

Inspection and Technical Services

Certificate of Authorization – Pressure Welder Performance Qualification Testing Center

ITS 20-007

The Certificate of Authorization quality program offered by Inspection and Technical Services (ITS) provides for, amongst other things, the approval of pressure welder performance qualification testing centers.

*“**pressure welder**” – means a person who acts as a welder, welding operator, brazer or brazing operator in respect of a boiler, pressure vessel or piping used in connection with a boiler or pressure vessel.*

This quality program is intended to approve organizations that have the necessary processes, training, qualified personnel, equipment and facilities in order to test pressure welders, and to provide a means of auditing compliance to their registered program. The requirements of this program are based on the latest editions of:

- **ASME Section IX** – *Qualification Standard for Welding, Brazing and Fusing Procedures; Welders; Brazers; and Welding, Brazing, and Fusing Operators;*
- **CSA B51** – *Boiler, pressure vessel and pressure piping code; and*
- The **Manitoba Steam and Pressure Plants Act and Regulation.**

Applications for a Certificate of Authorization – Pressure Welder Performance Qualification Testing Center will only be considered if the applicant:

- Completes the appropriate application form
- Submits a quality control manual
- Provides evidence of the weld examiners qualifications; CWB W178.2 Level 2 or 3 Welding Inspector Certification (with ASME endorsement), or current Welding Examiner Certificate of Competency issued by ABSA.

Applicants will be required to demonstrate their processes, knowledge, ability and conformance to their submitted quality manual by successfully completing an implementation audit conducted by the ITS Quality Inspector.

Successful applicants will be issued a Certificate of Authorization valid for 36 months, with a mandatory surveillance audit conducted by the ITS Quality Inspector every 12 months, or at a frequency requested by ITS. Certificate holders who fail to comply with the program requirements may be issued a temporary suspension, or cancellation of their program.

The Certificate of Authorization holder will be responsible for administering the performance qualification tests, and providing recommendations on the issuing of licenses through reporting to ITS. ITS will review the reporting and consider the recommendations to issue licenses.

All licenses will continue to be issued by the ITS.

Implementation and Surveillance Audits

Implementation and surveillance audits will be conducted by an ITS Quality Inspector.

The purpose of these audits are to verify that:

- All of the requirements of the quality manual have been implemented and are continually followed;
- The testing and evaluation of welded coupons are in accordance with ASME Section IX;
- The required reporting to the ITS is in the desired format and submitted;

The Quality inspector will require the Certificate of Authorization applicant to demonstrate their knowledge of the submitted quality manual. It will be necessary for all qualified personnel to be present, and to have the necessary equipment on hand.

Upon completion of the audit, the inspector will provide an audit report, including any nonconformances noted. Upon satisfactory completion of any nonconformities, a Certificate of Authorization will be issued.

Fees

The fees under this program include Audit of Quality Assurance Program at a rate of \$110 per hour, in accordance with—section 23(5) of the Steam and Pressure Plants Regulation.

Forms

- Application for Certificate of Authorization
- Sample Quality Manual