

PROCEDURES

QUALIFICATION TESTING / WELDING

3.0 PURPOSE

This section establishes the minimum requirements for qualification in shield metal arc welding (SMAW) procedures by which personnel will be deemed qualified to weld with these electric arc processes.

3.1 SCOPE

- A. Before starting the qualification test, the welder shall be allowed a reasonable time to adjust the welding equipment for the test.
- B. The welder shall use the same welding technique and proceed with the same speed that he will use if he passes the test and is permitted to do production welding.

3.2 INITIAL TEST REQUIREMENTS

- A. Initial testing should be conducted by a **Qualified Third Party**.
- B. The qualified representative conducting the test shall visually inspect the process to ensure that the welder follows the qualified welding procedure (API 1104 will be used in the standard).
- C. Operator welders shall initially qualify for arc welding under API 1104, Standard on pipe having a diameter of 6.625" and wall thickness of .250".

3.3 REQUALIFICATION

- A. Biannual tests are required for all electric arc welders. Test shall be at intervals not to exceed six months from the last date of qualification or requalification.
- B. This may be a production weld or a sample weld.

3.4 REJECTION CRITERIA

- A. Electric arc welders taking the requalification or initial test shall have the test weld found acceptable if it meets the requirements the API 1104 standard.

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FIGURE 1

REQUALIFICATION TEST - ELECTRIC ARC WELDING
Biannual

