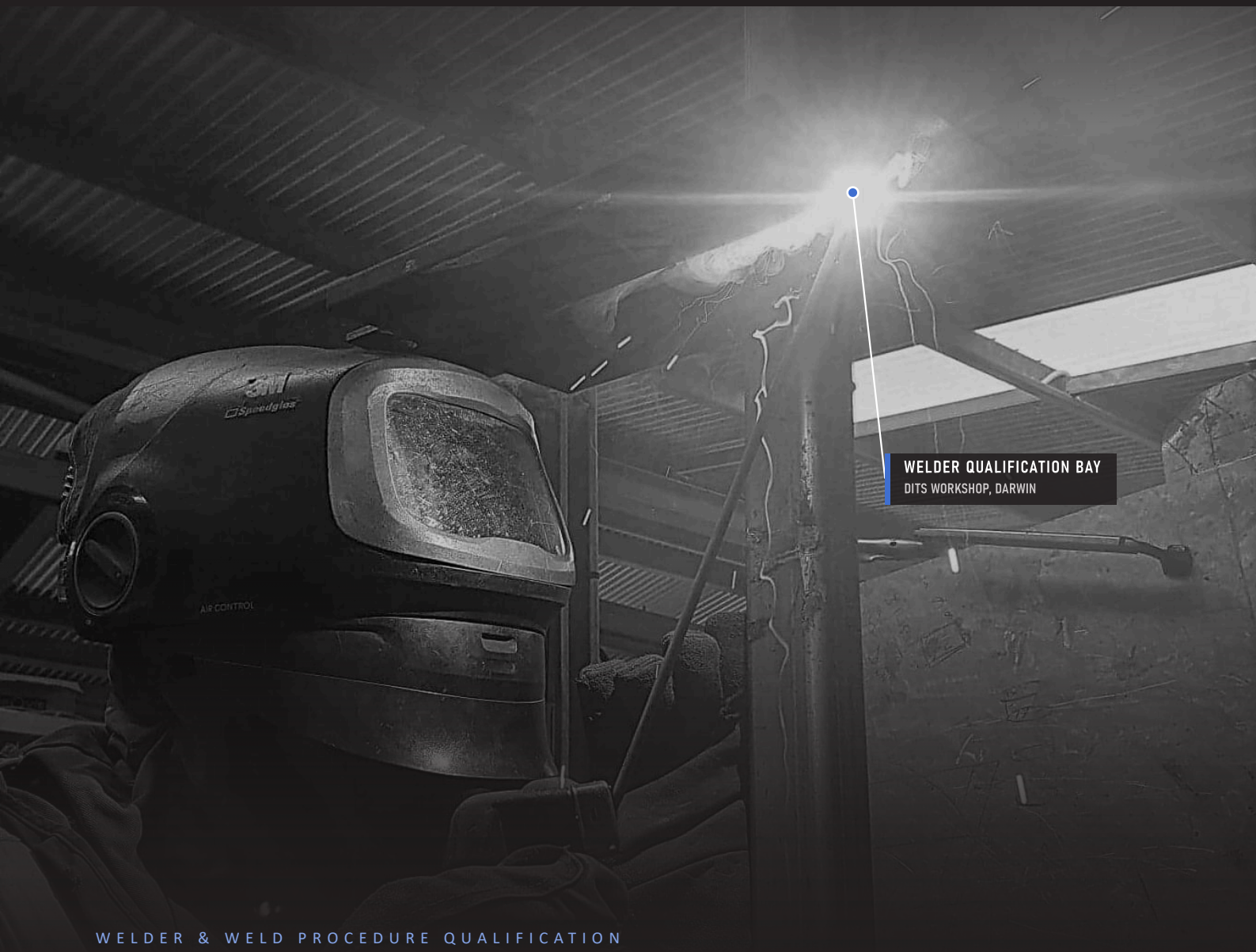


WELDER & WELD PROCEDURE QUALIFICATION

QUALIFIED TO THE CODE. PROVEN IN OUR BAYS.

Welder qualification testing in our Darwin workshop: three test bays, preheat and post-weld heat treatment on hand, and every coupon tested by visual, radiography, macro or fillet break. Supervised and signed off by qualified welding inspectors.

ASME IX | ISO 9606-1 | AS/NZS 2980 | AS/NZS 1554 | AS/NZS 3992 | AS/NZS 2885.2 | AWS D1.1 | API 1104

CODES WE TEST TO

QUALIFY TO THE CODE YOU BUILD TO.

A welder's ticket is only as good as the standard and procedure behind it. We test and certify welders to the code your job is built to, on the WPS they will actually weld to.

PRESSURE
ASME IX
Welder (WPQ) and procedure (PQR) qualification for ASME vessels and B31.3 piping.

INTERNATIONAL
ISO 9606-1
Welder qualification for steels. Recognised internationally and accepted under AS/NZS 3992.

AUSTRALIA & NZ
AS/NZS 2980
ISO 9606-1 adopted for Australia and New Zealand, with local additions.

STRUCTURAL
AS/NZS 1554
Structural steel welding: Part 1 carbon steel, Part 6 stainless.

PRESSURE EQUIPMENT
AS/NZS 3992
Welding and brazing qualification for pressure equipment, including AS 4041 piping.

PIPELINES
AS/NZS 2885.2
Welding of gas and liquid petroleum pipelines.

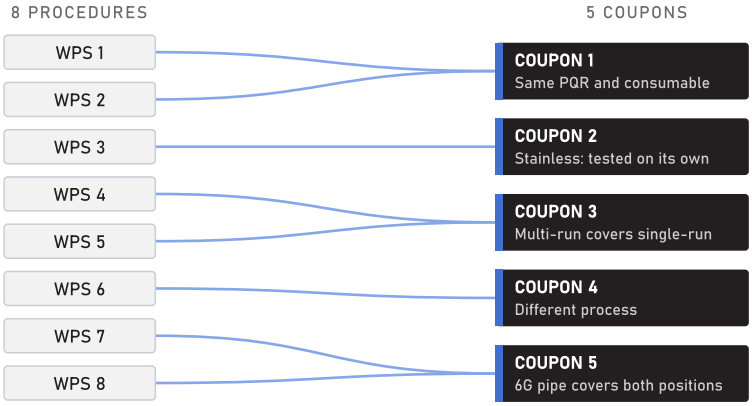
STRUCTURAL (US)
AWS D1.1
Structural Welding Code, for work specified to US codes.

OIL & GAS PIPELINES
API 1104
Welding of pipelines and related facilities.

FEWER COUPONS, SAME COVERAGE.

We read every WPS in your register, not just the list, and work out where the qualification ranges overlap. You get two prices: every procedure tested separately, and the smallest set of coupons that still covers them all.

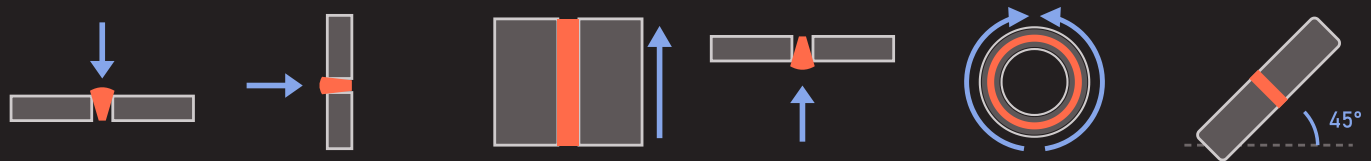
- Same PQR, consumable and position: one coupon
- Multi-run fillets cover single-run
- Each welder's record still lists every WPS



Example only. Combined coverage needs your client or principal to accept it.

POSITIONS

EVERY POSITION, PLATE AND PIPE.



1G · PA Flat

2G · PC Horizontal

3G · PF Vertical up

4G · PE Overhead

5G · PH Pipe fixed, uphill

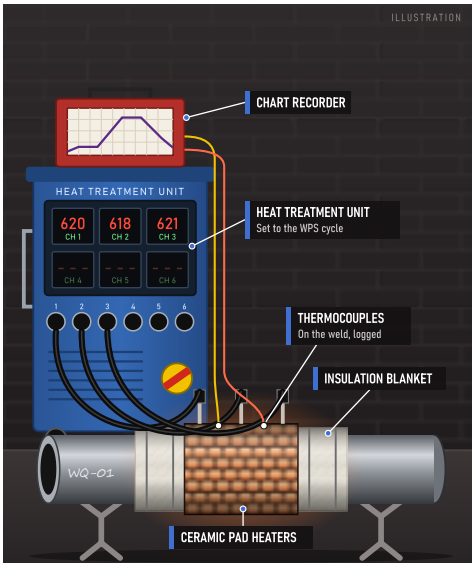
6G · H-L045 Pipe at 45°

A test qualifies a range, not just the coupon. Process, material group, thickness, diameter, position and consumable are all covered within limits. Weld outside that range on the job and the ticket doesn't cover it.

Fillets too: 1F · PA, 2F · PB, 3F · PF and 4F · PD. We state the range on every record, so supervisors can check a welder against a WPS at a glance.

IN OUR WORKSHOP

BAYS, HEAT TREATMENT AND TESTING, UNDER ONE ROOF.

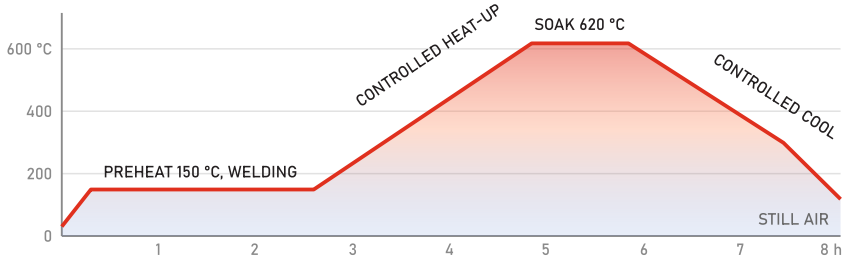


THREE WELDER QUALIFICATION BAYS

Dedicated test bays in our Darwin workshop, with the welding machines supplied for MMAW, GTAW and flux-cored tests.

PREHEAT AND POST-WELD HEAT TREATMENT

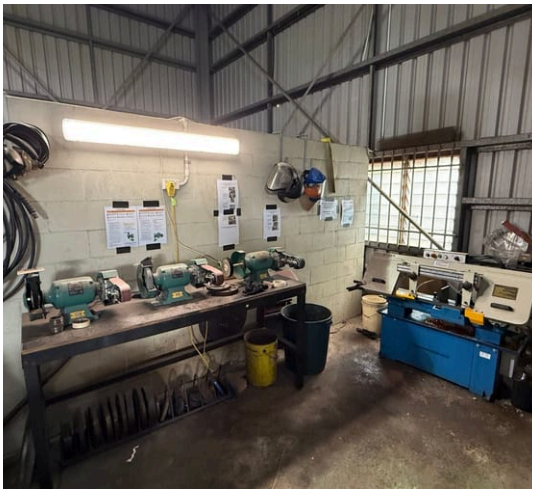
For procedures that call for it, coupons are preheated and heat treated to the WPS: flexible ceramic pads run from our heat treatment unit, or our programmable kiln (up to 1200 °C), with thermocouples on the weld and the cycle recorded.

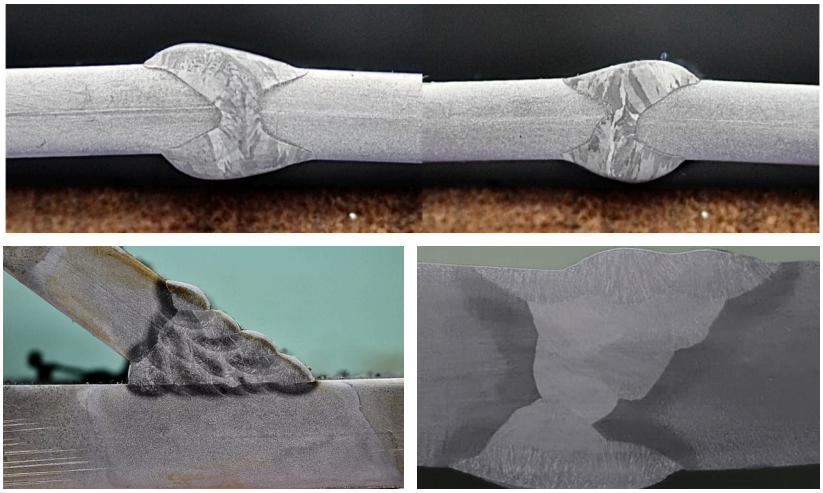


Example cycle. The WPS and the code set the temperatures, rates and soak time.

MACRO PREPARATION IN-HOUSE

Coupons are sectioned on the bandsaw, ground and linished at our macro prep station, then etched to show fusion, penetration and weld profile.





Etched macro sections: butt welds (top), multi-run fillet and double-V butt (below).

EVERY COUPON TESTED

VISUAL, RADIOGRAPHY, MACRO OR FILLET BREAK.

VISUAL

Every coupon, to the standard's acceptance criteria, before anything else.

RADIOGRAPHY

Butt coupons X-rayed in our own radiation bay, with a full RT report.

MACRO

Sectioned and etched to show fusion, penetration and profile.

FILLET BREAK

Fillet coupons broken open to check root fusion and soundness.

Fillet coupons: fillet break or macro, your choice. **Butt coupons:** radiography in our own bay, so results don't wait on an outside lab.

OUR PEOPLE

SUPERVISED AND SIGNED OFF BY QUALIFIED INSPECTORS.

Every test is supervised and every coupon assessed by a qualified welding inspector. The same people inspect fabrication and in-service welds, so they know what the code asks of a production weld.

CSWIP 3.1
Welding Inspector

CSWIP 3.2
Senior Welding Inspector

IWI LEVEL 2 & 3
International Welding Inspectors

CBIP LEVEL 3
Welding Inspector

CERT 10
Welding Supervisor (AS 2214)

IIW IWS
International Welding Specialist

HOW A QUALIFICATION RUNS

01
REVIEW
We read your WPS and PQR pack and plan the coupons.

02
WELD
In our bays, supervised, with preheat and PWHT if the WPS needs it.

03
TEST
Visual on every coupon, X-ray on butts, fillet break or macro on fillets.

04
CERTIFY
A record for each welder, listing every WPS and the range covered.

05
KEEP
Films, macro photos and records kept on file for your audits.

WELD PROCEDURES
Development of new welding procedures, review of existing ones, and repair procedures when a weld needs fixing.

WHAT WE SUPPLY
Bays, welding machines and consumables. We would prefer you to supply the test coupons; if you would rather we sourced them, they are charged at cost plus 15%. Welders bring their own powered-air helmet and gloves.

WHAT YOU GET

QUALIFICATION RECORDS	RANGE OF QUALIFICATION	TEST RESULTS	TWO PRICES
One per welder, to the standard tested	Processes, positions, thickness and diameter covered	Visual, RT report and films, macro photos	Every WPS, or the reduced coupon set

NEED WELDERS QUALIFIED BEFORE THE JOB STARTS?

Swift reporting, round the clock.

NATA 12303 | ISO 9001 | CSWIP | IIW | CERT 10

PHONE
08 8947 4403

EMAIL
admin@dits.net.au

OFFICE
DARWIN, NORTHERN TERRITORY

DITS.NET.AU