



Centre Pipe Welding Test Moderation Report 2010

Centre Pipe Welding Test Moderation Report for 2010**Contents Page**

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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 fairly static, but with several new centre's taking the place of centres who for various reasons are no longer able to conduct weld testing. There has again been a slight increase in the number of new examiners mainly within the new test centres. The number of tests being undertaken in all areas nationwide has once again remained fairly constant in spite of the economic turndown.

The two national moderators have been striving to complete the list of centres who have not yet had a welding test observation, but for various reasons there are still some outstanding. This will be the 6th year that moderation has taken place and it is imperative that all centres who have not had an observation (see list on page 6) make every effort to ensure the list is completed before the end of 2011. Obviously the test centre's who have recently received accreditation will be given priority initially. Once again the moderators will major on this activity and centres/examiners that fail to conform could be put under sanction and prevented from registering next year until an observation has been successfully conducted.

Summitskills is fully committed to the Green agenda and as such the moderators will be expected to conduct visits logistically by areas to minimize use of fuel and maximize use of time. The complete list of centre's/examiners who have or have not been observed conducting tests can be found on **page 6** of this report. It is the responsibility of the Centres to notify SummitSkills of any changes to staff/examiners/point of contact as this has tended to cause some confusion and delays in arranging moderation visits.

The external moderation process continues to ensure that the standards are being maintained at a consistently high level 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 2011.

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 2010.
I hope you find this report useful

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

Section 2. Centre Welding Moderation Report for 2010

	Test Moderation Area	Ref.	Excellent (%)	Good (%)	Satisfactory (%)	Unsatisfactory (%)
1	Administration		90	10	0	0
2	Notifying Engineering Services Skillcard Penrith	3e	95	5	0	0
3	Cost of Tests		85	10	5	0
4	Candidate Induction prior to test	1b -1j,3e	85	10	5	0
5	Procedure during test	3	95	5	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	80	15	0	0
10	Marking test pieces for identification purposes	1j	80	15	5	0
11	Visual inspection of weld set up	1k	80	20	0	0
12	Visual inspection of completed welds	3c	90	5	5	0
13	Cutting and preparing test specimens	P10	70	15	15	0
14	Bend testing coupons	3b,3c	85	15	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	85	10	0	5
18	Centre/Test Site facilities	7	80	20	0	0
19	Observation of weld tests	8	63	0	0	37

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>Methods of retaining the candidate's test pieces by tack welding them together as a single unit for each test undertaken has helped in the matching of candidates work to the correct marking schedule.</p> <p>Identification of the candidates test pieces to facilitate easier cross referencing to the relevant marking schedule has improved at all centres.</p> <p>Where observations of the testing procedure have taken place, everything was undertaken in the prescribed manner.</p> <p>More new examiners have applied and been accepted at various centres, both new and existing. This has once again retained the status quo.</p> <p>Many centres have purchased new equipment, which has enhanced their ability to attract candidates and offer different processes.</p> <p>The option to use Cellulosic electrodes is becoming much more common at all centres, consequently the penetration uniformity and continuity is showing great improvement.</p>	<p>Improvement is still required in area: 13, 17 & 19.</p> <p>Centres are still not all conforming to the width of test coupon as indicated in the TR5 and Notes for Guidance.</p> <p>There are fewer instances but again there have been cases where there is still a lack of uniformity in the size of test coupons .(as indicated in the Notes for Guidance TR5).</p> <p>Observation of live tests is still causing problems due to communication and logistical difficulties, but this still remains an essential part of the moderation process as indicated in the introduction.</p> <p>The moderators need sufficient notice to be able to arrange to visit centres to observe tests.</p> <p>Some centres have still not made adequate provision to ensure all test pieces are being retained safely for moderation. This has undermined the moderators choice of candidates to check and must be corrected or sanctions will be applied.</p> <p>There are still instances of the incorrect grade, or diameter of pipe being used for the test, this must be eradicated as it is non conformity with TR5.</p> <p>It is essential that BS EN 10255 2004 heavyweight pipe is used as a minimum. When conducting Oxy/Acetylene tests, centres must ensure that candidates do not use welding rods which do not conform to BS EN 12536 (TR5 page 8, section 4.1.1) as failure to do so can significantly affect the mechanical properties of the weld.</p>

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

Section 3. Centre Welding Moderation Report for 2010

	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	Deeside College		✓
9	Dundee College		✓
10	Edinburgh Telford College		✓
11	James Butcher (Independent)	✓	
12	Leeds College of Building	✓	
13	Liverpool College	✓	
14	The Manchester College	✓	
15	Materials Engineering Group Derby		✓
16	New College Nottingham	✓	
17	Newcastle College	✓	
18	NG Bailey & Co Ltd	✓	
19	North Glasgow College	✓	
20	North West Welder Training		✓
21	City College Plymouth		✓
22	Robert Saunders (Independent)	✓	
23	RWD Weld Testing (Independent)	✓	
24	Salford College	✓	
25	S. Devon Weld Centre (Independent)	✓	
26	Stoke on Trent College	✓	
27	Tullos Training	✓	
28	Muhamed Aly (Independent)	✓	
29	Southampton College		✓
30	Warwick College		✓
31	Hartlepool College		✓

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

National Region	Total tests 2008	Total tests 2009	Total tests 2010	O/A 2008	O/A 2009	O/A 2010	MMA 2008	MMA 2009	MMA 2010	MIG 2008	MIG 2009	MIG 2010	TIG 2008	TIG 2009	TIG 2010	Passed 2008	Passed 2009	Passed 2010	Failed 2008	Failed 2009	Failed 2010
East of England	24	22	21	5	3	7	16	16	12	3	3	2	0	0	0	24	22	18	0	0	3
South of England	143	66	96	26	11	10	113	55	85	2	0	1	0	0	0	141	66	87	2	0	9
London	35	99	82	3	20	35	27	73	47	2	4	0	1	2	0	33	98	80	2	1	2
Wales	3	11	9	2	0	3	1	11	6	0	0	0	0	0	0	3	11	8	0	0	1
Midlands	37	55	53	5	4	23	27	51	30	0	0	0	1	0	0	33	55	51	4	0	2
North East England	95	102	98	27	33	39	65	69	59	0	0	0	1	0	0	93	93	85	2	9	13
North West England	80	81	86	44	33	34	33	48	52	0	0	0	0	0	0	77	78	80	3	3	6
Scotland	131	118	112	45	53	35	77	65	77	0	0	0	0	0	0	122	105	109	9	13	3
TOTALS	548	554	557	157	157	186	359	388	368	7	7	3	3	2	0	526	528	518	22	26	39