



TITLE	TECHNICAL REGULATION FOR THE QUALIFICATION OF WELDING AND BRAZING PROCEDURES AND STAFF
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**NOTE: in case of discrepancies, the Italian version of this document prevails**

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**SUMMARY**

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## 1. FORWARD

Please refer to the general contractual conditions SGQ-D-08-01 available on the website [www.areassrl.it](http://www.areassrl.it) with regard to:

- purpose and field of application;
- terms and definitions;
- general conditions;
- certification contract;
- duration of the contract - withdrawal;
- impartiality and conflict of interest;
- subject of the verification and reference standard;
- right to use external resources;
- rights and obligations of AREAS Certificazioni Srl;
- rights and obligations of the organization;
- access to information;
- obligation to provide information on legal proceedings;
- inspection and safety in the workplace;
- economic conditions;
- additional checks;
- suspension of the system, product and personnel certificate;
- revocation of the system, product and personnel certificate;
- limits of certification and responsibility;
- limitations of liability and charges;
- forfeiture clause;
- indemnity and indemnity;
- cause of force majeure;
- renunciation, suspension, revocation of accreditation (where applicable);
- professional secrecy, confidentiality and privacy;
- privacy disclaimer;
- complaints, appeals and arbitration;
- exclusive forum;
- confidentiality and protection of intellectual and industrial property;
- change management;
- transfer of the certificate;
- certificate register;
- administrative liability of legal persons .

All the documentation necessary for certification must be submitted to AREAS Certificazioni Srl in Italian or English.

## 2. PURPOSE AND FIELD OF APPLICATION

This regulation defines the rules and methods to obtain the certification service implemented by AREAS Certificazioni Srl (hereafter AREAS) in the following areas:

- personnel assigned to carry out permanent joints in the field of welding and brazing;
- welding and brazing procedures.

within the following fields of application:

- as required by res 3.1.2 of Annex I of the Community Directive 2014/68 / EU PED (as implemented by Legislative Decree 15/02/2016 n. 26). This activity is carried out as a Notified Body for the Pressure Equipment Directive;
- voluntarily for other types of welded constructions, as a certification body for personnel and qualification of welding and brazing processes.

For inspection activities AREAS operates as a Type A Inspection Body.

The regulations specify the rights and duties of the organization and AREAS as part of the certification process according to the regulations in force, without prejudice to the provisions of the general contractual conditions referred to in chapter 1.

For all activities specified in this regulation, AREAS applies the provisions of the mandatory legislation issued by the competent authorities.

Any changes to the regulation itself will be communicated by e-mail upon publication of the same on the website.

These changes are considered accepted unless explicitly communicated by the customer.

### 2.1. Reference documents

In general, the referenced documents are applicable in the latest valid edition and / or revision.

- Directive 2014/68 / EU of the European Parliament and of the Council of 15 May 2014 on the harmonization of the laws of the Member States relating to the making available on the market of pressure equipment (recast);
- Legislative Decree 15/02/2016 n. 26, containing "Implementation of Directive 2014/68 / EU on pressure equipment";
- Guidelines issued by the Working Group "Pressure" (WGP) of the European Community for the PED Directive, and the Shared Opinions issued by the forum of Italian Notified Bodies.

The referenced and / or harmonized standards pursuant to the PED Directive will be applied as published in the Official Gazette.

- UNI CEI EN ISO / IEC 17024 Conformity assessment - General requirements for bodies that perform certification of persons
- UNI CEI EN ISO / IEC 17065 Requirements for Bodies that certify products, processes and services.
- UNI CEI EN ISO / IEC 17067 Fundamental Elements of Product Certification and Guidelines for Product Certification Schemes.
- UNI CEI EN ISO / IEC 17020 General criteria for the functioning of the various types of bodies that carry out inspection activities
- UNI CEI EN ISO / IEC 17021-1 Conformity assessment - Requirements for bodies providing audits and certification of management systems

- UNI CEI EN ISO / IEC 17025 General requirements for the competence of testing and calibration laboratories
- RG01 Regulations for the accreditation of Certification and Inspection Bodies - General Part
- RG01-02 Regulations for the accreditation of Personnel Certification Bodies
- RG01-04 Regulations for the accreditation of Inspection Bodies
- Other applicable EA / IAF documents

## 2.2. Terms and definitions

For the purposes of this regulation, all the definitions contained in the reference regulations apply in addition to the following ones.

**Welding/brazing procedure specification (WPS, BPS):** document that details the variables needed for a specific application, in order to ensure repeatability.

**Welding/brazing procedure:** Prescribed program of activities for carrying out a weld/brazing, including information on materials, preparation, preheating (if necessary), method and control, any heat treatment, as well as on the equipment to be used.

**Unified welding procedure:** welding procedure verified and certified by an examiner or examining body, which can therefore be made available to any manufacturer.

**Welding processes:** welding processes for which nomenclature and definitions refer to the ISO 857-1 standard and for the numerical coding to the EN ISO 4063 standard.

**Work instructions:** simplified specification, written or verbal, of the welding procedure, suitable for direct use in the workshop.

**Welding/brazing procedure qualification report (WPQR, BPAR):** report including all parameters relating to the welding/brazing of a test piece, required for the qualification of a specific welding/brazing procedure, as well as all the results of the checks and tests performed on the test.

**Welding/brazing procedure test:** execution, checks and tests of a welded joint, representative of a joint to be made in production, to verify the feasibility of a welding/brazing procedure.

**Pre-production welding test:** welding test having the same function as the welding procedure test, but based on a non-unified test pattern, simulating the production conditions.

**Qualification:** set of activities necessary to assess the suitability of a welding/brazing procedure and of the welder/brazer/operator (execution of the beads and tests), on the basis of the reference standards/specifications.

**Welder/brazer:** person in charge of manual or semiautomatic welding.

**Welding/brazing operator:** person in charge of automatic welding/brazing process or fully mechanized welding processes.

**Automatic welding/brazing:** welding/brazing in which all operations are carried out automatically. Adjustment of the welding/brazing parameters is not allowed during welding/brazing.

**Fully mechanized welding:** welding in which all the main operations (with the exception of positioning the piece to be welded) are carried out automatically. During welding, adjustment of the welding parameters is allowed.

**Candidate:** person who aspires to qualification or certification.

**Employer:** the organization responsible for the welding / brazing activities for which the candidate works on a regular basis; an employer can also be a candidate at the same time.

**Manufacturer:** workshop or site (or both) which is (are) under the same technical and quality management.

**Customer:** company or natural person requesting the qualification and responsible for welding production.

**Inspector:** AREAS qualified welding inspector.

**WPS:** Welding Procedure Specification

**WPQR:** Welding Procedure Qualification Record

**BPS:** Brazing Procedure Specification

**BPAP:** Brazing Procedure Approval Record

### 3. CERTIFICATION PROCESS

#### 3.1. Generality

Organizations or candidates wishing to obtain the qualification must send by post or e-mail a specific request containing the information necessary for the formulation of the service proposal.

AREAS welcomes applications without discrimination, prejudice or favourable conditions, deriving from belonging to particular associations and / or categories.

AREAS carries out a preliminary examination to verify whether the information provided is sufficient to formulate a service proposal, reserving, if necessary, with reference also to what is reported in this regulation, the possibility of requesting further details.

On the basis of these indications, AREAS formulates a service proposal which will be sent with reference to this regulation and to the application for certification, which constitutes to all effects a contractual document.

It is also possible that the request and the consequent offer will be handled independently by an examination centre qualified by AREAS; in this case, the exam centre will collect all the necessary information and documentation.

Upon receipt of the duly completed certification application for acceptance of the issued service proposal, AREAS will have 10 working days to produce comments on said requests or reject them; after this deadline has passed, the request must be considered automatically accepted and therefore the interventions of AREAS carried out according to these regulations must be considered contractually formalized.

In the case of PED qualifications, the organization declares that it has not submitted a similar application for certification to another Notified Body.

AREAS (or the examination centre) will notify the organization of the names of the inspectors who will carry out the assessments. The organization has the right to request the replacement of the inspector, within 5 days, by giving reasoned written communication to AREAS, which reserves the right to evaluate the reasons for the objection and the possibility of replacing the persons in charge.

The organization undertakes to allow the access of observers designated by the Accreditation Body or by the competent Ministry for notification, in carrying out its duties of control and monitoring of the activities carried out by AREAS as a Certification Body / Notified Body.

The presence of these observers will always be accompanied by AREAS personnel. Also, in relation to the timing of the communication to AREAS by the Accreditation Body, the notification of the presence of such observers could take place with minimum notice (less than 3 days), without this being a reason for non-acceptance by the customer of their presence.

AREAS technicians, and possibly ACCREDIA personnel, must be guaranteed free access to the production sites, personnel and documentation and the necessary assistance by the responsible personnel in charge of the verification.

With regard to the qualifications of the personnel, upon successful completion of all the examinations and tests required by the certification procedures and by this regulation, applicable on the basis of the chosen module, and specified in the service proposal sent to the organization and accepted by it, the technical secretariat sends the complete file with all the documentation to one or more competent and independent technicians (deliberation committee) for the complete review of the same and the decision to be taken regarding the granting of the certification.

Following the positive outcome of the decision of the deliberation committee, AREAS will issue the required certificate.

With regard to the qualifications of the proceedings, upon successful completion of all the examinations and tests required by the certification procedures and by this regulation, applicable on the basis of the chosen module, and specified in the service proposal sent to the organization and accepted by it, the technical secretariat sends the complete file of all the documentation to the Scheme Manager (or his substitute) for the complete review of the same and the decision on the granting of the certification, in accordance with EN 17020.

Following the positive outcome of the RS decision, AREAS will issue the required certificate.

In the event of a negative outcome, an appeal procedure is envisaged and a new application for certification can be presented by the Organization, which will be accepted without prejudice and with impartiality.

### 3.2. Communication obligation

AREAS has the obligation to inform the Notification Authority:

- of any refusal, limitation, suspension or withdrawal of a certificate (only in the notified area);
- of any requests for information, they have received from market surveillance authorities;
- upon request, of personnel assessment activities carried out as part of their notification and of any other activities, including cross-border and subcontracting activities.

Furthermore, it is obliged to provide access to the list of qualified personnel and to upload the certifications issued on the site [www.areassrl.it](http://www.areassrl.it).

AREAS has an obligation to provide other notified bodies with relevant information on issues concerning negative and, upon request, positive assessments.

### 3.3. Validity and renewal

The following table summarizes the main conditions for maintaining the validity of the welder / brazing certification following the first certification. Evidence and records are possibly necessary for any request for an extension at the end of the validity period.

Norm	Validity	Conditions for maintaining validity
ISO 9606-1	The validity depends on the method of extension (ISO 9606-1 § 9.3 revalidation) chosen at the time of qualification.	Certificate of qualification to be confirmed every 6 months by signature by the employer or the welding coordinator. In the absence of such confirmation, the qualification certificate is no longer valid.



Norm	Validity	Conditions for maintaining validity
		It should be noted that the renewal method provided for in letter c of § 9.3 of the standard is not payable by AREAS as per Scenario 1 of the technical circular of Accredia DC N ° 21/2021.
ISO 9606-2	2 years	Qualification certificate to be confirmed every 6 months, by signature, by the employer or welding coordinator, attesting that the welder worked within the initial qualification range. In the absence of such confirmation, the qualification certificate is no longer valid.
ISO 9606-3 ISO 9606-4 ISO 9606-5	2 years	Qualification certificates to be confirmed every 6 months, by signature, by the employer or the welding coordinator, who certifies that: a) the welder has regularly carried out the welding work for which he is qualified (interruptions for a period longer than six months are not allowed); b) there were no particular reasons to question the welder's skill and technical knowledge. If any of the above conditions are not met, the certification is not valid.
ISO 13585	5 years	Qualification certificate to be confirmed every 6 months, by signature, the person responsible for brazing activities or examiner/examining body, who certifies that the brazer or brazer operator has worked within the range of qualification and extends the validity of the qualification for a further six-month period. The manufacturer must check and document that the following conditions are met throughout the entire period of validity: : a) the brazier has regularly carried out the brazing work for which he is qualified (interruptions for a period longer than six months are not allowed); b) the brazing work was generally in accordance with the brazing conditions used in the certification test; c) there were no particular reasons to question the brazier's skill and technical knowledge. If any of the above conditions are not met, the certification is no longer valid.
ISO 14732	The validity depends on the method of extension (ISO 14732 § 5.3 revalidation) chosen at the time of qualification.	Qualification certificate to be confirmed every 6 months, by signature, by the employer or the welding coordinator, which certifies that the welding operator has worked within the initial qualification range; this confirmation extends the validity of the qualification for a further period of 6 months. In the absence of such confirmation, the qualification certificate is no longer valid. It should be noted that the renewal method provided for in letter c of § 5.3 of the standard cannot be provided by AREAS as per Scenario 1 of the technical circular of Accredia DC N ° 21/2021.
ASME code AWS code	The validity is unlimited	The validity of the qualification is unlimited, as long as there have been no welding work interruptions of more than six months, nor are there any particular reasons to question the skill of the welding operator / welder / brazing operator / brazing operator. If these conditions are not met, the certification is no longer valid.

In the event of changes to the certification standards, AREAS will be responsible for assessing that the qualifications currently valid still comply with the requirements of the new standards.



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### **3.4. Extension of the validity of certifications / qualifications**

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In the cases and in the manner defined by the individual reference standards, AREAS may extend the validity of the qualifications for the period provided for in the various cases by the reference standards (see table above).

The applicant must submit the request for extension of the validity of the qualification by the expiry date of the qualification certificate, with an advance that allows the examiner to intervene by the expiry date.

Those for whom the certification is about to expire will be notified by AREAS three months before the certification. The new effective date of the certification will be that of the resolution in which the renewal was granted.

Following the execution and positive outcome of the checks required by the applicable regulations, AREAS grants the extension of validity of the qualification certificate for the further years of validity as established by the regulations.

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### **3.5. Suspension and withdrawal of qualification**

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The provisions of the general contractual conditions apply and also, specifically, the following provisions regarding the certifications subject to this regulation.

AREAS can proceed with the suspension for:

- failure to comply with the statutory and regulatory requirements relating to the qualification;
- incorrect supervision of the work of the welder / welding / brazing operator by the employer;
- shortcomings in the technical specifications relating to welding / brazing, in the personnel and in the equipment detected or of which he became aware during the period of validity of the qualification;
- incorrect use of the qualification and the related qualification certificate; failure to comply with the requirements of this regulation and the documents mentioned therein.

AREAS can proceed with the revocation for:

- particular gravity of the conditions envisaged for the suspension;
- counterfeiting of certificates of qualification;
- use of suspended qualification certificates;
- repeated cases of suspension or the persistence of the conditions that led to the suspension of the qualification;
- persistence of the condition of arrears for more than one month from receipt of the notice sent;
- cessation by the welder / welding / brazing operator of carrying out the permanent joints object of the qualification, beyond the period provided for the conditions of validity.

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### **3.6. Advertising - Use for the purpose of CE marking**

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The organization or the person can make known in the ways deemed most appropriate the obtaining of the certification by AREAS. The organization or person must in any case clearly indicate any limitations and conditions imposed by AREAS at the time of issuing the aforementioned certification.

The organization or person can reproduce the certificate in its entirety, enlarging or reducing it, as long as it remains legible and is not altered in any way.

In case of use of the certificate that does not comply with what is indicated in the previous points or in case of their illicit use, AREAS will take the appropriate measures against the organization or the person, including recourse to appropriate legal actions.

### **3.7. Storage of samples and documentation**

AREAS ensures the correct management of the samples during the checks. The storage at AREAS or at the manufacturer of the samples already subjected to the checks is not required.

Copies of the certificates and the significant files of the technical documentation listed in the certificates are kept by AREAS for the time required by current legislation. At the end of this period, the paper documentation is digitized and stored together with the relevant documentation already in digital format.

Upon expiry of the certificate, all the candidate's personal documents (identity card, photo and visual acuity) will be destroyed by AREAS.

### **3.8. Use of trademarks and logos**

AREAS does not provide for the granting of the use of its certification mark for conformity assessment activities carried out within the notified area (SGQ-R-01-01 Rev. 1\_ Regulations for the use of the AREAS Certifications mark).

For any use of the ACCREDIA mark, refer to the RG09 regulation at the latest revision available on the website [www.accredia.it](http://www.accredia.it).

### **3.9. Subcontracting**

AREAS has qualified examination centres in the area which are autonomous in procuring customers and in their economic management. The examination centres are also autonomous in the management of inspections and in the collection of the documentation that will be subsequently sent to AREAS.

AREAS is always responsible for approving and issuing certificates.

## **4. CONFORMITY ASSESSMENT PROCEDURES**

### **4.1. Application for certification**

After the first contact with the customer, all the information necessary to start the certification process is requested.

Having obtained the information, AREAS prepares, on the basis of the tariff rate table, an economic offer for the test and certification activities and sends it to the interested customer together with the forms necessary for submitting the application.

The information is required in order to understand the type of qualifications, the applicability of the requirements of the standards and also ensure the availability and assignment of competent personnel to carry out the verifications.

As regards the qualification of the voluntary welding procedures and / or the approval of the operating procedures on permanent joints on pressure equipment pursuant to 2014/68 / EU - PED, annex I, res 3.1.2, the request must possibly contain the following information:

- name of the applicant organization;

- indication of the location (workshop or construction site) in which the qualification will be carried out;
- reference standard for certification;
- welding process (e.g. with reference to ISO 4063);
- type (s) of joint (s), WPS / BPS involved;
- type of material: indicate the steel group or other identification (e.g. with reference to CEN ISO / TR 15608);
- thickness: indicate the minimum and maximum values used in production;
- diameter: indicate (if applicable), the minimum and maximum values used in production;
- welding position (s).

With regard to the certification of welding personnel on a voluntary basis and / or the approval of personnel performing permanent joints on pressure equipment pursuant to 2014/68 / EU - PED, annex I, res 3.1.2, the request must possibly contain the following information:

- name of the applicant organization;
- indication of the location (workshop, construction site or other location) in which the qualification will be carried out;
- number of welders to be qualified for each welding specification;
- reference standard for certification (e.g. with reference to EN ISO 9606-1: 2017);
- welding process (e.g. with reference to ISO 4063);
- type (s) of joint (s), WPS / BPS involved;
- type of material: indicate the steel group or other identification (e.g. with reference to CEN ISO / TR 15608);
- thickness: indicate the minimum and maximum values used in production;
- diameter: indicate (if applicable), the minimum and maximum values used in production;
- welding position (s).

Upon acceptance of the offer by the Customer and receipt of the completed application, an order number is assigned and the application is reviewed.

In case of examination centres, they are responsible for collecting the certification applications which will subsequently be sent to AREAS together with the rest of the documentation.

## **4.2. Review of the application**

Product or person certification will be issued following the certification schemes identified by the scheme manager on the basis of the information and requests provided by the manufacturer. The scheme manager establishes the feasibility of the project on the basis of the authorizations obtained and the personnel and qualified resources available to AREAS. If these conditions are not met, AREAS rejects the application received.

## **4.3. Planning and execution of audits**

The planned inspection activities are carried out by AREAS inspectors, based on the requirements of the applicable assessment procedures described in detail later in this regulation.

Upon successful completion of all the examinations and tests provided and specified in the service proposal sent to the organization and accepted by it, the technical secretariat sends the file, complete with all the documentation, to one or more competent and independent AREAS technicians (committee of deliberation), for the deliberation and the revision.

Following the successful outcome of this verification and the approval of the related certification proposal, AREAS will issue the required certificate and send it to the organization.

In the event of a negative outcome, AREAS communicates this outcome to the organization and agrees with it the methods for any re-evaluation.

In the case of examination centres, it will be the responsibility of the latter to send a communication to the customer with indicated both the date / period of the inspection and the name of the inspector; the examination centre will be responsible for sending this document to AREAS together with the rest of the evidence.

#### **4.4. Instrumentation used**

The tools necessary for carrying out the tests may be made available by the requesting organizations.

These instruments must be suitable for the required tests, must have an accredited calibration certificate, and must be managed in compliance with the ISO / IEC 17025 standard.

All instruments used must be accompanied by the relevant LAT calibration certificate or certificate issued by an ISO / IEC 17025 accredited laboratory as a calibration laboratory.

Instruments that have an internal calibration card must be accompanied by this card and LAT certificates or certificates issued by an ISO / IEC 17025 accredited laboratory as a calibration laboratory, of the primary samples used in internal calibration.

AREAS inspectors verify the identification of the instruments and the related calibration certificates with metrological traceability, as well as the management procedures of the instrumentation and the methods of conservation of the same.

In the event that the necessary tools for carrying out the tests are not made available or the adequacy and calibration of these instruments is not guaranteed, these tests are not considered valid for certification purposes.

In the case of examination centres, it will be the responsibility of the latter to equip themselves with the tools necessary for the execution inspections, AREAS will check the presence and calibration of these instruments.

#### **4.5. Requirements for testing laboratories and related reports**

Applicants can submit to AREAS test reports in their possession, if issued by laboratories accredited according to ISO / IEC 17025 for the standards / tests relevant to the ongoing certification process.

In addition, test reports from laboratories that have been qualified by AREAS for the standards / tests relevant to the ongoing certification process are accepted.

If the test reports relating to the tests carried out on the representative sample of the product, presented by the applicant to AREAS, should report a date of execution of the same, prior to that of presentation of the certification application, they will not be accepted. In the event that the date of the tests is prior to the date requested for renewal of the certificate, however, the body reserves the right to accept them only after verifying that:

- no changes have been made to the reference standards for these tests;

- the manufacturer can demonstrate that no changes have occurred to the materials, the production process, or other changes to the product subject to certification, compared to the sample subject of the test reports presented.

AREAS reserves the right to use ISO / IEC 17025 accredited laboratories or laboratories qualified by the Body for the execution of the required tests on the products.

In the case of examination centres, it is possible for them to carry out the tests either directly at the inspection centre or at the centre of the centre. In the second case, it will be the responsibility of the examination centre to keep the equipment in a state of efficiency and calibration, AREAS will periodically verify that any tests carried out at the centre comply with the requirements.

#### **4.6. Execution of the tests and verifications in progress**

The qualification activity can be carried out, in accordance with the applicable regulations, at the customer's workshop, at a construction site or at centres / structures that are adequately equipped, from a technical and safety point of view. Before proceeding with the tests, the inspector checks the suitability of the environmental conditions and the correct functioning of the welding machines to be used.

The test tests must be carried out under the monitoring and control of the AREAS inspector, who must have the possibility to:

- verify the compliance of the welding procedure specifications in the different construction conditions proposed for the qualification;
- verify the conformity of the certificates of base materials and filler materials;
- verify the identity of the welders / operators and request a copy of the identity documents;
- identify the test samples after welding;
- check if the welder / operator is able to correctly apply the requirements of the reference specification;
- check, during the welding process, that the welders / operators are able to correctly apply the instructions given in the welding specifications; in case of their incapacity, the inspector can interrupt the tests informing the customer;
- judge the quality in progress through visual examination;
- judge the final quality through visual examination.

During the execution of the welded tests, the inspector checks whether the prescribed welding conditions do not produce visible systematic defects and unacceptable defects.

The inspector has the right to interrupt the execution of the tests if he finds the occurrence of opposite situations (welders / operators not able to correctly apply the prescriptions of the reference specification, inadequate preparations, unacceptable manufacturing faults or defects, etc.).

During the tests for the certification of the personnel, or the tests for the qualification of the procedure that provide for the certification of the personnel involved, the inspector assesses the executive ability of the welder during the welding process.

The welder is allowed to eliminate minor defects by chiselling, gouging, grinding during the deposition of the passes, except for the finishing layer.

If the inspector detects already during the execution of the test a lack of executive skills (too many repairs, inadequate quality, etc.), he will interrupt the execution of the welder's test and the same will not be subjected to the other subsequent examinations.

Furthermore, the inspector may, in his opinion, interview the welder in order to verify the level of technological knowledge limited to the reference process.

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#### **4.6.1. Any additional essays**

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In the event that an essay, for non-fundamental reasons, is unacceptable to the visual examination, the inspector in charge has the right to request the repetition of the execution of the same in the same conditions and regulations of reference.

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#### **4.7. Tests and examinations on the essays**

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At the end of the tests, the inspector identifies, in accordance with the applicable standard, the essays produced during the tests, the personnel who made them and collects all the required documentation to be sent to AREAS for the completion of the qualification process.

AREAS carries out the non-destructive and destructive tests required by the applicable standards. The exams are usually carried out in qualified laboratories.

AREAS has qualified and signed an agreement with some laboratories. If the customer entrusts, with the acceptance of the offer, the execution of the laboratory tests to AREAS, AREAS chooses the laboratory based, first of all, on the purpose of its accreditation or qualification in accordance with internal procedures, also account of other geographical and economic considerations.

The checks can also be carried out in a laboratory qualified by the customer or internal to the same; the chosen structure must operate in compliance with the technical requirements envisaged for the applicable tests, using competent and qualified personnel and suitable equipment, suitably calibrated. In this case, these checks must be carried out in the presence of the AREAS inspector.

Should the outcome of the tests and examinations find situations of non-compliance with the applicable requirements and prevent the qualification from being issued, AREAS will notify the customer in writing, highlighting the non-conformities found.

Non-destructive tests (CND exams) can be conducted directly by the AREAS inspector (or the examination centre) only if he has at least a 2nd level qualification in the CND method applied for the exam; in this case the reports will be drawn up and signed directly by the inspector or other staff of the examination centre.

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#### **4.8. Repetition of the test essays**

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In the event that the test does not meet any of the requirements of non-destructive tests and destructive tests, with the exception of what has already been described in the paragraph "Possible additional test", AREAS may request, depending on the conditions, the collection of further samples from the assays, the repetition of some tests (in accordance with the provisions of the relevant standards), or the execution to the customer of a further test, which must be welded and subjected to visual inspection and to the same checks.

With regard to personnel qualification activities, evidence of training / training activities may possibly be required before re-execution of the tests.

In the event of a further negative outcome of the tests, reference will be made to the applicable regulations.

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### **5. ISSUE OF CERTIFICATION / QUALIFICATION**

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Following the positive outcome of the tests and examinations, AREAS issues a qualification certificate for the welding / brazing procedures.

The released WPQR / BPAR documentation reports at least:

- identification of the applicant (company);

- the WPS / BPS that were used for the qualification and the conditions for carrying out the tests;
- the field of validity of the qualification;
- test reports (attachments);
- a copy of the certificates of the basic materials and consumables (attachments);
- information on tests, including any tests with negative results and related test reports.

Welding process qualifications normally have unlimited validity, except for any specifications defined by applicable standards. Following the issue of new regulations or their revision, the certification may need to be supplemented or reissued.

If the customer has changed his name / company name (keeping the same VAT number) and his registered and / or operational headquarters, he must notify AREAS for the reissue of the documents.

The costs for any verification and updating actions are charged to the customer.

Following the positive outcome of the tests and examinations, AREAS issues a certificate of qualification in the name of the applicant.

The qualification certificate of the welding / brazing personnel states at least:

- identification of welding / brazing personnel and employer;
- the WPS / BPS that were used for the qualification and the conditions for carrying out the tests;
- the field of validity of the qualification;
- information on tests and related results;
- the validity.

The duration of the certificates and the consequent validity, the conditions for maintaining the validity and the conditions for the extension of the certification, are established on the basis of the applicable standards.

## **6. OBLIGATIONS OF HOLDERS OF QUALIFICATIONS**

The provisions of the general contractual conditions apply and also, specifically, the following provisions regarding the certifications subject to this regulation.

Qualified personnel must undertake to comply with the rules of professional behaviour for welding / brazing personnel.

The holders of the qualification must, upon request, provide a copy of this qualification and operate within the limits of the application field of the same.

Holders of the qualification must undertake to:

- not to use the qualification of procedures and / or welders / welding operators / braziers in such a way as to be considered valid for activities other than those for which it was issued or in any case in such a way as to mislead or bring discredit to AREAS;
- in case of supply of qualification certificates to others, reproduce them in their entirety.

However, it is the employer's responsibility to promptly inform AREAS on aspects that may affect the ability of qualified persons to continue to meet the qualification requirements. AREAS must also be informed in the event of a change of employer.

The Qualified Person and the employer must keep a record of complaints received from their clients.



## 7. REVISIONS

Rev.0	07/15/2021	First issue
Rev.1	05/10/2021	General review
Rev.2	09/12/2021	General revision following Accredia findings
Rev.3	02/18/2022	Revision following 1st Accredia document (renewal methods §3.3) Modification of the proceeding's deliberation committee
Rev.4	03/14/2022	Amendment to paragraph 2 of the purpose with the insertion of the type of Body Modification to par.2.1 with insertion of new references Amendment to par.3.1 with details of the examination centres Addition of paragraph 3.9 on subcontracting
Rev.5	04/11/2022	Amendment to par. 4.1 / 4.3 / 4.4 / 4.5 / 4.7 with details of the tests carried out by the examination centres
Rev.6	22/04/2025	Amendment to par. 2.2 clarifying brazing Amendment to par. 3.3 regarding the duration of the qualification validity in accordance with ISO 13585:2021