



# Certification Process: Welding Personnel – Pressure Equipment

(Safety) Regulations 2016, SI 2016 No. 1105



When you contact us with regards to gaining Certification for your personnel our sales team will send you the appropriate application form.

The application includes all the necessary information required for us to issue a quotation, this often includes Name and Contact, Number of Applicants, Location, Language etc.

Once completed the application is reviewed by the certification body to ensure sufficient information is included, and that certification procedure can continue. A quote is then issued.

Planning includes appointment of the team, arranging dates and times, agreeing delegated/subcontracted activities and agreeing details of the exam.

Once the quote and plan is accepted our examiner will carry out the assessment in line with the agreed plan.

The reviewer will verify the exam results are in accordance with the applicable standards and approval criteria, they will further ensure all documentation is correct and present.

If certification is recommended by the reviewer a Certifier will carry out some additional checks and make the final decision. Upon a positive decision the Certificate is issued.

A plan is created to carry out Quality Inspections and Monitoring.



If at any stage in the process there is an issue that would prevent the final certification you will be sent the details and we can discuss further options available to you.

## Scope Covered by this scheme

For our latest scope please see our approved body listing:

<https://www.gov.uk/uk-market-conformity-assessment-bodies/tuv-rheinland-uk-ltd>

### APPLICABLE STANDARDS:

- EN ISO 9606 series (for qualification of welders)
- EN ISO 14732 (for qualification of operators / setters of welding equipment)

## Current Qualifications

In order to verify current qualifications under this scheme; please contact  
UKCA@uk.tuv.com

## Pre-requisites

The expected competence of an applicant is the ability to apply knowledge and skills to achieve intended results. It is therefore presumed that the applicant (welder, operator) has received training and/or has industrial practice within the range of qualification. Listed below are requirements which need to be submitted/confirmed on or before the day of examination:

- Applicants should be at least 18 years old (verification required on the day of examination using Photo ID).
- Confirmation of training in the requested area is required (including the requested revision of the standard or reference specification).
- Applicants should be fit and able for welding work medical certificate of no health impediments to be verified)
- Completed application and signed contract should be received
- Suitable facilities to conduct the theoretical and practical examinations

### FACILITY REQUIREMENT:

- A suitable\* examination room for the theoretical part of the examination. The room should have seating and writing positions equal to the number of candidates, with a minimum spacing of 2m<sup>2</sup> per person sitting the exam and adequate lighting and ventilation.
- A suitable\* area for the practical part of the examination (and changing facilities). The welding room shall consist of separate welding stations, anti-slip flooring of non-combustible material, adequate lighting (min. 500lx), adequate temperature (14°C min.), minimum ceiling height of 3.75m, sufficient gas extraction systems, minimum floor area of 2m<sup>2</sup>, suitable welding tools and equipment, all safety measures followed and correctly implemented.

For further criteria relating to facility requirements, please see annex 1

## Impartiality statement

The top management of TUV Rheinland UK Ltd is committed to maintain impartiality in Top management of TUV Rheinland UK Ltd is committed to maintain impartiality in all our services and makes the following Declaration of Impartiality:

Employees who evaluate products or management systems for certification purposes must not engage in consultation or technical advice for them. Accreditation standards apply strict prohibitions, e.g.; in case products are tested by bodies (clients or agents representing clients) who have been involved with design, manufacturing or sale of these products.

In order to safeguard our professional reputation, we expect our employees and external personnel to act ethically and impartially in the long-term interest of our company and society. We require personnel, internal and external, to reveal any situation known to them that may expose them or our company to conflict of interest. TUV Rheinland UK Ltd shall use this information to identify threats to impartiality raised by the activities of such personnel or by the organizations that employ them. We shall not use personnel, internal or external, or buy products / services from direct clients, until we can demonstrate that the risks or threats to impartiality (see below) are reduced to an acceptable level.

The conformity assessment body of TUV Rheinland UK is funded solely by the fees charged for TUV Rheinland services.

More information relating to impartiality policy and our terms and conditions relating to the certification of products are available upon request.

TUV Rheinland UK Ltd  
Friars Gate, 1011 Stratford Road  
Solihull, B90 4BN  
Tel: +44 (0)121 796 9400  
Email: UKCA@uk.tuv.com

[www.tuv.com](http://www.tuv.com)

 **TÜVRheinland**<sup>®</sup>  
Precisely Right.

# Annex 1 – Prerequisites for Certification process of Welding Personnel

## EXAMINATION ROOM – THEORETICAL PART OF THE EXAMINATION

1. Number of seating positions at least equal to the number of participants in the test.
2. Minimum area 40m<sup>2</sup> per 20 person/min. 2m<sup>2</sup> per person to be examined.

## WORKSHOP (WELDING SHOP) – PRACTICAL PART OF THE TEST

1. A candidate passing the practical test must be provided with a single workplace with access to the necessary control and measurement equipment and personal protective equipment. The equipment must meet the necessary requirements related to the applicable health and safety regulations.
2. Welding room should be a room with a minimum height of 3.75m and consist of separate welding stations.
3. The welding room shall consist of separate welding stations.
4. Room height min. 3.75m
5. Anti-slip floor made of non-combustible materials
6. Illumination of the stand to allow proper welding and visual inspection (min. 500 lx)
7. Temperature min. 14°C
8. Welding table with the possibility of fixing the specimen in the forced position and welding equipment to ensure safe welding process.
9. Welding gas extraction system for the reduction of pollutants harmful to health
10. Walls and ceiling and welding cabin interiors painted with matt paints
11. Walls or screens made of non-combustible, non-flammable material which suppress harmful radiation with min. 2m long ventilation gap at the floor. For gas work stations there is no need for local ventilation as well as the need to be separated by walls or screens.
12. At least 15m<sup>3</sup> of free space not occupied by devices and equipment for one person
13. Floor area 2m<sup>2</sup>
14. Large-volume or horizontal transport equipment with a mass greater than 25kg on a fixed welding station
15. Work-place must contain equipment for safe placement or suspension of the flow torch, container with water for periodical/failure cooling of the flow torch, electrode stub container.
16. Welding work-place with manual flow torches and accessories for safe placement or suspension of the torches.

17. Welding work-place for arc welding with covered electrodes equipped with electrode stub container.
18. No flammable materials are stored on the welding work-place and in the welding shop.
19. The location of equipment and workpieces makes it possible to leave the welding station quickly and safely.
20. The workstation should be provided with welding instructions (WPS/pWPS) appropriate for the welding method at that workstation.
21. Test participant shall have access to welding tools such as a grinder or dryer for storing covered electrodes.

## FACILITIES AND EQUIPMENT

1. The welding workshop shall be equipped with the necessary welding equipment, flow torches for gas welding in a technical condition to ensure that an examination is carried out in accordance with the applicable standards.
2. This equipment shall ensure that the welding parameters specified in the welding process manual (WPS/pWPS) are monitored.
3. Equipment and welding tools must be regularly inspected in accordance to the manufacturer or other entity procedure.
4. Damaged welding equipment should only be repaired by qualified personnel or qualified companies.
5. Before starting the examination, the examiner is obliged to check whether the equipment meets the requirements.
6. The manufacturer or other entity is informed about the method of supervision in the commercial offer being a part of the order (contract concluded with the manufacturer or other entity to provide the welder certification service). The entity recognized in accordance with the procedure MS-0038076 is checked for compliance with the requirements during the recognition audit.
7. The equipment and accessories are documented to fulfill health and safety requirements.
  - Parent material control document (plates, tubes)
  - Inspection document for welding consumables
  - Welding gas inspection document
  - Welding equipment inspection protocol
8. Permanent marking of the sample.
9. Gas supply station from bottles or bundles of bottles or gas pipelines.
10. In case of supply flow torch with gas from bottle, safety valve must be located at the inlet or inside the torch.



11. In case of supply flow torch with gas from bundle of bottles or gas pipeline, safety valve must be located at the every inlet.
12. Workstations for welding with covered electrodes equipped with an electrode dryer.
13. Workstations for welding with covered electrodes, MAG/MIG and TIG methods equipped with effective local ventilation.
14. Gas hoses for gases used in accordance with the purpose, type of gas and nominal pressure (gas-hose mixture suitable for the dominant gas in the mixture).
15. Consumables posing a risk to health and life – classified, labelled, safety data sheets for substances.
16. The equipment shall be inspected to the welding parameters specified in the WPS/pWPS.

#### EXAMINATION SAMPLES

1. Before starting the examination, the examiner is obliged to check that examination sample sets are prepared, secured and stored in an appropriate way. The manufacturer or other entity is informed about the method of preparation, protection and storage in the commercial offer being a part of the order (contract concluded with the manufacturer or other entity to perform the welder certification service). The entity recognised in accordance with the testing and certification condition is checked for compliance with the requirements during the recognition audit.
2. Examination samples should be stored in a secure place. Access to examination samples should be restricted to authorised persons and a certification body examiner. Examination samples must be suitable for the welding method, prepared in a way specified in the criteria document.
3. Each examination sample should have documentation. The documentation of the examination sample should specify for which method the sample can be used.
4. Separate storage space for filler metals, parent materials and consumables.
5. Welding materials stored in humidity-resistant shelves.
6. Storage instructions for consumables including, but not limited to, control of storage conditions (humidity, temperature).
7. Parent materials (plates, tubes) storage to avoid affects like damage, corrosion or soiling.
8. Basic materials (sheet metal, tube) for the examination should be confirmed by a certificate of min. 2.2 EN 10204.
9. Welding consumables shall be confirmed by the CE marking, where applicable.
10. Cutting machines (thermal and mechanical), stationary/portable grinders

#### PERSONAL PROTECTION AND AUXILIARY TOOLS.

1. Protective equipment of the participant must contain: welder's helmet, gloves, apron, etc.
2. Participant auxiliary tools such as a wire brush, a hammer to reflect trails, wire cutting pliers must be provided.
3. Examination samples shall be approved for examination purposes on the basis of visual inspection and documentation provided by the examiner.
4. In case of the sample does not meet the expected requirements, the examiner shall record appropriate remarks and observations in the form MS-0036607 test report.
5. The sample should be separated and not used in the exams anymore. The sample shall be marked with a red/white permanent marker and separated from the rest of the samples to be checked or permanently excluded from the sample collection.
6. In case the samples are prepared by the manufacturing plant or other entity, a larger number of samples must be prepared. Samples for the examination shall be selected and marked by the examiner. The examination entity should provide a sufficient number of samples for the examination process, with the assumption that if the examiner has doubts about the correctness of the sample, they must guarantee replacement of the sample.

#### TEST EQUIPMENT

1. Test equipment used during the examination process is supervised by the laboratory to which the tests are contracted. Tests are performed in laboratories on the basis of a cooperation framework agreement. The list of laboratories is included in the list of laboratories (MS-0034501).
2. Samples should be prepared in an appropriate way (bevel angle, root face) by a person authorized to do so, having qualifications in accordance with the requirements of individual standards (evaluation criteria). Samples should be labelled.

#### SOCIAL ROOMS, CLOAKROOMS AND SANITARY FACILITIES

1. Access to changing rooms and sanitary facilities should be provided.