

Standard Operating Procedure <b>Manual Welding Qualification</b>	SOP No. 7.010
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DCR No.: 11006  
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Page No.: 1 of 3

- 1 Purpose
  - 1.1 To establish a standard procedure for the qualification of all Therma manual welders.
- 2 Scope
  - 2.1 This procedure shall apply to all Therma manual welders.
- 3 Responsibility
  - 3.1 The Therma Quality Assurance Manager (QAM) shall administer this procedure and verify that welder(s) on the job has/have satisfied the criteria herein.
  - 3.2 The Therma Quality Control Examiner (QCE) is responsible for ensuring welder is performing tasks.
- 4 Procedures
  - 4.1 All welders shall be qualified under the direct supervision of the quality control department.
  - 4.2 All welders will be certified in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code, current edition/addenda.
  - 4.3 All certified welders will be assigned a stamp to be applied adjacent to his/her work (if applicable). In the event a welder leaves the company, his/her stamp will not be issued to another welder for at least six months.
  - 4.4 A record of each qualification for each welder will be prepared on a Welder Welding Operator Performance Qualifications (WPQ), FN 5.005.4.
  - 4.5 The welder's name, social security number, stamp ID and weld qualification will be entered into the Welder/Brazer Status Form, FN 7.010.1, by the QCE to assure that the individual welder has used the specific process within the requalification period of six months. Any

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Revision No.	SOP No.	Page
2	7.010	<b>2 of 3</b>

welder who has not welded using a specific process within the six-month period must renew his/her qualification as required by ASME, Section IX.

## 5 Review and Approval

- 5.1 The Therma QA/QC department shall ensure this accepted format is utilized.

Revision No.	SOP No.	Page
2	7.010	3 of 3

## Document Approval

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3/06/12  
Date

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