

AWS QC2-93

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Recommended Practice for the Training, Qualification and Certification of Welding Inspector Specialist and Welding Inspector Assistant



American Welding Society

Keywords — Welding inspector specialist, welding inspection, inspector certification

AWS QC2-93

Recommended Practice for the Training, Qualification and Certification of Welding Inspector Specialist and Welding Inspector Assistant

Supersedes AWS QC2-80

Prepared by
AWS Qualification and Certification Committee

Under the Direction of
AWS Education and Certification Council

Approved by
AWS Board of Directors

Abstract

This recommended practice defines the requirements and program for an employer (company) to certify Welding Inspector Specialists (WIS) and Assistants (WIA). The certification program is developed and controlled by an employer and is limited to its employees. The certification of (WIS) requires documentation of experience, training and satisfactory completion of an examination. The examination tests the (WIS's) knowledge of welding processes, welding procedures, welder qualification, destructive testing, nondestructive testing, terms, definitions, symbols, reports, records, safety and responsibilities.



American Welding Society

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Foreword

(This Foreword is not a part of AWS QC2-93, *Recommended Practice for the Training, Qualification and Certification of Welding Inspector Specialist and Welding Inspector Assistant*, but is included for information purposes only.)

The purpose of welding inspection is to determine that a welded product meets the requirements of a specific code, standard, specification or contract. These documents usually contain reference to a specific code, standard or specification, and detailed drawings that outline general and specific requirements for the work. The welding inspector must be thoroughly familiar with the welding processes used, welding procedures, welder qualifications, materials and limitations of weld testing; and must be able to read drawings, keep records, make reports and make responsible judgements.

For weld inspection to be effective, it must be performed in a manner that is consistent with the specification requirements and the technical and ethical principles. The employer must accept the burden of responsibility of training, testing, qualifying and certifying employees in accordance with an established written practice.

Comments and suggestions for improvement are welcome. They should be sent in writing to the Secretary, AWS Qualification and Certification Committee, American Welding Society, 550 N.W. LaJeune Road, P.O. Box 351040, Miami, FL 33135.

Official interpretations of any of the technical requirements of this standard may be obtained by sending a request, in writing, to the Director of Qualification and Certification Department, American Welding Society. A formal replay will be issued after it has been reviewed by the appropriate personnel following established procedures.

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Recommended Practice for the Training, Qualification, and Certification of Welding Inspector Specialist and Welding Inspector Assistant

1. Scope

1.1 This recommended practice establishes the minimum requirements for the employer training, qualification and certification of the *Welding Inspector Specialist* and *Welding Inspector Assistant*. The employer is responsible for the training, testing, examination and certification of the inspectors.

1.2 This recommended practice has been developed by AWS to aid employers in identifying the basic factors in training, qualifying and certifying personnel performing welding inspection for a specific company or project.

1.3 In developing the written practice (see Art. 6.0), the employer shall review the detailed recommendations presented herein and should incorporate them into the practice.

1.4 An AWS Certified Welding Inspector or Certified Associate Welding Inspector may perform the duties of the WIS or WIA, respectively, without qualification and certification under this recommended practice.

2. Levels of Qualification

There are two levels of welding inspector certification defined in this document. These are *Welding Inspector Specialist (WIS)* and *Welding Inspector Assistant (WIA)*.

2.1 Welding Inspector Specialist (WIS). A Welding Inspector Specialist is an individual who has been trained, qualified and certified by the employer as meeting the requirements of the employer's welding examination program.

2.2 Welding Inspector Assistant (WIA). Welding Inspector Assistant is an individual who has been trained, qualified and certified by the employer as meeting the requirements of the employer's program to assist the

WIS in performing the WIS's defined duties. The WIA shall perform inspection duties under the supervision of a WIS.

2.3 The WIS and WIA will not be subject to examination and certification by AWS. The WIS and WIA are not acceptable candidates for reciprocity as CWI or CAWI in accordance with AWS QC1.

3. Terms and Definitions

The terms included in this recommended practice are as defined in ANSI/AWS A3.0, *Standard Welding Terms and Definitions*, and as defined below.

Certification. A written statement or document attesting that an individual has met the standards as established for those particular functions.

Certifying Agency. The employer of the person being certified.

Certifying Official. The employee of the company is designated to certify inspectors and revoke certification.

Employer. The corporate, private or public entity which employs personnel for compensation.

Owner. The person or entity which will become the possessor or the designated engineer responsible for the construction of weldments erected or fabricated under a code, standard or specification.

Qualification. Demonstrated skill, training, knowledge and experience required for personnel to properly perform duties of a specific job.

Recommended Practice. Guidelines utilized in developing a written practice establishing uniform procedures for training, qualification and certification of WIS and WIA.

Training. The program developed to impart the knowledge and skills necessary for qualification and work performance.

Written Practice. A document prepared by the employer to specify methods, requirements, examination, records, certifying official, etc., for a company's welding inspection personnel certification program.

4. Function

In establishing a program, the employer shall state in the written practice specific functions to be carried out by the inspectors. The items in Appendix A shall be incorporated in the written practice. The company methods for accomplishing each duty shall be defined. The specific functions of the WIS and the WIA shall be defined in the written practice.

5. Education and Experience

5.1 WIS Candidate. The following are minimum requirements for each candidate who is to be considered for WIS.

5.1.1 The candidate shall be a high school graduate or hold an approved general equivalency diploma.

5.1.2 The candidate shall be employed no less than two years with the employer and have two year's experience in an occupational function that has direct relationship to weldments fabricated to a code, standard or specification and directly involved in one or more of the following:

- (1) Design. Preparation of plans and drawings for weldment construction
- (2) Production. Planning and control of welding operations such as procedures, equipment, materials or personnel involved in weldment fabrication
- (3) Construction. Performance as a welder, fitter or other function in the fabrication or erection of weldments
- (4) Inspection. Detection and measurement of weld discontinuities or verification of fabrication requirements
- (5) Repair. Repair of weldments

5.1.3 The candidate shall submit written documentation that he meets the requirements of Art. 5.1.1 and 5.1.2 or the alternatives listed in Art. 5.1.4.

5.1.4 Alternatives to Art. 5.1.1 and 5.1.2 for a combination of education and experience may be applied according to the following.

5.1.4.1 Experience. A candidate may be employed less than two years by the employer and have five

year's experience in the fabrication industry working to a code or standard. This experience shall be documented by transcripts or letters of reference.

5.1.4.2 The candidate shall have the following education and experience:

(1) Eighth grade level schooling with no less than ten year's experience in welding functions defined in Art. 5.1.2

(2) A maximum of two years of post high school education may be substituted for an equal number of years of the required five year's experience, provided the studies are directly related to and of the function defined in Art. 5.1.2

Post high school education is defined as the following:

(a) Associate or higher degree in engineering, engineering technology, physics or sciences

(b) Engineering/technical school courses¹ successfully completed in a curriculum that can be (or could have been) applied to (1) above

(c) Trade/vocational school courses¹ in a curriculum related to welding that can be (or could have been) applied to (a) above

5.2 WIA Candidate. The following are minimum requirements for each candidate for WIA:

5.2.1 The candidate shall hold a high school or an approved general equivalency diploma.

5.2.2 The candidate shall have at least six month's experience in an occupational function that has a direct relationship to weldments fabricated to a code or standard (see Art. 5.1.2).

5.2.3 Alternatives to Art. 5.2.1 and 5.2.2 for a combination of education and experience may be applied according to the following:

The candidate shall have an eighth grade level schooling with no less than five year's experience in welding functions defined in Art. 5.1.2.

6. Written Practice

6.1 The employer shall establish a written practice for the administration of personnel training, qualification, certification and job functions for welding inspectors.

¹ Courses in a curriculum means courses within a body of courses offered toward a degree, or can be applied to a degree in (1) above. Successfully completed courses of number of hours earned is necessary.

6.2 The written practice shall include topics, subjects and training related to the inspection of weldments fabricated to a code, standard or specification as applied by the employer.

6.3 The written practice shall define the company official who is authorized to certify inspectors or revoke certification. If an auditing committee is established, the company official responsible for certification shall be the chairman of the auditing committee.

7. Physical Requirements

7.1 **Performance.** Candidates must be physically able to safely perform the activities as required or specified by the employer. The functions to be performed by an inspector are defined in the employer's written practice.

7.2 **Vision Requirement.** Each inspector shall perform the following:

7.2.1 An eye examination shall be passed, with or without corrective lenses to prove (1) near vision acuity on Snellen English or equivalent, at twelve inches, and (2) far vision perception test for 20/40, or better.

7.2.2 A color perception test for red/green and blue/yellow differentiation shall be taken.

Note: It is the employer's responsibility to determine and enforce the need for any color perception requirements. However, the examination must be performed and documented on the inspector's record.

7.2.3 The eye examination shall be administered by an optometrist, medical doctor, registered nurse, certified physician's assistant or certified ASNT Level III personnel no more than seven months prior to the date of the inspector's certification or recertification.

7.2.4 The eye examination results shall be documented on a form that can be understood by non-medical personnel (see sample form, "VISUAL ACUTY RECORD" Appendix B).

8. Training

8.1 Candidates (WIS or WIA) to be considered for qualification and certification shall complete sufficient organized training to become thoroughly familiar with the principles and practices of welding inspection applicable to the practice to be used and the products to be inspected, including the inspection tools and equipment.

8.2 A recommended training course outline of subjects is provided in Appendix A.

8.3 The training program shall include sufficient examination to assure that the necessary skills have been learned and can be demonstrated.

9. Examination Requirements

9.1 **Proficiency Examination.** The employer shall examine the candidates or inspectors periodically to determine the employee's abilities in the inspection program. The examinations shall incorporate check points or proficiency demonstration to verify that the employee possesses the ability to perform specific inspection and interpret results. All examinations and results shall be a permanent part of the inspector's record.

9.2 WIS Examination

9.2.1 The employer shall structure a test consisting of three parts as defined below. Candidates shall meet the vision acuity requirement and achieve the minimum passing score for each of the three tests. Additional points on one test cannot be credited to another test to raise the score.

9.2.2 An open-book test shall be given on the requirements of a code or standard consisting of at least 32 questions and requiring a minimum passing score of 72%.

9.2.3 A test on fundamental welding principles shall be given. This test shall include welding processes, NDE methods, mechanical properties of materials and duties of the inspector. This test shall consist of at least 75 questions and require a minimum passing score of 72%.

9.2.4 A test on practical applications of welding inspection shall be given. This test shall include knowledge on topics such as weld discontinuities, welding and NDE symbols, welding procedures and inspection of actual samples for acceptance or rejection. This test will consist of 32 questions and require a minimum passing score of 72%.

9.2.5 Recommended duration of the tests are: Open book — one hour, Fundamentals — two hours, Practical — one hour.

9.3 WIA Examination

9.3.1 The employer shall structure a test consisting of two parts as defined below. Candidates shall meet the vision acuity requirement and achieve the minimum passing score for each of the two tests. Additional points on one test cannot be credited to another test to raise the score.

9.3.2 A test on fundamental welding principles shall be given. This test shall include welding processes, NDE methods, mechanical properties of materials and duties

of the inspector. This test shall consist of at least 60 questions and require a minimum passing score of 72%.

9.3.3 A test on practical applications of welding inspection shall be given. This test shall include knowledge on topics such as weld discontinuities, welding and NDE symbols, welding procedures and inspection of actual samples for acceptance or rejection. This test will consist of 25 questions and require a minimum passing score of 72%.

9.3.4 Recommended duration for the tests are: Fundamentals — one hour, Practical — one-half hour.

10. Certification

10.1 At the option of the employer, an outside agency may be engaged to provide assistance in training and qualification services. In such instances, the employer is responsible to assure that training, qualification and certification are in accordance with this document.

10.2 The employer purchasing outside training and qualification services is responsible for auditing the agency providing the services to assure that the service complies with this document. The employer shall maintain a written record of the audit(s).

10.3 Certification records shall be maintained on file by the employer and should contain records of the certified individual and copies of written practices as required by Art. 6.0. These records should be maintained during the time the inspectors are certified and for three years after the termination of the employee. These records shall contain as a minimum the following:

- (1) Name of certified individual
- (2) Experience and training of the individual
- (3) Statement indicating satisfactory completion of training in accordance with employer's written practice.
- (4) Results of examinations prescribed in Art. 7, 8 and 9.
- (5) Signature of certifying official
- (6) Date(s) of certification

11. Code of Ethics

Preamble: The company will allow the inspector to submit all the applicable inspection reports prepared as directed by the code or contract of jurisdiction.

11.1 Responsibility to the Public. The WIS and WIA are obligated to preserve the health and well-being of the public by performing their duties of weld inspection in a conscientious and impartial manner to the full extent of the inspector's qualifications.

Accordingly,

(1) The WIS and WIA shall undertake and perform assignments only when qualified by training, experience and capability. Credentials shall be shown upon request.

(2) The WIS and WIA shall be completely objective, thorough, and factual in any written report, statement of testimony of the work and include all relevant or pertinent testimony in such communication.

(3) The WIS and WIA shall sign only for work that the WIS or WIA has inspected or for work over which the WIS has personal knowledge through direct supervision.

(4) The WIS and WIA shall neither associate with nor knowingly participate in a fraudulent or dishonest venture.

11.2 Conflict of Interest

11.2.1 The WIS and WIA shall avoid conflict of interest with the employer and will disclose any business association or circumstance that might be so considered.

11.2.2 The WIS and WIA shall not accept compensation, financial or otherwise, from more than one party for services on the same project, or for services pertaining to the same project, unless the circumstances are fully disclosed and agreed to by all interested parties or their authorized agents.

11.2.3 The WIS and WIA shall not solicit or accept gratuities, directly or indirectly, from any party or parties dealing with the client or employer in connection with the WIS or WIA work.

11.2.4 The WIS and WIA shall, while serving in the capacity of an elected, retained, or employed public official, neither inspect nor approve work on projects relating to their public office.

11.3 Unauthorized Practice. Any violation of any required standard of conduct prescribed by this recommended practice if related to the WIS or WIA occupation, including any violation of the Code of Ethics contained in this recommended practice, shall constitute an unauthorized practice subject to the imposition of sanctions by the company official or auditing committee.

Caution: While the WIS and WIA have established credentials, company certification alone may not legally qualify the inspector to provide inspection service to the public. Contract documents, building code laws, and other specifications for the project may require inspections to be performed under the direction of others, such as a professional engineer or AWS Certified Welding Inspector.

12. Revocation of Certification

12.1 The company official or auditing committee has the power to suspend, refuse renewal, or revoke the WIS

or WIA certification for violation of the requirements of this document or the written practice.

12.2 The company official or auditing committee may recommend termination of a WIS or WIA who flagrantly violates the Code of Ethics.

13. Reinstatement

Reinstatement of revoked certification is allowed, provided the reason for the revocation has been rectified to the company official's or auditing committee's satisfaction. Documentation of reinstatement and the supporting reasons become a pertinent part of the WIS or WIA record.

14. Recertification

14.1 Each WIS or WIA shall be recertified at least once every three years in accordance with the following criteria as determined by the company official:

14.1.1 There shall be documented evidence of continuing satisfactory welding inspection performance to a code or standard.

14.1.2 The inspector shall pass an eye examination as specified in Art. 7.

14.2 The WIS or WIA may be reexamined at any time at the discretion of the employer and have certification extended or revoked.

14.3 Reexamination for proficiency of the WIS or WIA may be requested by the owner. The company certification official shall provide verification of proficiency.

15. Termination

All certifications are automatically terminated when an employee leaves the employer where he had been certified. Upon termination, the employee may request a document showing training and certification as a WIS or WIA.

Appendix A

Guidelines for Recommended Training Course for Welding Inspector Specialist or Welding Inspector Assistant

(This Appendix is not a part of AWS QC2-93, *Recommended Practice for the Training, Qualification and Certification of Welding Inspector Specialist and Welding Inspector Assistant*, but is included for information purposes only.)

I. Introduction

- A. Capabilities
 - 1. Judges quality
 - 2. Interprets specification — limitations and intent
 - 3. Communicate results and makes reports to supervisor
- B. Qualifications
 - 1. Physical condition
 - 2. Vision
 - 3. Knowledge of welding
 - 4. Knowledge of drawings, specifications, codes and procedures
 - 5. Knowledge of testing methods
 - 6. Experience
 - 7. Education and training
- C. Responsibilities
 - 1. General
 - 2. Specific company responsibilities

II. Welding, Cutting and Brazing Processes

- A. Processes used in fabricating the product being inspected
- B. Overview of each process
- C. Discontinuities which may be encountered with each process

III. Properties of Metals

- A. Weldability
- B. Metallurgy
- C. Chemistry

- D. Mechanical
 - 1. Tensile strength
 - 2. Soundness
 - 3. Hardness
 - 4. Toughness
- E. Testing for Mechanical Properties
- F. Metallographic Tests

IV. Fabrication

- A. Joint Preparation
- B. Joint Fit up
- C. Welding Procedure Specification
- D. Welder Qualification
- E. Other Fabrication Documents

V. Heat Treatment

- A. Preheat
- B. Postweld Heat Treatment

VI. Nondestructive Examination

- A. Visual Inspection
 - 1. Application and acceptance standards
 - 2. Tools and their use
- B. Liquid Penetrant Testing
 - 1. Procedures
 - 2. Acceptance standards
- C. Magnetic Particle Testing
 - 1. Acceptance standards
- D. Other Testing and Inspection
 - 1. 100% sampling
 - 2. Random sampling

- 3. Radiographic
- 4. Ultrasonic
- E. Specific Company Procedures

VII. Inspection Documentation

- A. Verify Dimensions
- B. Written Welding Procedures
- C. Welder Qualification Papers

- D. NDE Reports
- E. Narrative Reports

VIII. References

- A. AWS *Welding Handbook*, 7th Edition, Volumes 1 through 5
- B. AWS *Welding Handbook*, 8th Edition, Volume 1
- C. *Welding Inspection*, AWS 1980

Appendix B

Recommended Form for Visual Acuity Record

(This Appendix is not a part of AWS QC2-93, *Recommended Practice for the Training, Qualification and Certification of Welding Inspector Specialist and Welding Inspector Assistant*, but is included for information purposes only.)

- The date of the eye exam must not be more than 7 months prior to the date of the welding inspectors exam.
- DO NOT ALTER THE PRINTED TEST REQUIREMENTS. DO NOT ADD ANY MEDICAL TERMINOLOGY. CHECK ONLY ONE BOX PER TEST.

NOTE: Visual acuity records which do not comply with the above will not be accepted.

Applicant's Name _____ Certificate No. _____ Social Security No. _____

Date & City of your CWI test _____

TESTS.

	Meets without eye correction	Meets with eye correction	Does not meet
1. <u>Far Vision</u> 20/40 or better	☐	☐	☐
2. <u>Near Vision</u> Snellen English at a distance of 12 inches	☐	☐	☐
<u>Color Perception</u> Pseudoisochromatic plates	Meets	Does not meet	
3. Red/green differentiation	☐	☐	
4. Blue/yellow differentiation	☐	☐	

I certify that I, _____, administered an eye exam
Printed Name of Eye Examiner

to _____, on _____ which demonstrated
Printed Name of Applicant
Mo. Day Year

the vision capabilities indicated above. Check one of the following:

- | | | |
|---|--|---|
| ☐ Optometrist | ☐ Medical Doctor | ☐ ASNT Level III |
| ☐ Registered Nurse | ☐ Certified Physician's Assistant | |

State License # _____

Signature of Eye Examiner
Professional Address
 _____ Tel. No. (_____) _____

I certify that the above-named eye examiner works under my supervision. Check one of the following:

- | | |
|---|--|
| ☐ Optometrist | ☐ Medical Doctor |
| ☐ Registered Nurse | ☐ Certified Physician's Assistant |

Printed Name of Supervisor
Signature of Supervisor

* Only if already certified