

Welder Qualification & Procedure Qualification Testing: Options for Evaluation

Note: This applies to CWB Clients located in North America only. Any pricing noted is subject to change.

Following welder or procedure qualification testing, CWB Clients have several options related to the preparation, testing and evaluation of testing coupons. A summary of these options is below.

Part A covers the options for welder qualification testing for CSA W47.1, including Annex K (stainless steel) and Annex M (marine welding).

Part B covers the options for welder qualification testing for CSA W47.2, CSA W186, W59 Annex U.

Part C covers the options for procedure qualification testing.

Questions related to these options can be directed to our Call Centre at 1-800-844-6790 or to your assigned Certification Services Representatives (CSR).

A. Welder Qualification Testing (CSA W47.1, including Annex K and Annex M)

Option 1: Return Visit by CWB Certification Service Representative

All clients may choose to prepare and bend welder test coupons, and then arrange for the CWB CSR to make a return visit to the client facility to evaluate the bend tests.

CWB charges for this option are based on the actual travel time, travel kilometers, and on-site time incurred by the CSR.

Option 2: Client Prepares & Bends Test Coupons – Coupons Sent to CWB Laboratory

All clients may choose to prepare and bend welder test coupons, and then send the coupons to the CWB Laboratory in Milton, ON or in Nisku, AB for evaluation.

CWB charges for this option are \$17.50/set of 3 (or 4) bends. A copy of CWB Form 624 “Laboratory Information” as provided by the CWB CSR must be sent with the test plates to the selected laboratory.

Shipping charges are covered by the client. Plates sent collect or receiver paid will not be accepted. CWB is not responsible for lost or missing plates during shipping.

Option 3: Client Sends Test Plates to CWB Contracted Laboratory

For convenience to our clients, CWB Certification has several contracted laboratories in Canada to perform evaluations of welder qualification assemblies either by radiographic inspection or by mechanical (bend, macro, or fracture) testing.

Clients may ship test plates direct to one of the following locations for preparation and testing:

Radiographic Testing:

- **Applus BC:** 19165 94th Avenue, Surrey, BC, V4N 3S4
- **Applus Ontario:** 4325 Harvester Rd #13, Burlington, ON, L7L 5M4
- **Mequaltech:** 8740, Boul. Pie-IX, Montreal, QC, HIZ 3VI

Bend Testing:

- **CWB Nisku:** 206 19th Ave. Nisku Industrial Park, Nisku, AB, T9E 0W8
- **CWB Milton:** 8260 Parkhill Dr, Milton, ON, L9T 5V7
- **Mequaltech:** 8740, Boul. Pie-IX, Montreal, QC, HIZ 3VI

CWB charges for this option vary on test assembly type, but current pricing for our standard 10mm “S” Class test plate is \$32.00 for radiographic evaluation and \$48.00 for bend test evaluation. These prices include all required preparation and evaluation. For pricing for other test assemblies, please contact your CSR.

A copy of CWB Form 624 “Laboratory Information” as provided by the CWB CSR must be sent with the test plates to the selected laboratory.

Shipping charges are covered by the client. Plates sent collect or receiver paid will not be accepted. CWB is not responsible for lost or missing plates during shipping.

Option 4: Client Selected Laboratory

All clients may choose to send their test plates to a laboratory of their option for radiographic testing or mechanical (bend) testing.

Where radiographic testing is selected, the client must arrange for the image (digital or film) to be sent to the CWB Milton Laboratory for evaluation. CWB charges for this option are for the evaluation of radiographs at \$86/hour.

For bend testing is selected, the client must arrange for the bends to be sent back their facility for evaluation by the CSR (see Option 1) or to the CWB Milton or CWB Nisku Laboratories for evaluation (Option 2). CWB charges for this option are as noted in Options 1 and 2.

The client is responsible to ensure the selected laboratory ships the image and/or test specimens back to the client or to the CWB Milton Laboratory for evaluation. If the image and/or test specimens are not received by CWB, the client is responsible to contact their selected laboratory to resolve the shipping issues.

Please note that the selected laboratory must meet the requirements of CSA W47.1, specifically that they must:

- Be an organization or laboratory accredited by a national accreditation body (e.g., Standards Council of Canada) whose scope certification includes the relevant testing method, OR
- Be a welding inspection organization certified to CSA W178.1 whose scope of certification includes the relevant testing method; OR
- Be acceptable to the CWB

Clients must confirm with their CSR that their selected laboratory is acceptable prior to testing being conducted. Clients are responsible to ensure their selected laboratory understands the requirements for testing in the applicable standard.

B. Welder Qualification Testing (CSA W47.2, W186, W59 Annex U)

Option 1: Return Visit by CWB Certification Service Representative

All clients may choose to prepare and macro/fracture/bend welder test coupons, and then arrange for the CWB CSR to make a return visit to the client facility to evaluate the bend tests.

CWB charges for this option are based on the actual travel time, travel kilometers, and on-site time incurred by the CSR.

Option 2: Client Prepares & Macros/Fractures/Bends Test Coupons – Coupons Sent to CWB Laboratory

All clients may choose to prepare and macro/fracture/bend welder test coupons, and then send the coupons to the CWB Laboratory in Milton, ON or in Nisku, AB for evaluation.

CWB charges for this option are \$86/hour. Shipping charges are covered by the client.

Option 3: Client Sends Test Plates to CWB Contracted Laboratory

For convenience to our clients, CWB Certification has several contracted laboratories in Canada to perform evaluations of welder qualification assemblies by mechanical (bend, macro, or fracture) testing.

Clients may ship test plates direct to one of the following locations for preparation and testing:

Mechanical Testing:

- **CWB Nisku:** 206 19th Ave. Nisku Industrial Park, Nisku, AB T9E 0W8
- **CWB Milton:** 8260 Parkhill Dr, Milton, ON, L9T 5V7
- **Mequaltech:** 8740, Boul. Pie-IX, Montreal, QC, H1Z 3V1

CWB charges for this option vary on test assembly type. For specific pricing for by assembly type, please contact your CSR.

A copy of CWB Form 624 “Laboratory Information” as provided by the CWB CSR must be sent with the test plates to the selected laboratory.

Shipping charges are covered by the client. Plates sent collect or receiver paid will not be accepted. CWB is not responsible for lost or missing plates during shipping.

Option 4: Client Selected Laboratory

All clients may choose to send their test plates to a laboratory of their option for mechanical (macro/fracture/bend) testing.

Following testing, the client must arrange for the bends to be sent back their facility for evaluation by the CSR (see Option 1) or to the CWB Milton or CWB Nisku Laboratories for evaluation (Option 2). CWB charges for this option are as noted in Options 1 and 2.

The client is responsible to ensure the selected laboratory is aware of the requirements for test coupon preparation and testing. CWB is not responsible for errors made by the client selected laboratory and additional charges from CWB may be applied should test coupons require rework or retesting.

The client is responsible to ensure the selected laboratory ships the test specimens back to the client or to the CWB Milton Laboratory for evaluation. If test specimens are not received by CWB, the client is responsible to contact their selected laboratory to resolve the shipping issues.

Please note that the selected laboratory must meet the requirements to:

- Be an organization or laboratory accredited by a national accreditation body (e.g., Standards Council of Canada) whose scope certification includes the relevant testing method, OR
- Be a welding inspection organization certified to CSA W178.1 whose scope of certification includes the relevant testing method; OR
- Be acceptable to the CWB

Clients must confirm with their CSR that their selected laboratory is acceptable prior to testing being conducted. Clients are responsible to ensure their selected laboratory understands the requirements for testing in the applicable standard.

C. Procedure Qualification Testing (All Standards)

Option 1: Return Visit by CWB Certification Service Representative

All clients may choose to prepare and macro/fracture/bend procedure test coupons, and then arrange for the CWB CSR to make a return visit to the client facility to evaluate the test coupons.

For tensile testing, the CSR must witness the tension tests.

CWB charges for this option are based on the actual travel time, travel kilometers, and on-site time incurred by the CSR.

Option 2: Client Prepares & Macros/Fractures/Bends Test Coupons – Coupons Sent to CWB Laboratory

All clients may choose to prepare and macro/fracture/bend test coupons, and then send the coupons to the CWB Laboratory in Milton, ON or in Nisku, AB for evaluation.

Note: This option is not available for tension testing.

CWB charges for this option are \$86/hour. Shipping charges are covered by the client.

Option 3: Client Sends Test Plates to CWB Contracted Laboratory

For convenience to our clients, CWB Certification has several contracted laboratories in Canada to perform evaluations of procedures qualification assemblies by mechanical (tension, bend, macro, fracture, impact, or hardness) testing.

Clients may ship test plates direct to one of the following locations for preparation and testing:

Mechanical Testing:

- **CWB Nisku:** 206 19th Ave. Nisku Industrial Park, Nisku, AB T9E 0W8
- **CWB Milton:** 8260 Parkhill Dr, Milton, ON, L9T 5V7
- **Mequaltech:** 8740, Boul. Pie-IX, Montreal, QC, H1Z 3V1

CWB charges for this option vary on test assembly type. For specific pricing for by assembly type, please contact your CSR.

A copy of CWB Form 624 “Laboratory Information” as provided by the CWB CSR must be sent with the test plates to the selected laboratory.

Shipping charges are covered by the client. Plates sent collect or receiver paid will not be accepted. CWB is not responsible for lost or missing plates during shipping.

Option 4: Client Selected Laboratory

All clients may choose to send their test plates to a laboratory of their option for mechanical (tension, macro/fracture/bend/impact/hardness) testing.

Following testing, the client must arrange for the test report(s) to be sent to CWB Milton for assessment.

Please note that the selected laboratory must meet the requirements to:

- Be an organization or laboratory accredited by a national accreditation body (e.g., Standards Council of Canada) whose scope certification includes the relevant testing method, OR
- Be a welding inspection organization certified to CSA W178.1 whose scope of certification includes the relevant testing method; OR
- Be acceptable to the CWB

Clients must confirm with their CSR that their selected laboratory is acceptable prior to testing being conducted. Clients are responsible to ensure their selected laboratory understands the requirements for testing in the applicable standard.

The client is responsible to ensure the selected laboratory ships the test specimens back to the client or to the CWB Milton Laboratory for evaluation. If test specimens are not received by CWB, the client is responsible to contact their selected laboratory to resolve the shipping issues.