



CERTIFICATION SCHEME FOR PERSONNEL

DOCUMENT No. CSWIP-WI-6-92

Requirements for the Certification of Visual Welding Inspectors Welding Inspectors and Senior Welding Inspectors (fusion welding) in accordance with the requirements of BS EN ISO 17637

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CSWIP is administered by TWI Certification Ltd

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 among others, Welding Inspectors, Welding Supervisors, Welding Instructors, Welding Examiners, Welding Quality Control Co-ordinators, Heat Treatment Operatives, Cathodic Inspection personnel, Plant Inspectors, Underwater Inspectors, Plastics Welders and NDT 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 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 ISO/IEC 17024 (latest revision).

The current document covers the Certification of Visual Welding Inspectors, Welding Inspectors and Senior Welding Inspectors. There are two categories of Senior Welding Inspector: one with Radiographic Interpretation and one without.

N.B. CSWIP Senior Welding Inspector with Radiographic Interpretation does not comply with ISO 9712 requirements.

The requirements governing Registration of Visual Welding Inspectors, Welding Inspectors and Senior Welding Inspectors are detailed in separate documents: CSWIP-WI-1-91 Part 1 and Part 2. Success in the appropriate CSWIP Certification examination is one of the prerequisites of Registration.

Registration is strongly recommended as it helps to satisfy the CSWIP certificate renewal requirements, see Clause 4.5.1.

N.B. Mentions of codes and standards throughout this document refer to the latest revision, unless otherwise specified.

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. General

1.1 Scope

This document prescribes procedures by which personnel may be examined, and, if successful, certificated for the duties of Visual Welding Inspector, Welding Inspector or Senior Welding Inspector, as defined in Clause 1.2. This document does not purport to cover personnel who do not have the responsibilities defined in Clause 1.2. The examinations are primarily intended for fusion welded steel construction, but endorsements are available for other material groups.

There are recognition arrangements between TWI Certification Ltd and other Welding Inspector Certification Schemes: details of which can be found at www.cswip.com

This scheme is not normally intended to apply to engineers or engineering surveyors concerned with the total certification of the plant.

1.2 Responsibilities of personnel

Typical areas of work activity of personnel for whom CSWIP Welding Inspector certifications would be suitable are given below:

1.2.1 Visual Welding Inspectors

- a) Post weld visual inspection
Visual inspection and dimensional check of completed weld against specification requirements and drawings.

and under the supervision of a Welding Inspector or Senior Welding Inspector:

- b) Establish the most suitable welding processes
- c) Codes and standards
Application of the requirements of codes and standards.
- d) Parent material identity
Verification against documentation and markings of correctness of parent material.
- e) Welding consumables identity
Verification of correctness of welding consumables (electrodes, filler wires, consumable inserts, gases, fluxes etc).
- f) Pre-weld inspection
Verification that dimensions, fit up and weld preparations are in accordance with the engineering drawings.
- g) Preheating
Verification that preheat (where required) is in accordance with specified procedures.
- h) In-process welding surveillance
Surveillance during welding to verify compliance with specified procedure including any preheat, interpass temperature control and post heat requirements.

1.2.2 Welding Inspectors

Those given above plus:

- i) Supervision of Visual Welding Inspectors in the conduct of activities (b) to (h) above.
- j) Welding procedures
Establishing that a procedure is available, has been approved as required by the appropriate authority and is being employed in production.
- k) Witnessing of welder and procedure approval tests
Witnessing the preparation of test pieces and destructive tests, and verifying compliance with appropriate standards and specifications.
- l) Welder approvals
Verification that adequate and valid welder approvals are available, and that only approved welders as required are used in production.
- m) Post weld heat treatment
Verification that post weld heat treatment has been conducted in accordance with specification requirements.
- n) Reports
Preparation of inspection reports.

1.2.3 Senior Welding Inspectors

Those given above plus:

- o) Supervision of Welding Inspectors and Visual Welding Inspectors in the conduct of activities (b) to (n) above as appropriate.
- p) Certification of compliance
Final acceptance and certification that the requirements of the specification have been met.
- q) Weld drawings
Interpretation of weld drawings and weld symbols.
- r) Records
Maintenance of comprehensive inspection records.
- s) Weld defects
Identification of weld defects and determination of their acceptability in relation to the written specification.
- t) NDT results
Verification of NDT reports on welding work for which the Senior Welding Inspector is responsible. This may include radiographic testing results.
- u) Quality assurance
Ensuring that quality assurance standards and procedures are maintained.

1.3 Requirements prior to taking a certification test

Job responsibilities and experience criteria for examination eligibility as given below are strictly adhered to and enforced.

1.3.1 Visual Welding Inspector

Although there is no specific experience requirement it is recommended that candidates possess a minimum of six months' welding related engineering experience and two years industrial experience.

In addition, candidates must comply with Clause 1.3.4.

1.3.2 Welding Inspector

A minimum of 3 years welding inspection experience related to the duties and responsibilities listed in Clause 1.2.1 and 1.2.2 under qualified supervision, independently verified

or

CSWIP Visual Welding Inspector for a minimum of 2 years with job responsibilities in the areas listed in 1.2.1 and 1.2.2 above

or

CSWIP Welding Instructor or CSWIP Welding Foreman/Supervisor for a minimum of one year.

In addition to all of the above, candidates must comply with Clause 1.3.4.

1.3.3 Senior Welding Inspector

CSWIP Welding Inspector for a minimum of 2 years with job responsibilities in the areas listed in 1.2.1, 1.2.2 and 1.2.3 above

or

5 years' authenticated welding inspection experience related to the duties and responsibilities listed in Clause 1.2.1, 1.2.2 and 1.2.3, independently verified.

In addition to the above, candidates must comply with Clause 1.3.4.

1.3.4 Training

All candidates (with the exception of 'mature candidates,' see section 1.4) must attend a CSWIP approved course of training at the appropriate level prior to examination. Details of such courses are available on request from www.twitraining.com

1.3.5 Health/Eyesight

Candidates need to be in satisfactory physical condition, and the person completing the application form will be required to signify that the candidate's health and eyesight are adequate to enable them to carry out their duties. An eyesight test certificate must be submitted with the application form issued by a medically recognised person within the previous 12 months, to provide proof of near visual acuity unaided, uncorrected or corrected in at least one eye, such that the candidate is capable of reading Times Roman N5 fonts or Jaeger Number 1 fonts, or equivalent sized letters. These letters shall have a height of 1.6 mm at a distance of not less than 30 cm with one or both eyes on a standard reading test chart.

1.4 Mature Candidate Route

A mature candidate route offering exemption from formal training is available for the following:

1.4.1 Visual Welding Inspector

Candidates who are able to demonstrate at least ten years' recent continuous experience in visual welding inspection duties, as indicated in Clause 1.2.1 under qualified supervision, independently verified.

1.4.2 Welding Inspector

Candidates who are able to demonstrate at least ten years' recent continuous experience in welding inspection duties, as indicated in Clause 1.2.1 and 1.2.2 under qualified supervision, independently verified

or

Candidates who hold an International Welding Inspector Basic Level Diploma with two years' recent continuous experience in welding inspection duties, as indicated in Clause 1.2.1 and 1.2.2 under qualified supervision, independently verified.

1.4.3 Senior Welding Inspector

Candidates who hold an International Welding Inspector Standard Level Diploma with two years' recent continuous experience in senior welding inspection duties, as indicated in Clause 1.2.1, 1.2.2 and 1.2.3, independently verified.

2. EXAMINATION PROCEDURE

2.1 Visual Welding Inspector

The examination procedure for the Visual Welding Inspector consists of a practical examination only, and candidates must satisfy the examiner in all parts (see 2.2.2). Details of the examination format and syllabus are given in Appendix 1.

2.2 Welding Inspector

The examination procedure for the Welding Inspector (consists of written and practical examinations. Please refer to Appendices 1 and 2 respectively for details of the examination format and syllabus.

2.2.1 Written examination

The written examinations consist of multiple choice question papers and are designed to test the candidate's knowledge of the syllabus.

2.2.2 Practical examination

Candidates will be required to inspect and report on eight examination specimens.

2.3 Senior Welding Inspector 3.2.1

Candidates who do not already hold a valid CSWIP Welding Inspector certificate must also complete the full Welding Inspector examination, including mature candidates, in addition to the procedure outlined below.

2.3.1 Examination

The written examinations consist of multiple choice questions and are designed to test the candidate's knowledge of the syllabus.

- a) General knowledge question paper.
- b) Scrutinise four NDT-related documents.
- c) Scrutinise and interpret a fabrication drawing.
- d) Answer multiple choice questions based on the TWI Specification.

2.4 Supplementary Radiographic Interpretation

Candidates who hold a valid Senior Welding Inspector 3.2.1 may take at any time during the life cycle of this certification the radiographic interpreter supplementary examination to gain the 3.2.2 Senior Welding Inspector.

N.B. CSWIP Senior Welding Inspector with Radiographic Interpretation does not comply with ISO 9712 requirements.

2.4.1 Written Examination

The written examination consists of multiple choice questions and is designed to test the candidate's knowledge of the syllabus.

2.4.2 Practical Examination

Candidates are required to interpret 10 images of radiographs and answer 5 multiple choice questions per each image.

N.B. The practical part of the examination covers both light and dense metallic materials.

2.5 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 that certificate.

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.

Examinations may be taken at any one of a number of Test Centres in the UK and overseas. Lists are available on request.

3. CATEGORIES OF CERTIFICATION

Candidates may apply for one of the following certification categories:

- 3.0 Visual Welding Inspector
- 3.1 Welding Inspector
- 3.2.1 Senior Welding Inspector without radiographic interpretation
- 3.2.2 Senior Welding Inspector with radiographic interpretation.

Note: Senior Welding Inspector certificates will contain no reference to any NDT certification unless the radiographic interpreter supplementary is taken.

4. CERTIFICATION

4.1 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.

4.2 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.

4.3 Unsuccessful candidates

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

The retest (or complete re-examination) may not be taken within 30 days of the previous examination, unless additional approved training is undertaken before taking the retest.

Candidates who are unsuccessful in the retest will be required to re-take the full approved course followed by the full examination.

4.4 Period of validity

The certificate is valid for five years from the date of completion of the initial examination and may be renewed for a further five years on application, provided evidence is produced in accordance with Clause 4.5.1. 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; and
- 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.

4.5 Renewal

4.5.1 Five year renewal

In order for the certificate to be renewed after five years, the holder has to demonstrate that they have maintained their competence by:

- i) *providing evidence of continuous work activity in welding inspection; and
- ii) providing evidence that the holder has kept up to date in welding technology; and
- iii) providing evidence of satisfactory visual acuity in accordance with Clause 1.3.5. The eyesight test must have been completed within the 12 months prior to renewal.

One way of satisfying Part (ii) is by Registration (see document CSWIP-WI-1-91). Part (i) can be satisfied by submitting a log sheet of relevant work activity covering the period of validity of the certificate. Requests for the appropriate documentation should be sent to TWI Certification. Contact details are provided at the end of this document.

The certificate will not be renewed without further test if a substantiated complaint is notified by the Governing Board during the period of its validity. Further instruction and retest may then be required.

Renewal must take place no later than 21 days after the date of expiry. 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. Candidates who do not renew or cannot provide verified evidence of work activity will be required to undertake an examination as directed by the Certification Body.

4.5.2 Ten year recertification

Certificates are renewed beyond ten years from the initial examination (or from a previous ten 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 4.5.1. Requests for the appropriate documentation should be sent to TWI Certification Ltd.

The 10 year examination for Visual Welding Inspector will consist of a practical visual inspection of eight examination specimens.

* As a guide, 'reasonable continuity' in any given five year period means that absences from work for which the certificate was granted should not exceed one year in one or several periods.

The 10 year examination for Welding Inspector (and Senior Welding Inspector 3.2.1) will consist of the following:

- a) Multiple choice general paper.
- b) Practical visual inspection of eight examination specimens.

Note: To renew a 3.2.2 Senior Welding Inspector certificate, in addition holders will be required to take the standard radiographic interpreter practical endorsement.

One retest, to be taken within six months of the 10 year renewal examination, will be allowed.

Failure by a Visual Welding Inspector or Welding Inspector at the retest point will mean that the candidate must take the full course and successfully pass the full initial examination to regain the certification.

Failure by a Senior Welding Inspector at the retest point will mean that the candidate must successfully pass the full initial examination for Welding Inspector and then take the full course and successfully pass the examination for Senior Welding Inspector.

A 3.2.2 Senior Welding Inspector who chooses not to take or who fails only the radiographic interpreter renewal practical will be awarded a Senior Welding Inspector 3.2.1 certificate. The full supplementary radiographic interpretation can be retaken at any time during the life of the 3.2.1 certificate.

4.6 Complaints and appeals

An aggrieved party in a dispute which considers itself to have reasonable grounds for questioning the competency of a CSWIP-certified 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 inspector or the employer upon application in writing to the Governing Board.

4.7 Supplementary tests

4.7.1 3.2.1 Senior Welding Inspector

Candidates for Senior Welding Inspector who already possess a valid CSWIP Welding Inspector certificate will be required to undertake a supplementary test consisting of all the parts listed in Section 2.3.

It is not recommended that a supplementary test be attempted during the 12 weeks immediately preceding the expiry date of an existing certificate as failure could jeopardise renewal/recertification of the CSWIP Welding Inspector.

Certificates issued as a result of successful completion of the CSWIP Senior Welding Inspector examination may supersede any previous CSWIP Welding Inspector certificate. Such certificates will be valid for five years from the date of the initial examination.

4.7.2 Radiographic Interpretation

The supplementary Radiographic Interpretation may be taken as an option at the same time as the Senior Welding Inspector examination or at any time later during the life of the certificate. Success in this supplementary examination does not extend the life of the certificate to which it is added.

5. 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.

6. REFERENCES

ISO 17637	Non-destructive testing of welds. Visual testing of fusion-welded joints
ISO 17024	Conformity assessment. General requirements for bodies operating certification of persons
ISO 9606	Qualification testing of welders. Fusion welding. Steels
ISO 9712	Non-destructive testing – Qualification and certification of NDT personnel
ASME IX	Qualification Standard for Welding, Brazing, and Fusing Procedures; Welders; Brazers; and Welding, Brazing, and Fusing Operators

7. ADDRESSES

For further general information contact:

TWI Certification Ltd
Granta Park
Great Abington
Cambridge
CB21 6AL
UK

Phone: +44 (0) 1223 899000
Email: personnel@twicertification.com
Website: www.cswip.com

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

TWI Training and Examinations
Granta Park
Great Abington
Cambridge
CB21 6AL
UK

Phone: +44 (0) 1223 899500
Email: trainexam@twi.co.uk
Website: www.twitraining.co.uk

CERTIFICATION SCHEME FOR PERSONNEL

CERTIFICATION OF VISUAL WELDING INSPECTORS, WELDING INSPECTORS AND SENIOR WELDING INSPECTORS

APPENDICES TO DOCUMENT NO CSWIP-WI-6-92

Appendix 1: Examination Syllabus

Appendix 2: Radiographic Interpreter (Welds) Syllabus

APPENDIX 1: EXAMINATION SYLLABUS

1 Visual Welding Inspector

1.1 Examination format

Practical Part A1: Inspection of eight examination specimens to a code provided by the Test Centre. Time allowed: 90 minutes.

Practical Part B1: Inspection of a T-joint fillet weld (not fractured) to a code provided by the test centre. Time allowed: 30 minutes.

Pass mark for all parts is 70%.

1.2 Subjects

Candidates will be expected to have knowledge of:

- a) **Codes and Standards**
The make-up of typical application standards.
- b) **Terminology**
Welds, joints, weld face, toe, root, throat, leg length, HAZ, fusion boundary. Terminology for defects.
- c) **Materials – Inspection points**
 - Size: thicknesses, lengths, diameters
 - Type: grade, composition against documentation
 - Condition: cleanliness and surface for welding
 - Heat treatment condition and distortion
- d) **Welding processes**
Basic features of manual and mechanised welding processes.

The identification of weld defects due to misuse or malfunction of processes.
- e) **Consumables**
The identification of consumables to British, European, ISO and American standards.

Coating types and fluxes. Shielding gas compositions. Electrode and filler wire compositions.

The storage and drying of electrodes and fluxes, matching consumables (electrodes with shielding gases, electrodes with fluxes).
- f) **Visual examination and dimensional checking before and after welding**
Weld preparations and fit-up. Dimensions and shape of finished welds. Defects. Code requirements.
- g) **Identification of pre-heat**
Application and control.
- h) **Safety**
Health and safety requirements and practices.
- i) **Visual examination of repaired welds**
Partially removed welds and completed removed welds.

2 Welding Inspector

2.1 Examination format

Theory Part 1:	Welding Inspection Theory 80 multiple choice questions. Time allowed: 2 hours.
Theory Part 2	Questions relating to WPS's and welder certifications 40 multiple choice questions. Time allowed: 1 hour 30 minutes.
Practical Part 1:	Inspection of eight examination specimens to a code provided by the Test Centre. Time allowed: 1 hour 30 minutes.

Pass mark for all parts is 70%.

2.2 Subjects

Candidates will need to demonstrate knowledge of the Visual Welding Inspector syllabus plus:

i) **Materials**

- Size: thicknesses, lengths, diameters
- Type: grade composition against documentation
- Condition: cleanliness and surface for welding
- Heat treatment condition and distortion

The effect of composition, thickness and hydrogen on welding of certain grades of steel. The techniques and control used to avoid hydrogen induced cracking and lamellar tearing.

Post weld heat treatment, its conduct and control.

j) **Welding processes**

The effect of variations in welding parameters. The influence of process on appearance and penetration. British, American and ISO symbols on drawings.

k) **Welding procedures and welder approvals and their control**

The essential features of a procedure.

British, European, American and other systems of procedure and welder approval and appropriate documentation.

l) **Quality control of welding**

The implementation of quality controls and in-process inspection. Organisation and records.

m) **Destructive tests**

The selection and purpose of all destructive tests specified in standards. Assessment of results.

n) **Non-destructive testing**

The methods, capabilities and limitations, and assessments of reports related to penetrant, magnetic particle, radiographic and ultrasonic testing of parent materials and welded joints.

o) **Weld defects**

Identification of defects. Reasons for their occurrence and acceptance.

p) **Distortion**

The influence of welding techniques on distortion. The control of distortion. The influence of heat treatment and machining.

q) **Reporting**

The preparation of technical reports on all aspects of inspection referred to above.

3 Senior Welding Inspector 3.2.1

3.1 Examination format

Candidates who do not already hold a CSWIP Welding Inspection certificate must also complete the full Welding Inspector examination in addition to the procedures outlined below:

Theory Part A3:	General Welding Theory, Product Technology and NDT. 30 multiple choice questions. Time allowed: 45 minutes.
Theory Part B1:	Scrutinise and comment on four NDT-related documents. 40 multiple choice questions. Time allowed: 75 minutes.
Theory Part C3:	Scrutiny and interpretation of a fabrication drawing. 10 multiple choice questions. Time allowed: 30 minutes.
Theory Part D3:	TWI Specification. 60 multiple choice questions. Time allowed: 150 minutes.

Pass mark for all parts is 70%.

3.2 Subjects

Candidates will need to demonstrate a knowledge of the Visual Welding Inspector and Welding Inspector Syllabuses given in more detail above plus:

- r) **Supervision of welding inspectors and record keeping**
Supervisory techniques and the duties of a supervisor including comprehensive record keeping.
- s) **Certification of compliance**
Requirements of typical contracts, codes and specifications.
- t) **NDT**
Factors affecting the detectability of weld defects by the various NDT methods. A detailed knowledge of verification of NDT results and reports for conventional volumetric and surface methods.
- u) **Weld drawings**
The understanding and interpretation of weld drawings.
- v) **Quality assurance**
Quality assurance and quality control procedures and their implementation.

4 Radiographic Interpretation – Supplementary

4.1 Examination format

Theory Part D3: Standard Radiographic Interpretation Option - Nature and properties of X and/or gamma radiation. Photographic aspects, fundamental aspects of radiographic quality, geometry of image formation, interpretation.
20 multi-choice questions. Time allowed: 30 minutes.

Practical Part D3: Radiographic interpretation: Certification is awarded for arc welding processes for light and dense metallic welds.

Consists of 50 multiple choice questions related to 10 images of radiographs (each image of a radiograph is followed by 5 questions).

Candidates are required to interpret the image first as the answers to the questions are linked to the interpretation result.

This part of the examination is Open Book (TWI specification is available).

Time allowed: total 1 hour and 40 minutes.

Pass mark for all parts is 70%

4.2 Subjects

- x) **Review of Radiographs**
Interpretation of weld radiographs. In accordance with the Radiographic Interpreter (welds) syllabus, see Appendix 2 2.

APPENDIX 2: REVIEW OF RADIOGRAPHS (WELDS) SYLLABUS

Theory

1 Nature and properties of X and/or gamma radiation

Penetration, absorption, scatter, diffraction, transmission. Rectilinear propagation. Photographic properties.

2 Photographic aspects

- a) Dark room procedures: layout, light traps and entrance, wet and dry benches, film-pass hatches, processing units, safe-lights and ancillary equipment. Handling and processing of films, temperature control.
- b) Sensitometry: types of film and paper used in industrial radiography. Characteristic curves, speed, contrast, definition, density. Fog. Graininess. Inherent unsharpness. Latitude. Commercial films and their properties.
- c) The use of screens.
- d) Spurious indications: light (and safe-light) fogging, chemical fog, strains, air bubbles, reticulation, pressure marks, static marks, drying marks, finger marks, defective screens, incomplete fixing, film manufacturing faults.

3 Fundamental aspects of radiographic quality

- a) Quality of radiation.
- b) Optimum working densities.
- c) Radiographic contrast. Objective and subjective contrast. Methods of controlling radiographic contrast. Effects of scattered radiation. Use of filters, screens, masking and blocking media. Influence of processing conditions and viewing conditions on contrast.
- d) Radiographic definition: objective and subjective, unsharpness, geometric unsharpness, inter-relationship of dimensions of focal spot or source, focus (source) - object and focus (source) - film distances. Inherent unsharpness. Movement. Film screen contact. The summation of factors controlling definition.
- e) Control of radiographic sensitivity and its assessment by the use of image quality indicators.

4 X-ray and gamma ray equipment

A knowledge of the effects on radiographic quality in the event of equipment change.

5 Geometry of image formation

Control of focus (source) - object distance, object - film distance, focus (source) - film distance. Selection of beam angle.

6 Exposure calculations

Effect of distance on exposure. Use of exposure charts and calculators for X and gamma radiography.

7 Application to welds

- a) Interpretation of radiographs in steel plate, and circumferential butt joints in steel pipe.
- b) Welds in aluminium.
- c) Welds in copper and its alloys.

d) Welds in small bore tubes.

e) The determination of the depth of a flaw from one surface in a specimen by the practical use of the tube or source shift method.

8 Viewing of radiographs

Optimum viewing conditions. Checking for acceptable density, contrast and freedom from spurious indications. Analyse the loss of sensitivity in order to rectify faulty techniques.

9 Welding technology

a) Terminology for welds, welded joints, welding procedures, weld defects, parent metal defects.

b) Influence on techniques of geometry, size, surface condition, parent metal composition, weld metal structure. Influence of surface cladding, heat treatments and weld repairs.

c) Basic principles of fusion welding processes.

d) Types of defect associated with particular parent metal/welding process combinations. Types of defect in welds and parent metals detectable by ultrasonics. Defect parameters which influence detectability, e.g. size, geometry, distance from surface, orientation, reflectivity and opacity.

Practical

1 Practical part is based on BS EN ISO standards. Candidates are required to interpret 10 images of radiographs and answer 50 multiple choice questions (5 per image). The questions are focused on the following main areas of knowledge.

a) Sensitivity assessment (Image quality Indicator, optical density)

b) Technique validation assessment (correct selection of configuration, correct number of exposures required for 100% inspection, and similar).

c) Correct characterisation of the defect(s) (candidate is required to recognise the defect(s) on the weld radiograph and provide the name using correct terminology)

d) Acceptability assessment (candidate is required to be able to apply correct acceptance criteria and make a decision: Acceptable / Non-acceptable).

e) Welding process adjustment (candidate is required to correctly identify the possible reason for the origination of the welding defect).