

These testing and certification regulations apply to the

- **Testing and certification of permanent joining personnel**
- **Testing and certification of operators and setters**

1. Scope

This scheme applies to the testing and certification of personnel but not limited to the following standards:

EN ISO 9606-1 a),b),c), EN ISO 9606-2 to 5 a),b), EN ISO 13585 a),b), EN 13067 a),b)

EN ISO 17660-1; EN ISO 14732 a),b),c); EN ISO 25239-3

these standards can be issued in conjunction with the

- a) Pressure Equipment (Safety) Regulation 2016 as amended by the (EU Exit) Regulations
- b) AD2000 leaflet HP 3
- c) EN 13445-4

2. Entry requirements:

Only applicants whose training and previous activity give reason to expect that they have sufficient specialist knowledge and skills to pass the examination may take part in the examinations. This is usually the case if the requirements of the standards and regulations applied for are met.

For identification reasons a photographic identification document must be shown prior to examination.

The employer provides appropriate workplace, facilities, joining equipment, test pieces, joining consumables free of charge. Equipment shall be verified or calibrated appropriate.

A WPS/pWPS must be provided for the applied process and scope.

3. Application procedure

The application for certification is made using form "Application" in the valid version. The form must be completed, signed, and submitted to the certification body with the necessary information.

The certification body reviews the application to confirm that the applicant meets the requirements for the certification scheme.

4. Assessment and review process

The assessment procedure is, if required by national regulations divided into a theoretical part (job knowledge test) and a practical part (examination of manual skills) and is carried out in the presence of an inspector appointed by the certification body.

a. Job knowledge test, if required by national regulations

The technical knowledge examination is a written examination (selection questions) and is limited in content to the permanent joining process used in the practical examination and accident prevention regulations. This theoretical examination consists of 20 questions, each with three possible solutions, of which only one - the correct one - must be marked on the answer sheet. If more than one answer is marked as correct, the answer will be marked as incorrect. At least 17 questions must be answered correctly to fulfil the requirements. All questions on accident prevention regulations must be answered correctly.

Examination time: max. 30 minutes

b. Practical examination

The practical examination is carried out on standardised test pieces according to the corresponding technical standards for personnel certification. In the course, an already prepared test piece is joined by the candidate in compliance with the parameters specified in the procedure specification (pPS or PS). The test pieces shall be clearly marked with the candidate's number and, if applicable, the 12 o'clock position. .

Regarding welding the following conditions must be observed:

- For fillet welds, the required fillet weld thickness of the test piece shall be specified in the pWPS or WPS used for the test
- The test pieces shall have at least one stop and restart in the root and cover layers. If more than one welding process is used, at least one stop and restart shall be made in the root and cover layers for each welding process. The stop and restart areas shall be marked.
- The welder will be permitted to remove minor irregularities by grinding, except for the cover layer(s), where only the stop and restart may be ground. The approval of the inspector or test supervisor shall be obtained for this purpose.
- Any post weld heat treatment required in the pWPS or WPS may be omitted under the responsibility of the manufacturer.

Testing time: appropriate to the specimen

After joining, the test piece is inspected by the inspection officer or inspector in accordance with the regulations.

5. Certification decision

If all certification requirements are met, certification is granted, and a certificate is issued to the certified person. The certification body remains the sole owner of the certificates.

6. Suspension, withdrawal, or limitation of the scope.

The validity of the certification starts with the date of welding of the test piece and must be confirmed every 6 months by the joining coordinator or the certification body, otherwise the certificate becomes invalid. The validity of the certificate ends with the date stated on the certificate.

If there is reasonable doubt about the ability of a certificate holder to produce permanent joints in accordance with the quality requirements of the product standard or if the certificate is misused by the applicant or client, the certificate may be suspended, withdrawn or restricted in scope with immediate effect.

7. Re-approval/certification process

After expiry of the validity, the permanent joining personnel shall be revalidated.

A new application is necessary.

8. Complaints and appeals

If there are reasons for appeals against the approval procedure or complaints against an approved person, these may be submitted in writing to the certification body for the approval of non-destructive testing personnel at TUV SUD BABT. Complaints are examined by the senior certification engineer of the

certification body and appeals are examined by senior management personnel not involved in the approval process. The complainant will be formally informed at the end of the complaint or appeal procedure.

9. Use of certificates

The certificate may be used as proof of valid approval. Claims of being approved after expiration, withdrawal, revocation, or expiry of the approval is not permitted.

10. Rights and obligations of the certificate holder

- a. The certificate holder has the right to inspect the file on which the certificate is based at TUV SUD BAPT.
- b. The certificate holder undertakes to refund the certificate if he has not permanent joined within the scope of the certificate for more than 6 months, if no non-destructive tests have been carried out for surveillance and if the six-monthly confirmations of the employer are not available.
- c. The certificate holder undertakes to return the certificate if his practical examination gives rise to justified doubts about a consistent weld quality and if the employer refuses the 6-monthly entries for renewal of the certificate for this reason.

Contact: Certification body PE(S)R

TUV SUD BAPT Unlimited
Certification body for permanent joining personnel
Octagon House
Concorde Way
Fareham
Hampshire
PO15 5R
United Kingdom
Mail to: BAPT@tuvsud.com