

Welder Qualifying Agency Inspection-Evaluation Checklist



WABO Welder Qualifying Agency Inspection-Evaluation Checklist

Updated 2020

Inspection-evaluation of a WABO Welder Qualifying Agency must be completed every three years in order to maintain registration with WABO.

Inspection-Evaluation Information

Date: _____ Initial _____ Resurvey/audit _____

Surveyor/Auditor Name(s): _____

Qualifying Agency Information

Name: _____

Address (mailing): _____

Address (physical): _____

Name: _____ Title: _____

Phone: _____ Fax: _____

E-Mail: _____

Examiner(s) Information

(Name) (CWI Certificate No.) (Expiration Date)

(Name) (CWI Certificate No.) (Expiration Date)

(Name) (CWI Certificate No.) (Expiration Date)

(Name) (CWI Certificate No.) (Expiration Date)

Radiography Testing Information

(Name of the qualified agency if testing is subcontracted)

(Name of individual(s) ASNT-TC-1A qualified-NDT Level III certified)

(Name of individual(s) ASNT-TC-1A qualified-NDT Level II certified)

(Name of individual(s) ASNT-TC-1A qualified-NDT Level II certified)

Inspection-Evaluation Checklist

1. Personnel

<u>Yes</u>	<u>No</u>	<u>Refer to Comments</u>
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- | | | | |
|-------|-------|----------|---|
| _____ | _____ | _____ a. | The agency personnel witnessing tests, conducting mechanical tests and approving the mechanical and visual test coupons are WABO Approved Welder Examiners. |
| _____ | _____ | _____ b. | The personnel performing radiographic testing are qualified in accordance with ASNT recommended Practice No. SNT-TC-1A and are NDT Level II certified. |
| _____ | _____ | _____ c. | The agency has had changes in personnel since the last survey/audit. (If "yes," explain in comments.) |

Comments: _____

2. Documents and Publications

<u>Yes</u>	<u>No</u>	<u>Refer to Comments</u>
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- | | | | |
|-------|-------|----------|--|
| _____ | _____ | _____ a. | The agency has a WABO Welder and Welding Operator Qualification Standard No. 27-13. |
|-------|-------|----------|--|

- _____ b. The agency has a Quality Assurance system and quality system manual meeting criteria outlined in 27.13.3.
- _____ 1. Organizational Chart
- _____ 2. Conflict of Interest
- _____ 3. Rules for Security
- _____ 4. General Quality Control Procedures
- _____ 5. Retest Procedure / Form
- _____ c. The agency has current copies of Forms 100, 200, 300, and 400.
- _____ d. The agency has the most recent edition of the **AWS Structural Welding Code-Steel** (D1.1).
- _____ e. The agency has the most recent edition of the **AWS Structural Welding Code-Sheet Steel** (D1.3) if applicable.
- _____ f. The agency has the most recent edition of the **AWS Structural Welding Code-Reinforcing Steel** (D1.4) if applicable.
- _____ g. The agency has the most recent edition of the **AWS Structural Welding Code-Seismic Supplement** (D1.8) if applicable.

Comments: _____

3. Records

Yes	No	Refer to Comments
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- | | | |
|-------|-------|---|
| _____ | _____ | _____ a. The agency record keeping system is orderly. |
| _____ | _____ | _____ b. The agency maintains current mill cert. documentation on welding materials. |
| _____ | _____ | _____ c. The agency maintains copies of welder's qualification test record. (Forms 100, 200, 300, and 400) for 3 years. |
| _____ | _____ | _____ d. The welder qualification test record results can be correlated with welding test coupons. |
| _____ | _____ | _____ e. Retest records were verified. Applicant _____
Date of record _____ |

____ ____ ____ f. Verification of Visual Inspections (root pass), Final per 27.13.8.
Inspection Date _____ Result Recorded _____

Comments: _____

4. Testing Practices and Specimens

Yes No Refer to
Comments

____ ____ ____ a. The agency has a written procedure for submittal to the weld candidate outlining the following:

____ Test procedures

____ Safety rules

____ Fit up

____ Test requirements (positioning)

____ Weld experience

____ ____ ____ b. In the initial discussion with the weld candidate is welder's experience discussed?

____ ____ ____ c. The agency requires positive photo identification of testing applicants prior to administration of exam.

____ ____ ____ d. The agency identifies testing materials.

____ ____ ____ e. The agency maintains a testing materials rack, or other suitable storage area, for identified test materials.

____ ____ ____ f. The agency performs specimen inspections both before and after machining operations.

____ ____ ____ g. The agency performs metallurgical procedures adequately (e.g. grinding, polishing, finishing and etching-if acceptable)

____ ____ ____ h. The agency identifies test specimens (e.g. etching or some other acceptable manner).

____ ____ ____ i. The agency maintains a secured storage area for completed, identified test specimens

____ ____ ____ j. The agency performs bend testing in house.

- ___ ___ ___ k. The agency performs radiographic testing in house.
- ___ ___ ___ l. The agency subcontracts radiographic testing.
- ___ ___ ___ m. The agency provides copies of radiograph reports with the form 100 & 200 sent to the WABO office.
- ___ ___ ___ n. The agency maintains bend test or radiographic specimens for six (6) months.
- ___ ___ ___ o. The agency uses acceptable Welding Procedure Specifications (WPS).

Comments: _____

5. Equipment and Materials

Yes	No	Refer to Comments
___	___	___ a. The agency has a designated machine(s) for WABO certification testing.
___	___	___ b. The agency has a maintenance program and schedule for the designated WABO certification testing machine(s).
___	___	___ c. The agency has a supply of appropriate consumables.
___	___	___ d. The agency has an electrode/rod oven with a built-in thermostat or other temperature control.
___	___	___ e. The agency electrode/rod oven has a built-in or other temperature measuring gauge.
___	___	___ f. The agency electrode/rod oven is maintained at the appropriate temperature. (250 degrees F or 120 degrees C or otherwise specified by code).
___	___	___ g. The agency welding booths are equipped with adequate ventilation, lighting, and work positioners.
___	___	___ h. The agency's bend test jig conforms to WABO prescribed specifications. (Refer to Standard 27-13 illustration)
___	___	___ i. If the agency performs, or subcontracts, radiographic testing, the equipment, procedure, and technique used meet criteria prescribed in AWS D1.1.

_____ j. The agency has a maintenance program and schedule for amp meters to be calibrated every 12 months.

Comments: _____

6. Inspection and Hand Tools

Yes	No	Refer to Comments
_____	_____	a. The agency has inspection shields.
_____	_____	b. The agency has weld gauges.
_____	_____	c. The agency has an adequate white light source.
_____	_____	d. The agency has 3X power magnifying glass.
_____	_____	e. The agency has an amp meter (annual calibration required).
_____	_____	f. The agency has measuring devices e.g. rules, calipers, etc.
_____	_____	g. The agency has suitable solutions for etching.
_____	_____	h. The agency has die stamps-1/4" min.

Comments: _____

7. Operations

Yes	No	Refer to Comments
_____	_____	a. Is fit up & positions inspected prior to start of welding?
_____	_____	b. Are welding procedures available for use by the candidate & understood?
_____	_____	c. Does the candidate set up the welding machine to comply with the weld procedures?
_____	_____	d. Does the examiner prepare the test coupons?

- _____ e. Does the examiner periodically review the welding of the test coupons?
- _____ f. Does the examiner test the coupons?
- _____ g. Does the examiner visually review the completed test coupons for acceptability?
- _____ h. Does the examiner evaluate the test coupons?

Comments: _____

8. Weld Certifications approved at this facility

<u>Structural Welder</u>	<u>Process</u>	<u>Procedure #</u>
	SMAW :	
	GTAW:	
	GMAW	
	FCAW	
<u>Sheet Steel</u>	SMAW :	
	GTAW:	
	GMAW	
	FCAW	
<u>Reinforcing Steel</u>	SMAW :	
	GMAW	
	FCAW	
	FCAW	
<u>Welding Operator</u>	SAW	
<u>Seismic Restricted ACCESS</u>	SMAW :	
	FCAW	