing activities are subcontracted by TWI Certification Ltd to one of its approved Examining Bodies, see section 8. These Bodies will act as the interface between TWI Certification and the manufacturer. TWI Certification Ltd rigorously controls the procedures and functions of Examining Bodies in the conduct of their work on behalf of TWI Certification Ltd.

Testing of individual candidates (or welding procedures) is arranged between the Examining Body and the manufacturer. The Examining Body will also check that any pre-test requirements as applicable are fulfilled by the candidate(s). The Examining Body is responsible for setting examinations and tests, witnessing welding and/or testing as required by the selected standard and for informing TWI Certification of the test results.

If mechanical testing or NDT is needed in relation to a welder approval or a welding procedure approval test, the Examining Body must employ a UKAS approved test house with the appropriate scope of approval.

2 STANDARDS

Approval testing and certification is available in accordance with the current issues of the standards listed below:

2.1 Welder Approval Testing

EN 287-1:	Approval testing of Welders - Fusion Welding – Part 1: Steels
BS EN ISO 9606	Approval Testing of Welders – Fusion Welding – Part 2: Aluminium and Aluminium Alloys
AWS D1.1:	Structural Welding Code – Steel
AWS D3.6M:	Specification for Underwater Welding
ASME:	Boiler and Pressure Vessel Code. Section IX. Welding and brazing qualifications
BS EN 13133:	Brazing, Brazer approval,

2.2 Welding Procedure Approvals

EN 288: All parts	Specification and Qualification of Welding Procedures for Metallic Materials
BS EN 15614: All parts	Specification and Qualification of Welding Procedures for Metallic Materials
BS EN 15613	Specification and Qualification of Welding Procedures for Metallic Materials
AWS D1.1:	Structural Welding Code - Steel
ASME:	Boiler and Pressure Vessel Code. Section IX. Welding and brazing qualifications
BS EN 13134:	Brazing. Procedure approval.

The above lists are not intended to be exhaustive and other appropriate standards may be used.

3 **APPROVAL TESTING**

3.1 **Welders and Welding Procedures**

The Examining Body is responsible for ensuring that the requirements of the standard selected by the manufacturer are fulfilled. The standards are prescriptive and require no additional criteria.

4 **APPROVAL CERTIFICATES**

The following paragraphs apply unless stated otherwise in the selected approval standard.

Two approval certificates are issued for each successful examination to the sponsoring organisation, usually the manufacturer. Duplicate certificates may be issued to the sponsoring organisation to replace any which are lost or destroyed. This will only be done after extensive enquiries by TWI Certification Ltd.

The period of validity of an approval certificate and the conditions for renewal are governed by the selected standard. Certificates are only valid providing that:

- 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.

*Note: In the case of welding procedure approvals, c) and d) do not apply.

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5 **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 candidate or the manufacturer upon application in writing to the Governing Board but must be within six months of the date of examination.

6 **RECORDS**

Examining Bodies and TWI Certification Ltd maintain records of examinations and tests. Full records are only held for a period of eight months from the date of the test, only outline details of the test and the results are maintained on file.

7 **APPLICATION FOR TESTING AND FEES**

Manufactures will be required to submit completed application forms to the Examining Body. These forms are issued by the Examining Body and all the information required must be on these forms. In the event of a false statement being discovered in the information provided by the manufacturer, any testing undertaken will be declared null and void. Approval certificates are automatically invalidated if there are any outstanding fees.

8 **ADDRESSES**

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

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For specific information on examinations and tests and arranging for them to be carried out, contact the approved Examining Body:

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REFERENCE

- 1 The Pressure Equipment Regulations 1999 (S.I. 1999 No 2001)