



Rules for the Certification of Industrial Welders and Welding Operators

Effective from 2 October 2006

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CHAPTER 1 – GENERAL

1.1

These Rules set out the procedures applied by RINA for the certification of Welders and Welding Operators in accordance with the Standards of series EN 287, EN 9606 and EN 1418, as well as the procedures to be followed by Organisations in order to apply for, obtain and maintain such certification.

1.2

Access to certification is open to all Organisations regardless of whether or not they belong to a particular Association or Group. RINA will charge fees for its certification activity in accordance with its established fee schedules in force, which are applied fairly and consistently.

1.3

The certification issued by RINA refers to the personnel indicated on the Certificate of Qualification as operating within the Organisation applying, where "Organisation" is intended to mean a public or private firm, body or association, which may or may not be legally incorporated, with its own function and administration or, alternatively, an individual. Where Organisations have several operational units, each such operational unit can be considered an Organisation.

1.4

The terms used in these Rules are the same as those in the Standards ISO/IEC 17024 and UNI CEI EN 45020.

CHAPTER 2 – REFERENCE STANDARDS

2.1

The requirements applicable for the purpose of the certification in question are the Standards of series EN 287, EN 9606 and EN 1418; RINA may, at its discretion and at the request of the Organisation making the application, carry out the same activities of qualification of personnel using other recognised standards.

CHAPTER 3 – ISSUE OF THE CERTIFICATION

3.1

Organisations wishing to obtain the above certification for their personnel are to fax, post or email a request to this effect containing at least the following information:

- a) name of the Organisation;
- b) reference standard;
- c) number of people to be qualified;
- d) welding process;
- e) base material;
- f) thickness of base material;

g) welding position;

On the basis of the information submitted, following a preliminary examination to check that there are no omissions, RINA will formulate a service proposal which will be sent together with a copy of these Rules.

3.2

Upon receipt of acceptance of the foregoing proposal, RINA will send the Organisation written confirmation of the acceptance of the request itself.

The request submitted by the Organisation and its acceptance by RINA formalise the contract for intervention by RINA in accordance with these Rules.

At its discretion, RINA may also require the submission of other documents for examination, in support of the information already submitted, where this is deemed important for the purpose of the certification concerned.

RINA will notify the Organisation of the names of the Surveyor(s) appointed to examine and qualify the Welders/Operators; the Organisation may object to such appointments provided that it submits justified reasons for this.

3.3

Subject to the satisfactory outcome of the Welder's/Operator's practical test (visual examination), the RINA Surveyor makes provision for the identification by means of permanent marking (e.g. hard stamping) of the weld samples for subsequent destructive or non-destructive tests as applicable.

Destructive testing, to be carried out with a RINA Surveyor in attendance, may be performed on the Organisation's own premises if they have the necessary test equipment or at an independent test laboratory.

In the latter case, if the independent laboratory is accredited in accordance with UNI CEI EN ISO/IEC 17025 Standard for the specific sector relevant to that product, RINA may or may not attend the destructive tests.

3.4

Upon receipt of the weld sample test results, and subject to their satisfactory outcome and acceptance by the specially appointed RINA Technical Committee, a Certificate will be issued for each Welder/Operator examined, stating that he has been approved for qualification.

In the event of unsatisfactory results, RINA will notify the Organisation and make arrangements for possible re-testing.

CHAPTER 4 – PERIOD OF VALIDITY OF THE CERTIFICATION

4.1

The Certificate is valid for two years provided that every six months it is signed by the bearer's (permanent

or temporary) employer or supervisor who certifies that the following conditions are satisfied:

- a) the Welder/Operator performs the welding operations for which he is qualified on a regular basis; interruptions exceeding six months are not permitted;
- b) the work of the Welder/Operator is generally in accordance with the welding conditions used in the performance approval test;
- c) no doubts arise concerning the ability and technical skill of the Welder/Operator.

CHAPTER 5 – EXTENSION OF THE VALIDITY

5.1

The validity of a Certificate of qualification may be extended for further two-year periods within the limits of the range of validity of the original qualification, provided that the conditions in 4.1 are satisfied and, in addition:

- a) the production of welded joints carried out by the Welder/Operator is to be of the required quality;
- b) a record of tests, for example six-monthly documentation regarding radiographic or ultrasonic examinations or fracture test reports, is to be enclosed with the Certificate of Qualification of the Welder/Operator issued by RINA.

Subject to the positive outcome of the aforementioned checks, generally performed on the Organisation's own premises, RINA will grant an extension of validity and sign the relevant Certificate of Qualification in the spaces provided.

Where an Organisation does not follow the procedure set out above for the purpose of extending the validity of the Certificate of Qualification, the Welder/Operator may be requalified following the steps laid down in Chapter 3.

CHAPTER 6 – CANCELLATION OF THE CERTIFICATION

6.1

RINA may perform activities of monitoring or inspection of qualified personnel within the scope of its institutional activities such as:

- surveys at shipyards, works and production facilities;
- certification or periodical surveys of company quality systems in accordance with the Standards of series UNI EN ISO 9000 and EN 729;
- compulsory certification or periodical surveys of products subject to EC Directives;
- industrial certification activities by third parties.

Within the scope of such activities RINA may proceed with the cancellation of certificates of qualified personnel whenever:

- it is found that the conditions in 4.1 are not satisfied;
- there is objective documented evidence showing that the qualified personnel are no longer able to work to the standard demonstrated at the time they were approved for qualification.

RINA may also proceed with the cancellation of certificates of qualified personnel if they are in arrears with their payments for RINA's services.

6.2

Notification of a cancelled Certificate will be sent to the Organisation by registered letter and will automatically result in the removal of the Welder/Operator in question from the list referred to in Chapter 7.

The Organisation concerned is to return the relevant certificate to RINA. Should such Organisation subsequently intend to request certification again, it is to submit a new application and follow the entire procedure from the beginning.

6.3

Following cancellation of its certification, the Organisation may no longer use the Certificate(s) or copies thereof.

CHAPTER 7 – LIST OF CERTIFIED PERSONNEL

7.1

RINA makes available to the public and regularly updates the list of Organisations that have obtained certification of their Welders/Operators.

This list contains:

- the official title of the Organisation;
- the number of qualified Welders/Operators;
- the type of qualification issued (welding process, position, base material and thickness);
- the date of expiry of the Certificate;
- the reference standard.

Where the Organisation is an individual who has given his consent to the use of his personal details, in lieu of the company name the list will include this person's name and address.

CHAPTER 8 – TRANSFER OF THE CERTIFICATE

8.1

RINA may transfer a Certificate bearing the name of a particular Welder/Operator to an Organisation other than that which applied for and obtained the certification of the Welder/Operator in question, provided that written authorisation to this effect is submitted to RINA by the original Organisation.

CHAPTER 9 – CLAIMS

9.1

The Organisation is to keep a record of any claims lodged involving its certified personnel.

In the course of its activities related to the extension of the validity of the certification or during other certification activities involving monitoring of operators who perform special processes (see 6.1), RINA may request evidence of such records from the Organisation.

CHAPTER 10 – CONTRACTUAL CONDITIONS

10.1

The contractual conditions are governed by the current edition of the RINA Rules "General contract conditions for System, Product and Personnel certification".