

The certification scheme of welders

Information for an applicant

1. Welder certification services are available to all persons complying with the following prerequisite criteria:

- an applicant has completed training and / or industrial practice or has already passed certification earlier;
- an applicant's health condition shall allow to perform practical and theoretical (if necessary) exams in the declared area of certification;

2. An applicant may contact ATESTEERIMISKESKUS in any convenient way (by post, email, phone, personally) to order certification.

The application shall indicate, at least:

- personal identification and contact data;
- the desired certification range; normative documents/standards compliance with which is to be certified;
- a guarantee of payment for certification works regardless of their result.

The application must be signed by the applicant and an authorized representative of the employer.

3. To order certification the following application shall be submitted:

- the application for certification: on site the form AK VO-7-0 or online the form AK VO-7-0 E.
Address: <https://industry.enefit.com/en/teenused/metallitoostus/testimine-ja-sertifitseerimine>
- guaranteed payment for certification work, regardless of its result.

4. Task, scope of certification, description:

Task is to perform permanent proved quality joints of metallic materials with butt- and/or fillet welds on plates and on pipes by manual and semi-mechanized welding of:

- Steels - all types,
- Nickel and nickel alloys,
- Copper and copper alloys,
- Aluminium and aluminium alloys,
- Titanium and titanium alloys.

The scope of certification is in accordance with the standards:

- EVS-EN ISO 9606-1:2017 - Qualification testing of welders - Fusion welding (Steels - all types);
- EVS-EN ISO 9606-2:2005 - Qualification testing of welders - Fusion welding (Aluminium and aluminium alloys);
- EVS-EN ISO 9606-3:1999 - Qualification testing of welders - Fusion welding (Copper and copper alloys);
- EVS-EN ISO 9606-4:1999 - Qualification testing of welders - Fusion welding (Nickel and nickel alloys);
- EVS-EN ISO 9606-5:2000 - Approval testing of welders - Fusion welding (Titanium and titanium alloys, zirconium and zirconium alloys).

Note:

Mandatory for use are the latest official versions of documents, including all additions and changes to them.

Description:

Certification confirms ability of a person to use welding filler materials, an electrode holder or a welding torch in order to provide qualitative permanent joint with fusion welding of metals in a production conditions.

5. Certification process and assessment

5.1 Examination process

- application review, candidate identification and confirmation of compliance with the preliminary requirements of the scheme;
- safety training, familiarization with the certification scheme, rights and obligations, WPS/pWPS;
- examination of professional / functional knowledge (or theoretical test) of the candidate is carried out in accordance with the applicant's application.

Theoretical test method:

written test with multiple answers and matrix way of evaluation.

The functional knowledge test is limited to questions related to the welding process declared in the application.

Criteria for assessing functional knowledge:

The test is recognized as completed if the number of correct answers is at least 60%. If the functional knowledge test is negative, the candidate is not allowed to take the practical exam.

With a positive result of the functional knowledge test, the candidate is allowed to the practical exam:

- distribution of examinational samples, welding equipment, consumable materials and tools;
- familiarization with working places;
- control of compliance of welding and parent materials with certificates and WPS/pWPS (in the case of using materials and WPS / pWPS provided by the employer who sent the applicant for certification);
- control of correctness of assembly of welding joints in accordance with WPS/pWPS;
- marking of examinational samples;
- monitoring and control (by the examiner) of compliance with welding parameters in accordance with WPS/pWPS;
- visual inspection of the completed welding joint and preliminary assessment.
- Note: when passing certification, at any stage, the candidate should not be intoxicated. Otherwise, the certification may be interrupted.

5.2 Testing of examinational samples

5.2.1. Delivery of the control welding joint to a testing laboratory accredited according to EVS-EN ISO/IEC 17025 for non-destructive testing and/or destructive testing.

5.2.2. Performance of necessary tests and obtaining the testing protocols

5.3 Decision on certification

5.3.1. Analysis and assessment of test results and observations during the exam

5.3.2. Making a decision on certification.

5.4 Preparation and setting of certification documents.

5.5 Delivery of a set of documents to the applicant.

6. Period of validity

6.1 Initial certification

Criteria for initial certification:

A successful theoretical test (if necessary) and examination samples welded in accordance with the requirements of the standards, which have successfully passed the necessary tests, give the right to obtain initial certification.

Certificate of a person shall take effect from the date of welding of the examinational sample with positive test results.

Period of certificate validity shall meet requirements of the standard for qualification testing:

- for welders corresponding to EVS-EN ISO 9606-1:2017 - 3 years (p. 9.3a),
- for welders corresponding to EVS-EN ISO 9606-2:2005, -3:1999, -4:1999, -5:2000 - 2 years (p.9.2 EVS-EN ISO 9606-2:2005; p.10.1 EVS-EN ISO 9606-3:1999, -4:1999, -5:2000),

The certificate valid until indicated date of validity under condition of confirmation (p. 6.2 Scheme).

6.2 Confirmation of the validity, suspending and revocation of qualification, reducing/changing the scope of certification.

The validity of the certificate shall be confirmed every 6 months. Satisfactory performance by a certified person working in the field of certification is subject to approval.

The person responsible for welding at the manufacturer performs the confirmation by way of an entry in the certificate. The entry in the certificate confirms the successful work of the certified person in the field of certification. The entry shall be a basis for the extension of the certificate for the next 6 months (p. 9.2 of EVS-EN ISO 9606-1:2017, -2:2005; p.10.1 EVS-EN ISO 9606-3:1999, -4:1999, -5:2000).

In the absence of the confirmation the certificate becomes invalid (for welders: p.9.1 of EVS-EN ISO 9606-1:2017; p.9.2 EVS-EN ISO 9606-2:2005; p.10.1 EVS-EN ISO 9606-3:1999, -4:1999, -5:2000).

The certification Body - Atesteerimiskeskus cancels the certificates issued by it in the event of the receipt of documented information from third parties about:

- number of defects due to the fault of a certified person in the manufacture of products;
- changing certificate data without authorisation of the certification Body - Atesteerimiskeskus;
- violation of the rules of handling the certificate.

The cancellation is made in the list of certified persons and on a duplicate of the certificate. The certified person is notified of the revocation of certification.

A reduction in the scope of certification is not applicable. Expansion of the scope of certification requires full certification process within the new scope of certification and obtaining a new certificate for the new certification area.

6.3 Recertification of welder qualification

Recertification is not performed. After the expiration of the certificate, the certified person can confirm his continued competence by obtaining a new certificate, having passed the certification procedures as part of the initial certification.

7. Use of certificates

The certified person is obliged to:

- refer only to the field of certification that is indicated in the certificate issued;
- do not use the certificate in a manner that is able to damage interests and reputation of Atesteerimiskeskus;
- do not make statements with regard to certification that can be regarded as erroneous, inappropriate or misleading;
- discontinue making any references to the certification if the certification is suspended or withdrawn.

Note: incorrect or misleading references to the certification, using in advertising, catalogues, publications, etc. shall be stopped by all means necessary and the appropriate measures shall be taken, such as suspension or revocation of the certificate or the certification and (where necessary) legal intervention (judicial action). *The legal owner of the certificate is the Certification Body.*

8. Appeal or complaint procedure

Complaint:

An applicant with any claims to Atesteerimiskeskus may submit a complaint. A complaint shall be worded clearly in writing. Complaints are filed in free form and shall contain, at least, the following information:

- details of the applicant filing the complaint;
- date of the complaint;
- contact person;
- reference to the certification;
- description of the complaint;
- the applicant's signature.

Note: Atesteerimiskeskus guarantees a timely response to the complaint. Notification with regard to the complaint is made within 3 business days. Information about the process of review of the complaint and the decision is provided in due time.

Appeal:

If a customer disagrees with a decision on certification, he/she has the right to submit an appeal. The appeal is filed in free form and shall contain, at least, the following information:

- details of the applicant filing the appeal;
- date of the appeal;
- contact person;
- reference to the certification;
- description of the appeal (with references to the regulatory documentation);
- the applicant's signature.

Note: Atesteerimiskeskus guarantees a timely response to the appeal. Notification with regard to the appeal is made within 3 business days. Information about the process of review of the appeal and the decision is provided in due time.

9. The obligations of the Parties in certification

Atesteerimiskeskus is obliged to:

- Perform certification with the required expertise and according to the indicated regulatory documentation.
- Be guided by the declared policy of impartiality, confidentiality and equity.
- Bear legal responsibility and guarantee impartiality and equity of works with regard to certification of any applicant.
- To guarantee the confidentiality from third parties of any information when performing certification, and of any Client information received from other sources than from the Client. The exception is the accreditation body (e.g. Estonian Accreditation Centre), which may be provided with certification documentation for review during audits.
- Avoid discrimination on any grounds.
- Provide for independence of any commercial, financial, administrative or other pressure that is able to affect the certification.
- Provide the applicant with all the required information on the certification process.
- Accept complaints and appeals of applicants, respond to them in a timely manner and inform the person who filed the complaint or appeal.

Customer shall:

- Perform requirement of the certification scheme.
- Provide all the information necessary for certification and guarantee its accuracy.
- Comply with rules on use of certificates.
- Provide certificates to its customers in full without any corrections.
- Cease using the certificate at the end of its validity period or after its revocation by Atesteerimiskeskus.
- Not use certificates in a manner that may damage reputation of Atesteerimiskeskus as well as avoid misleading statements with regard to certificates.