

## **WELDING TECHNOLOGY CENTRE**

### **B H E L: Tiruchirappalli**

#### **PROCEDURE REGARDING INITIAL QUALIFICATION & RE-QUALIFICATION FOR WELDERS**

Boiler pressure parts components manufacturing requires Indian Boiler Regulations (IBR) qualified welders for welding operation. These welders have to be qualified as per IBR chapter XIII. The qualification process in BHEL Trichy is envisaged as below.

##### **Initial Qualification (IQ):**

Upon induction into our organization, are given training is imparted for Carbon Steel (CS) plate for a duration of 3-7 days. On successful completion of training, the individual has to sign the application related to his/her qualification. Welders have to appear the test conducted by the competent authority as per IBR 609. His/her performance will be evaluated as per form XII of regulation 613 and 607. The test results will be declared by the competent authority for the successful welders as per Form XIII and the welder data will be kept updated .

After successful completion of Carbon Steel plate, welders will be called for Alloy steel tube and pipe qualification in the following processes. 1) GTAW + SAMW, 2) GTAW + FCAW. The duration of training for the above processes is three (3) weeks. On successful completion of training, these welders will be qualified as stated above. His/her qualification is valid for a period of 2 years and updated .

Welders/welding machine operators will be qualified on need basis. Training by senior operators on the machine is given. On successful completion of training, the Welders/welding machine operators have to appear the test conducted by competent authority. This qualification test results will be issued in form XIII by the competent authority and valid for two years.

Welders/welding machine operators who are not successful in the tests will be called for re-test and training if required.

##### **Re-Qualification (RQ):**

Before the expiry of his/her validation, welders/ welding machine operators are called for Re-qualification (RQ) as per Regulation 610. The individual has to sign the required application related to his/her qualification. Welders/ welding machine operators have to appear for the test conducted by competent authority as per IBR 609 and his performance will be evaluated as per form XII of regulation 613 and 607. The test results will be declared by the competent authority for the successful welders as per Form XIII and the welder data will be kept updated . His/her qualification will be valid for further a period of 2 years.

Welders those who are not successful in the tests will be called for re-test within validity period.

Intimations regarding the test are made through the controlling officers of the welders against acknowledgment. Training is provided by Welding Technology Centre and tests are conducted periodically and qualification is issued by competent authority appointed by IBR personnel.