



Contributed by
Walter J. Sperko, P.E.,
NCPWB Consultant

ASME Section IX now requires those who test welders to be qualified.

ASME Section IX 2019 Edition requires that contractor personnel who supervise the welding of procedure and performance qualification test coupons have knowledge and understanding of welding processes and Section IX. This requirement becomes mandatory on January 1, 2020 for all new qualifications.

In brief, ASME Section IX, QG-106, requires that contractors:

- Appoint those who will supervise welding or test coupons to do so.
- That those persons have sufficient knowledge of Section IX requirements and welding technology to be sure that what is recorded on the welder qualification record or a procedure qualification record is an accurate record of what was done and
- That there be some objective evidence of that person's qualifications.

NCPWB has issued the [“Policy Regarding ASME Section IX Requirements for Qualification of Contractors Who Supervise Welder Testing at UA/NCPWB Joint Test Events”](#) to address this requirement for testing that is done under the joint UA/NCPWB program. While this policy is sufficient for Joint Test Events, contractors will also have to address this requirement internally.

NCPWB recommends that contractors satisfy this requirement by adding the following to their Quality Control Manuals or to other operating procedures if they do not have a formal Quality Control program. It is not necessary to list all the options shown when a contractor has individuals qualified to one or more of the possibilities listed below. This is not a complete listing of possible qualifications.

Policy for Qualification of Those Who Will Supervise the Welding of Test Coupons

Management shall appoint in writing those individuals who will supervise the welding of procedure and performance qualifications and for the certification of such qualification records. A copy of the current edition of ASME Section IX shall be at the location where testing is being given.

Individuals who supervise the welding of procedure and performance qualifications shall have one of the following qualifications:

For procedure qualification testing:

- Attendance at the ASME-sponsored training seminar “ASME BPV Code, Section IX: Welding, Brazing & Fusing Qualifications” Course (PD190)
- Attendance at the “ASME BPV Code, Section IX: Welding & Brazing Qualifications Online Instructor-Led Course” (EL516)
- Successful completion of the Hartford Steam Boiler online program, “ASME Section IX”

- Successful completion of the NCPWB seminar, “Welding Qualification Supervisor Training Program” when preliminary PQRs are prepared by others
- Has prepared at least five (5) WPSs, supervised the welding of qualification test coupons, completed supporting PQRs without the aid of software and had them formally reviewed by an Authorized Inspector or customers
- Has prepared WPSs for at least two different welding processes under the supervision of someone meeting the above qualification requirements, supervised the welding of qualification test coupons, completed supporting PQRs without the aid of software and had them reviewed by that individual

For those who will supervise welding of performance qualification test coupons, the above or:

- Successful completion of the NCPWB seminar, “Welding Qualification Supervisor Training Program”
- An AWS SCWI/CWI where the open book test taken was ASME Section IX (provided to all CWIs as part of their test results)
- An AWS SCWI/CWI with endorsements in ASME Section VIII and Section IX or B31.1/B31.3
- An AWS SCWI/CWI with endorsements for Performance Qualification (WPQ1)
- A history of having supervised the qualification of at least six (6) welders, completed welder the qualification records without the aid of software and having them formally reviewed by an Authorized Inspector or customers
- Has qualified welders using at least two different welding processes under the supervision of someone meeting the above qualification requirements, has completed the welder qualification records without the aid of software and has completed the *Record of Supervision of a Welder Qualification Test*.

A Near-Vision Acuity examination shall be administered annually to each supervisor who supervises welder or welding operator performance qualification. The examination shall ensure natural or corrected near-distance acuity in at least one eye such that the supervisor is capable of reading a minimum of Jaeger Number 1 or equivalent type and size letter at the distance designated on the chart but not less than 12 in. (30.5 cm) on a standard Jaeger test chart or an equivalent Ortho-Rater or similar test pattern.

The following forms document our personnel’s knowledge and ability to supervise test events in accordance with the ASME Section IX requirements.

On Company Letterhead

Personnel Authorized to Supervise Welding of Test Coupons and to Certify Qualification Records

The following individuals are assigned responsibility by (Company Name) for supervising the welding of test coupons for the qualification of welding procedure and of welders and welding operators. They are also authorized to certify qualification records in behalf of the company.

The following individuals qualified to supervise the welding of procedure qualification test coupons:

Name and title:

- 1) _____
- 2) _____
- 3) _____
- 4) _____

The following individuals qualified to supervise the welding of welder and welding operator qualification test coupons:

Name and title:

- 1) _____
- 2) _____
- 3) _____
- 4) _____

By: _____ Date: _____

Title: _____

On Company Letterhead

Record of Qualification to Supervise the Welding of Welder and Welding Operator Qualification Test Coupons

This is to certify that _____ has completed the training or activity marked below and has the experience marked below meeting the requirements of the company to supervise the welding of test coupons by welders and welding operators.

- Meets the requirements of the company to supervise the welding of procedure qualification test coupons.
- Successful completion of the NCPWB seminar, "Welding Qualification Supervisor Training Program."
- An AWS SCWI/CWI where the open book test taken was ASME Section IX (provided to all CWIs as part of their test results).
- An AWS SCWI/CWI with endorsements in ASME Section VIII and Section IX or B31.1/B31.3.
- An AWS SCWI/CWI with endorsements for Performance Qualification (WPQ-1).
- A history of having supervised the qualification of at least 6 welders, completed welder the qualification records without the aid of software and had them formally reviewed by an Authorized Inspector or customers.
- Have qualified welders using at least two different welding processes under the supervision of someone meeting the above qualification requirements, have completed welder the qualification records without the aid of software have completed the *Record of Supervision of a Welder Qualification Test*.

By: _____ Date: _____

Title: _____

On Company Letterhead

Record of Qualification to Supervise Welding of Procedure Qualification Test Coupons

This is to certify that _____ has completed the training or activity marked below meeting the requirements of the company to supervise the welding of procedure qualification test coupons.

- Attendance at the ASME-sponsored training seminar "ASME BPV Code, Section IX: Welding, Brazing & Fusing Qualifications." (PD190)
- Attendance at the "ASME BPV Code, Section IX: Welding & Brazing Qualifications Online Instructor-Led Course." (EL516)
- Successful completion of the Hartford Steam Boiler online program, "ASME Section IX."
- Successful completion of the NCPWB seminar, "Welding Qualification Supervisor Training Program" when preliminary PQRs are prepared by others.
- Has prepared at least five (5) WPSs, supervised the welding of qualification test coupons, completed supporting PQRs without the aid of software and had them formally reviewed by an Authorized Inspector or customers.
- Has prepared WPSs for at least two different welding processes under the supervision of someone meeting the above qualification requirements, supervised the welding of qualification test coupons, completed supporting PQRs without the aid of software and had them reviewed by that individual.

By: _____ Date: _____

Title: _____

On Company Letterhead
(or from an optometrist or similar)

Near-Vision Acuity Examination

This is to certify that _____ has

- Natural
- Corrected

near-distance acuity in at least one eye and is capable of reading a minimum of Jaeger Number 1 or equivalent type and size letter at the distance designated on the chart but not less than 12 in. (30.5 cm) on a standard Jaeger test chart or an equivalent Ortho-Rater or similar test pattern.

By: _____ Date: _____

Title: _____

Record of Supervision of a Welder Qualification Test

Date of this test event: _____
Name of Welder: _____
Method of Identification (Driver's license, passport, state ID, etc): _____
Identification of WPS followed: _____
Test Coupon Material Specification and Grade: _____
Outside Diameter, NPS or "Plate" : _____ Thickness: _____
Position of the test assembly: _____
Top of assembly Stamped with a "T" (yes/no/N/A): _____
Welder/Brazer's identification stamped on the assembly (yes/no): _____
Welder has the appropriate personal protective equipment (yes/no): _____
There is adequate ventilation where the welder will be working (yes/no): _____
Welding Process(es) and type: _____
Electrode and/or filler metal classification and trade name: _____
Welded from one side or from both sides: _____
Backing (used or none): _____
Consumable insert (none or type and size): _____
Progression used for the root pass: _____ For the fill pass(es): _____
Root Current type and polarity: _____ Amps or wire feed speed: _____ Volts: _____
Fill Current type and polarity: _____ Amps or wire feed speed: _____ Volts: _____
Cover Current type and polarity: _____ Amps or wire feed speed: _____ Volts: _____
Approximate weld deposit thickness (in.) for the first process or electrode type: _____
Approximate weld deposit thickness (in.) for the second process or electrode type: _____
Shielding gas composition: _____ Flow rate (CFH): _____
Backing gas used (yes/no): _____
Test coupon was moved from its fixed position during the test (yes/no): _____
If weld was made from one side, the root surface exhibited evidence of grinding (yes/no): _____
The weld surfaces are free of cracks, incomplete fusion, incomplete penetration, (yes/no): _____
Greatest reinforcement height (in.) on the face side: _____ On the root side: _____

I certify that I prepared this while the above-named welder was welding his test coupon. A copy of the welder qualification record signed by me is attached.

By: _____ Typed or printed name: _____

Date: _____