



Centre Pipe Welding Test Moderation Report 2009

Centre Pipe Welding Test Moderation Report for 2009**Contents Page**

| Section | Contents | Page |
|----------------|--|-------------|
| 1 | Introduction | 3 |
| 2 | Moderators report for 2009 | 4&5 |
| | <ul style="list-style-type: none">• Strengths & Areas for improvements highlighted from the moderation process. | |
| 3 | Number of welding tests conducted throughout 2009 | 6&7 |
| | <ul style="list-style-type: none">• Number of tests identified per region• Comparison of 2007- 2009• Centres Observed/to be Observed | |

Section 1. Introduction

The 'Centre Approval' process and external moderation of the pipe welding test continues to be a success. The number of approved centres across the UK has remained static, but with several enquiries from prospective new centres there could be an increase in 2010. There has again been a slight increase in the number of new examiners, which has offset the losses due to retirement. The number of tests being undertaken in all areas nationwide has remained fairly constant, but obviously some areas have been affected by the economic crisis impacting on the labour force within the industry.

Jim Wilson has now taken on a large proportion of the welding centres and with two moderators available it is providing a quicker response time to centres requiring observations of their testing procedures, This will be the 5th year that moderation has taken place and there are still centres/examiners that have not actually managed to arrange an observation of a test.

This year the moderators will major on this activity and centres/examiners that fail to conform will be put under sanction and prevented from registering next year until an observation has been successfully conducted. The complete list of centres/examiners who have or have not been observed conducting tests can be found on **page 6** of this report.

Centres are respectfully reminded that any changes to staff/examiners/point of contact must be immediately conveyed to SummitSkills. Some centres have failed to notify SummitSkills of changes and this has caused confusion and delays in arranging moderation visits.

The external moderation process continues to ensure that the standards are consistently high across all the centres and enables good practice to be shared amongst individual examiners. SummitSkills would like to thank all the staff at the Engineering Services SKILLcard and the HVCA for their sterling work. We would also like to thank all the centres and examiners and wish them continual success for 2010.

The following report has been compiled by the SummitSkills welding moderators and highlights the main strengths, areas for improvement and issues observed during visits to the majority of approved welding test centres throughout 2009.

I hope you find this report useful

From the SummitSkills approved pipe welding project team:

Neil Collishaw - (project manager) – neil.collishaw@summitskills.org.uk
John Wilcock – (National Welding Moderator) – john.wilcock@summitskills.org.uk
Jim Wilson – (National Welding Moderator) – jim.wilson@tiscali.co.uk
Margaret McCann – (Administrator) – Margaret.mccann@summitskills.org.uk

General information can be found at <http://www.summitskills.org.uk/businesses/244>

Section 2. Centre Welding Moderation Report for 2009

| | Test Moderation Area | Ref. | Excellent (%) | Good (%) | Satisfactory (%) | Unsatisfactory (%) |
|----|--|-------------|----------------------|-----------------|-------------------------|---------------------------|
| 1 | Administration | | 90 | 10 | 0 | 0 |
| 2 | Notifying Engineering Services Skillcard Penrith | 3e | 90 | 10 | 0 | 0 |
| 3 | Cost of Tests | | 75 | 20 | 5 | 0 |
| 4 | Candidate Induction prior to test | 1b -1j,3e | 65 | 30 | 5 | 0 |
| 5 | Procedure during test | 3 | 90 | 10 | 0 | 0 |
| 6 | Invigilation of test | 2 | 90 | 10 | 0 | 0 |
| 7 | Time limit of test | 1e | 100 | 0 | 0 | 0 |
| 8 | Ensuring fixed butt is not moved during test | 2b, P5 | 100 | 0 | 0 | 0 |
| 9 | Marking test pieces for position | 2b, 1f | 90 | 10 | 0 | 0 |
| 10 | Marking test pieces for identification purposes | 1j | 75 | 20 | 5 | 0 |
| 11 | Visual inspection of weld set up | 1k | 80 | 20 | 0 | 0 |
| 12 | Visual inspection of completed welds | 3c | 85 | 5 | 10 | 0 |
| 13 | Cutting and preparing test specimens | P10 | 65 | 15 | 20 | 0 |
| 14 | Bend testing coupons | 3b,3c | 80 | 20 | 0 | 0 |
| 15 | Assessing welds for marks | 1k | 70 | 30 | 0 | 0 |
| 16 | Completion of marking sheets | 3d | 95 | 5 | 0 | 0 |
| 17 | Retaining test specimens as per Guidance Notes | P6 | 80 | 15 | 0 | 5 |
| 18 | Centre/Test Site facilities | 7 | 70 | 30 | 0 | 0 |
| 19 | Observation of weld tests | 8 | 43 | 0 | 0 | 57 |

| Strengths | Areas for Improvement |
|--|---|
| <p>The majority of centres are performing to a very high standard in most of the areas listed above:</p> <p>Better methods of retaining the candidate's test pieces by tack welding them together as a single unit for each test undertaken has been maintained.</p> <p>Identification of the candidates test pieces to facilitate easier cross referencing to the relevant marking schedule has continued to improve.</p> <p>Where observations of the testing procedure have taken place, everything was undertaken in the prescribed manner.</p> <p>More examiners have either retired from, or transferred to other centres, but in the majority of cases they have been replaced to maintain the status quo.</p> <p>Many centres have purchased new inverter plant and extra grinding and cutting equipment, which has enhanced their ability to attract candidates.</p> <p>Cellulosic electrodes are becoming much more common, particularly amongst external candidates who use them as part of their on site welding activities. Their use is apparent in penetration uniformity and continuity.</p> | <p>Improvement is still required in area: 13, 17 & 19. Centres are still not all conforming to the width of test coupon as indicated in the TR5 and Notes for Guidance.</p> <p>Once again there have been cases where there is still a lack of uniformity in the size of coupons cut from the same test pieces (indicated in the Notes for Guidance/TR5).</p> <p>Observation of live tests has still caused problems due to communication and logistical difficulties, but this still remains an essential part of the moderation process as indicated in the introduction. The employment of an extra moderator has helped to alleviate this problem slightly. The moderators cannot make arrangements to visit centres to observe tests if they do not have sufficient notice.</p> <p>Some centres have once again not made adequate provision to ensure all test pieces were retained safely for moderation. This has again undermined the moderation process and must be corrected or sanctions will be applied.</p> <p>There were still instances of the incorrect grade, or diameter of pipe being used for the test, and the centres have been warned that any future instances will result in the test results being rescinded.</p> <p>It is essential that BS 1387 Red Band heavyweight pipe is used as a minimum. When conducting Oxy/Acetylene tests, centres must ensure that candidates cannot inadvertently pick up welding rods which do not conform to BS EN 12536 (TR5 page 8, section 4.1.1)</p> |

Note: Ref. taken from Observation Report, Inspection Checklist, Notes for Guidance

Section 3. Centre Welding Moderation Report for 2009

| | TEST CENTRE/EXAMINER | Test Observed | Test Not Observed |
|----|--------------------------------------|---------------|-------------------|
| 1 | A. Moffatt Pipewelding (Independent) | ✓ | |
| 2 | Bexley College | ✓ | |
| 3 | Blackpool & the Fylde College | | ✓ |
| 4 | Cambridge Regional College | | ✓ |
| 5 | Colchester Institute | | ✓ |
| 6 | Coleg Glan Hafren | ✓ | |
| 7 | Croydon College | | ✓ |
| 8 | Downing Consultants (Independent) | | ✓ |
| 9 | Deeside College | | ✓ |
| 10 | Dundee College | | ✓ |
| 11 | Edinburgh Telford College | | ✓ |
| 12 | James Butcher (Independent) | | ✓ |
| 13 | Leeds College of Building | ✓ | |
| 14 | Liverpool College | ✓ | |
| 15 | The Manchester College | ✓ | |
| 16 | Materials Engineering Group Derby | | ✓ |
| 17 | New College Nottingham | ✓ | |
| 18 | Newcastle College | ✓ | |
| 19 | Newham College | | ✓ |
| 20 | NG Bailey & Co Ltd | ✓ | |
| 21 | North Glasgow College | ✓ | |
| 22 | North West Welder Training | | ✓ |
| 23 | City College Plymouth | ✓ | |
| 24 | Robert Saunders (Independent) | | ✓ |
| 25 | RWD Weld Testing (Independent) | | ✓ |
| 26 | Salford College | | ✓ |
| 27 | S. Devon Weld Centre (Independent) | | ✓ |
| 28 | Stoke on Trent College | ✓ | |
| 29 | Tullos Training | ✓ | |
| 30 | Welder Training Servs (Independent) | ✓ | |
| 31 | Mohamed Ally (Independent) | | ✓ |
| 32 | Southampton College | | ✓ |

Section 3. Number of weld testing results (figures do not include provisional tests)

| National Region | Total tests 2007 | Total tests 2008 | Total tests 2009 | O/A 2007 | O/A 2008 | O/A 2009 | MMA 2007 | MMA 2008 | MMA 2009 | MIG 2007 | MIG 2008 | MIG 2009 | TIG 2007 | TIG 2008 | TIG 2009 | Passed 2007 | Passed 2008 | Passed 2009 | Failed 2007 | Failed 2008 | Failed 2009 |
|--------------------|------------------|------------------|------------------|------------|------------|------------|------------|------------|------------|----------|----------|----------|----------|----------|----------|-------------|-------------|-------------|-------------|-------------|-------------|
| East of England | 23 | 24 | 22 | 3 | 5 | 3 | 17 | 16 | 16 | 2 | 3 | 3 | 1 | 0 | 0 | 23 | 24 | 22 | 0 | 0 | 0 |
| South of England | 134 | 143 | 66 | 38 | 26 | 11 | 94 | 113 | 55 | 0 | 2 | 0 | 0 | 0 | 0 | 132 | 141 | 66 | 2 | 2 | 0 |
| London | 131 | 35 | 99 | 20 | 3 | 20 | 105 | 27 | 73 | 3 | 2 | 4 | 0 | 1 | 2 | 128 | 33 | 98 | 3 | 2 | 1 |
| Wales | 5 | 3 | 11 | 2 | 2 | 0 | 3 | 1 | 11 | 0 | 0 | 0 | 0 | 0 | 0 | 5 | 3 | 11 | 0 | 0 | 0 |
| Midlands | 62 | 37 | 55 | 5 | 5 | 4 | 55 | 27 | 51 | 0 | 0 | 0 | 0 | 1 | 0 | 60 | 33 | 55 | 2 | 4 | 0 |
| North East England | 188 | 95 | 102 | 60 | 27 | 33 | 110 | 65 | 69 | 0 | 0 | 0 | 0 | 1 | 0 | 170 | 93 | 93 | 18 | 2 | 9 |
| North West England | 110 | 80 | 81 | 50 | 44 | 33 | 53 | 33 | 48 | 0 | 0 | 0 | 0 | 0 | 0 | 103 | 77 | 78 | 7 | 3 | 3 |
| Scotland | 167 | 131 | 118 | 63 | 45 | 53 | 83 | 77 | 65 | 0 | 0 | 0 | 0 | 0 | 0 | 146 | 122 | 105 | 21 | 9 | 13 |
| TOTALS | 820 | 548 | 554 | 241 | 157 | 157 | 520 | 359 | 388 | 5 | 7 | 7 | 1 | 3 | 2 | 767 | 526 | 528 | 53 | 22 | 26 |