

PROCEDURES

QUALIFICATION TESTING / GENERAL

1.0 PURPOSE

It is the purpose of this section to provide the requirements and procedures for qualifying operator and contractor personnel in the joining of various pipe materials. This section is separate from the Operator Qualification Written Plan.

1.1 SCOPE

This section covers the following:

- A. Qualification test for plastic pipe and fittings.
- B. Qualification test for SMAW and GMAW welding of pipe and fittings.

1.2 GENERAL

- A. Initial qualification of all personnel who will join plastic pipe or weld within the Operator's system should be conducted by a **Qualified Third Party**.
- B. Re-qualification of operator and contractor personnel may be conducted by qualified operator personnel who, are qualified by training and/or experience, or have been qualified by a qualified third party.
- C. Contract Inspectors who are qualified by training and/or experience may re-qualify contractor personnel.

Note: Initial testing requirements will apply to all individuals who are qualifying for the first time, or for any individual whose qualification has lapsed, (become invalid).

1.3 PLASTIC PIPE JOINERS

- A. All personnel qualified in plastic pipe joining procedures will be given an annual requalification test. (Time not to exceed 12 months)
- B. All tests shall be documented on the appropriate form and maintained in accordance with the Operator's procedures. (It is recommended that records be maintained for a minimum of five years) All test coupons shall be inspected and evaluated by a qualified individual.

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- C. Operator plastic pipe joiners who fail their pipe joining requalification test may retest within two weeks after failing the test. If the retest is failed, the pipe joiner should be barred from joining for a minimum period of six months.
- D. Contract plastic pipe joiners who fail their pipe joining requalification test may be retest within two weeks after failing the test. If the pipe joiner fails the retest, the pipe joiner shall then wait a minimum of six months before being given another pipe joining test.
- E. The pipe joiner may work in a classification, which does not have the requirement for that particular pipe joining process.
- F. Qualification after six months should be conducted by a qualified third party and should be conducted as if being an initial test.
- G. A pipe joiner shall be required to re-qualify if production work does not appear satisfactory.
- H. The supervisor shall pull the qualification card of any pipe joiner whose work does not appear satisfactory.

1.4 WELDERS

- A. Operator welders who fail their re-qualification test may be retested within two weeks after failing the test. If the retest is failed, the pipe joiner should be barred from welding for a minimum period of six months.
- B. Contract welders who fail their requalification test may be retested within two weeks after failing the test. If the retest is failed, the pipe joiner should be barred from welding for a minimum period of six months
- C. The contract welder may work in a classification, which does not have the requirement for that particular welding process.
- D. Qualification after six months should be conducted by a qualified third party and should be conducted as if being an initial test.
- E. No welder may weld with a particular welding procedure unless, within the

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preceding six calendar months, that welder has been qualified in welding that procedure.