

# CSA W47.1 – M (Marine Annex) Q & A



cwbgroup

**Q.** Do I have to re-certify my company?

**A.** No. The implementation of Marine Annex in CSA Standard W47.1-19 will not result in the need for the “Re-certification” of any clients currently certified to the 2009 edition.

**Q.** How do I get to meet the new Marine Annex requirements of the CSA Standard W47.1-19?

**A.** The new Marine Annex supplements the certification requirements of the CSA W47.1. It specifies new performance qualification for welding personnel and new qualification of welding procedures in line with the Class Societies rules.

**Q.** When can I transition to the new Marine Annex?

**A.** The transition process to the 2019 edition of CSA W47.1 will become effective September 1, 2020.

**Q.** Do I get a new Letter of Validation after I complete my transition to the new Marine Annex?

**A.** Letters of Validation will not be re-issued prior to the expiry date as they currently do not specify the year of the certification standard.

**Q.** Do I have to change my Scope of Operations to clearly state Marine Annex?

**A.** This is not required by the CWB. The Scope of Operations can be maintained to be in line with the type of operations you have in your shipyard / fabrication shops.

**Q.** In order to reflect that my company meets the new Marine Annex do I have to change our certification into W47.1-M.

**A.** No. The CWB will not issue a new certification into CSA W47.1-M. The new identification of certification has been introduced to help class society's surveyors to acknowledge that all personnel qualifications and welding procedures meet the new Marine Annex. You will have to change the Company's scope of Operations to include Marine operations.

**Q.** Will the change in the standard impact my annual Fees?

**A.** No, the release of the 2019 edition (including the Marine Annex) will have no impact on your annual fees. There is no requirement for existing clients to purchase the new version of the standard to maintain your certification. However, we encourage our clients to buy a copy of the latest edition to both be familiar with the new provisions of the Marine Annex for personnel qualifications and welding procedure qualifications.

# CSA W47.1 – M (Marine Annex) Q & A



cwbgroup

**Q.** What if I am currently in "applicant" status, and would like to meet Marine Annex requirements?

**A.** The certification requirements specified in the body of the CSA W47.1 have not been changed. Your CWB Representative will continue to work with you to help you achieve the desired certification for your organization.

**Q.** What are changes required for the Welding Engineers and Welding Supervisors?

**A.** All currently accepted Welding Engineers and Welding Supervisors will not be required to undergo a new re-qualification or to write any new exams. After September 1st, 2020 all new Welding Engineers and Welding Supervisors applying for qualifications will have to meet the requirements of the 2019 edition of the CSA W47.1 standard.

**Q.** In order to meet the new Marine Annex do I have to retest my welders?

**A.** The CWB will not request to retest any welding personnel (tackers, welders, and operators). Existing qualifications will continue to be valid until the expiry date shown on their card. Starting September 1st, 2020 at the request of the company we can start testing to the new Marine Annex.

**Q.** If our welders currently hold multiple qualifications and multiple positions obtained in accordance with CSA W47.1 what type of test is required in order to transition to the new Marine Annex?

**A.** There will be no changes with respect to the initial, upgrade and check testing for all new and valid qualifications. All current or new qualifications will follow the logic of the existing standard. However, the welding of the new test assemblies is required to meet the new test assemblies specified in Annex M. For example, a welder having a current "S" class for all positions, all thicknesses for a specific welding process will only perform a check test for 3GF-4GF position following the new Figure M.1 or M.2, as applicable. Check test will continue to be permitted to be performed 90 days prior or after the expiry date of the current expiry qualification unless there is a specific request from the class society's surveyor.

**Q.** Does the new Marine Annex permit Alternate testing?

**A.** No, the new provisions only specify standard test assemblies specified in Figures M.1, M.2, M.3, M.4 and M.5.

**Q.** Are the new "M" qualifications considered transferable from one shipyard to another shipyard?

**A.** Yes, unless the new shipyard or class society's surveyor do not accept such requirements.

# CSA W47.1 – M (Marine Annex) Q & A



cwbgroup

**Q.** Do the new welder tickets will reflect specific qualifications for Marine Annex?

**A.** Yes, the new tickets will be identified as CSA W47.1 with specific classification like S-M, FW-M, etc.

**Q.** What if I have "M" qualification and I need to work for a different project requiring W47.1 qualification, do I need to re-qualify?

**A.** No, the new Marine Annex welding personnel qualifications will meet and exceed the current qualifications of the CSA W47.1 standard. The new welder qualifications will show the applicable qualifications for the Marine Annex and for the main body of the standard.

**Q.** Do I have to resubmit my accepted welding procedures?

**A.** No, there is no requirement to resubmit any welding procedure documentation (WPS and WPDS). All currently accepted documentation will continue to be considered approved (grandfathered). However, any new welding procedure documentation submitted after June 1, 2020, should refer to the 2019 edition of the standard.

**Q.** If my current accepted welding procedure data sheets (WPDSs) do not meet the new Marine Annex do I have to submit new WPDSs?

**A.** Yes. These new WPDSs will be reviewed in accordance to the new Marine Annex requirements and will be assessed accordingly.

**Q.** Can I still use my previous PQRs tested in accordance with the current edition of the CSA W47.1 or Class Society?

**A.** Yes, the CWB will evaluate the previous tested PQRs in accordance with the new Marine Annex and assess them accordingly. The CWB will advise you if the previous tested PQRs meet the new Marine Annex and the next steps required in the process of the approval.

**Q.** If I qualified my welding procedures in accordance with W47.1-Marine Annex requirements and I need to work for a different project requiring W47.1. Do I need to re-qualify my welding procedures?

**A.** No, the new requirements of the Marine Annex meet and exceed the CSA W47.1 requirements for welding procedures.

**Q.** Can a company follow the Marine Annex for offshore structures applications?

**A.** NO. CSA W59 Annex U has provisions for offshore structures applications.

# CSA W47.1 – M (Marine Annex) Q & A



cwbgroup

**Q.** Can a Class Society solely witness testing and approve procedures in accordance with W47.1- Marine Annex?

**A.** No. The CWB is the sole administrator of the CSA W47.1.

**Q.** Can a Class Society also witness testing of welding procedure qualification testing in accordance with W47.1- Marine Annex when CWB witnesses such testing?

**A.** Yes. If the Contract needs the Class Society's approval of such procedures, they can also witness the testing at the same time with the CWB's CSR.

**Q.** Can a welding procedure data sheet bare double acceptance?

**A.** Yes. The welding procedure data sheets can bare the CWB acceptance stamp along with the Class Society acceptance.

**Q.** What are the types for mode of transfer considered for MCAW process?

**A.** MCAW process will have the same types for mode of transfers in line with GMAW process: spray / pulsed / globular and short circuit. Any change from spray / pulsed / globular mode to short circuit mode and vice versa will require a new qualification test.

**Q.** If a welder successfully obtains a qualification for GMAW process is this welder also considered to be qualified for MCAW process?

**A.** Yes. A GMAW process welder qualification is also considered valid for MCAW process within the same class / classification / etc., and vice versa.

**Q.** When start / stop is required by the class when conducting a procedure qualification are the welders allowed to use the grinders?

**A.** Yes.

**Q.** Does the welding inspector conducting inspection on marine application required to have a Marine Annex (Annex M) endorsement?

**A.** CSA W178.2 does not require the welding inspectors to have an endorsement for Annex M at this time.