

AWS B1.1 Visual Examination of Welds

3. Qualification of Examination Personnel

3.1 General. Individuals assigned the task of performing formal visual examinations should be qualified. The three elements of qualification may include education, training, and experience. Since visual examination requires the ability to see small discontinuities or imperfections, good visual acuity is also desirable.

3.2 Visual Acuity. The individual should have sufficient visual acuity to perform an adequate examination. Consideration should be given to sufficient near and far vision with natural or corrected vision. A documented periodic visual acuity examination is a requirement of many codes and specifications, and is generally considered good practice.

3.3 Equipment. Visual examination may require the use of special tools or equipment. The tools or equipment depend upon the application and the degree of accuracy required. Some tools may need to be calibrated prior to use. Although this guide presents an outline of visual examination aids, there are many different concepts and other variations of equipment. As a general rule, those tools should be used that: (1) comply with the project requirements, (2) are adequate for the intended accuracy, and (3) satisfy the need of the examination.

3.4 Experience and Training. The visual examiner should have sufficient knowledge and skill to perform the examination successfully and meaningfully. Knowledge and skill can be imparted or obtained through the educational and training processes. Either method can be performed in a classroom or on the job. The variety of methods and processes of imparting or obtaining knowledge and skill are many, but the art of good judgment does not always come easily or readily. Sufficient time should be allowed for individuals to properly grasp key points pertaining to the following:

(1) joint preparation, (2) welding preheat, (3) interpass temperature, (4) weldment distortion, (5) welding consumables, (6) base materials, and (7) workmanship standards.

3.5 Procedures. Development of standard or specialized procedures covering examination methodology and acceptance criteria produces consistent and accurate results. Such procedures are normally prepared by the employer and typically consist of detailed instructions that interrelate the various fabrication processes, the customer's detailed requirements, and examination criteria. Items such as who performs an examination, when to perform an examination, how to perform an examination, and where to perform an examination are typically included in the procedure. As a minimum the standard procedures should include the following: workmanship standards, check lists, and examination equipment requirements. When written procedures are not available, examiners may be asked to work directly with relevant codes and specifications.

3.6 Certification Programs. To provide assurance that visual examiners are qualified it may be desirable to have visual examination personnel formally certified. Contract documents, fabrication standards, or regulatory agencies may require special qualifications for visual examiners. Several standards developers offer certification programs for visual examiners such as AWS QCI, Standard for Certification of Welding Inspectors.

4. Fundamentals of Visual Examination

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Engineered Waste Package System Design Specification, 1983 The Welding of Aluminium and Its Alloys G Mathers, 2002-09-24 The Welding of Aluminium and its Alloys is a practical user's guide to all aspects of welding aluminium and aluminium alloys. It provides a basic understanding of the metallurgical principles involved, showing how alloys achieve their strength and how the process of welding can affect these properties. The book is intended to provide engineers with perhaps little prior understanding of metallurgy and only a brief acquaintance with the welding processes involved, with a concise and effective reference to the subject. It is intended as a practical guide for the Welding Engineer and covers weldability of aluminium alloys, process descriptions, advantages, limitations, proposed weld parameters, health and safety issues, preparation for welding, quality assurance and quality control issues, along with problem solving. The book includes sections on parent metal storage and preparation prior to welding. It describes the more frequently encountered processes and has recommendations on welding parameters that may be used as a starting point for the development of a viable welding procedure. Included in these chapters are hints and tips to avoid some of the pitfalls of welding these sometimes problematic materials. The content is both descriptive and qualitative. The author has avoided the use of mathematical expressions to describe the effects of welding. This book is essential reading for welding engineers, production engineers, production managers, designers, and shop floor supervisors involved in the aluminium fabrication industry. A practical user's guide by a respected expert to all aspects of welding of aluminium. Designed to be easily understood by the non-metallurgist whilst covering the most necessary metallurgical aspects. Demonstrates best practice in fabricating aluminium structures.

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