



Rules for the Certification of Permanent Joining Operators

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Technical Rules

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CHAPTER 1 – GENERAL

1.1

These Rules define any supplementary and/or substitutive procedures, applied by RINA for certification of permanent joining operators, in relation to the requirements of the General Rules for the Certification of Persons RC/C 85.

The paragraphs of these Rules refer to (and keep the same numbering of) the corresponding paragraphs of the General Rules for the Certification of Persons which were subject to any changes and/or integrations.

CHAPTER 2 – DEFINITIONS

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

CHAPTER 3 – REFERENCE STANDARDS

3.1

The standards applicable to the above certification are UNI EN ISO 9606 series, UNI EN ISO 13585, UNI EN ISO 14732, UNI EN ISO 25239 series, UNI EN ISO 15618 series, UNI EN 13445 series; if requested by the applicant Organisation, RINA will have the right to perform the same personnel qualification activities in conformity with other recognized standards.

The certification process of permanent joining operators is in compliance with standard UNI CEI EN ISO/IEC 17024:2012 General requirements for Bodies providing certification of persons.

CHAPTER 4 - REQUIREMENTS FOR ADMISSION TO EXAMINATION

4.1

Any Organisations that wish to obtain the above certification for their own personnel must send a specific request by fax, mail or e-mail with at least the following information:

- a) Organisation's name;
- b) reference standard;
- c) number of persons to qualify;
- d) welding procedure;
- e) base metal;
- f) base metal thickness;
- g) welding position
- h) if needed, verification of job knowledge

After a preliminary examination to check completeness of the information provided by the Organisation, RINA will prepare a service proposal that will be sent together with these Rules.

CHAPTER 5 - ASSESSMENT AND CERTIFICATION PROCESS

5.1

Upon reception of the acceptance of the above service proposal, RINA will send a written confirmation to the Organisation for the acceptance of the application.

The Organisation's application and relevant acceptance by RINA are the formal contract regulating RINA operations carried out in accordance with these Rules.

RINA reserves the right to request and examine, at its discretion, any other documents, as an integration and support to the information received from the applicant Organisation, deemed to be important for the above certification.

RINA will inform the Organisation about the names of the technician(s) in charge of the examination for the qualification of permanent joining operators; the Organisation may object to the appointment of these technicians, justifying the reasons for the objection.

5.2

The requesting Organisation undertakes to make available to RINA measuring instruments appropriately calibrated and provided with a calibration report; this applies in particular to the instruments necessary for measuring electrical parameters and the pre-heating or interpass temperature (when the temperature is considered an important parameter in relation to the procedure and the materials used).

After the practical test performed by the operator (visual test) is successfully completed, the RINA technician will proceed with the permanent and unique identification (e.g. punching) of the samples subject to permanent joining for any subsequent destructive and/or non-destructive tests.

Destructive tests shall be carried out at an accredited laboratory in accordance with the ISO 17025 standard; if the laboratory is not accredited RINA will take part in the conduction of any destructive tests.

With regard only to fracture, bend and macro tests, they can be carried out at the Organisation's premises in the presence of a RINA technician, provided that the Organization has the necessary suitable equipment (e.g. press, acid solutions, polishing tools, etc.).

The verification of the 'Functional knowledge' required by the EN ISO 14732 standard is always carried out by the Rina technician in accordance with the requirements of Annex A of EN ISO 14732.

In the event of a request by the Organization for the verification of job knowledge, the methods set out in the individual technical reference standards will apply.

By way of example, for the EN ISO 9606 series standards, the verification of technical knowledge is carried out with one or a combination of the following methods:

- a) objective written tests (multiple choice)
- b) oral exams based on a list of written questions
- c) computer test
- d) demonstration/observation test based on a written list of topics

The standard method of verification of any technical knowledge required adopted by Rina is that corresponding to point d), unless otherwise expressly requested by the Organization.

CHAPTER 6 - ISSUE OF CERTIFICATES

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

CHAPTER 7 - VALIDITY OF CERTIFICATES

7.1

The validity period of the Certificate is set out in the various standards (UNI EN ISO 9606-1/-2: p. 9; UNI EN ISO 9606-3/-4/-5: p. 10; UNI EN ISO 13585: p. 9; UNI EN ISO 14732: p. 5) starting from the date established in the reference standard, provided that it is signed every six months by the employer (also temporary) or supervisor who verifies that the following conditions are satisfied:

- a) the permanent joining operators must carry out the permanent joining activity (e.g. welding and/or brazing) for which he/she is qualified on a regular basis; no interruptions are allowed for a period greater than six months;
- b) the permanent joining personnel's work must usually be in accordance with the permanent joining conditions used in the qualification test;
- c) there must be no specific reasons to cast doubt on the skills and technical knowhow of permanent joining operators.

In the presence of permanent joining operators who operate in accordance with PED Directive 2014/68/EU and who must be certified in accordance with standards other than the ones specified here above, the qualification certificates shall be issued by RINA and their validity shall comply with the reference harmonized standards considering only the case in which tests shall be repeated.

CHAPTER 8 – MAINTENANCE OF CERTIFICATES

The method of maintenance of the validity of certifications for permanent joining operators are those required by reference standards and are under the responsibility of the responsible of the welding activities of the Organization

CHAPTER 9 - RECERTIFICATION

9.1 PROLONGATION OF CERTIFICATION

The method of renewal of certifications for welders and welding operators is assumed by default to correspond to the renewal method 9.3.a (EN ISO 9606-1), 9.2 (EN ISO 9606-2), 5.3.a (EN ISO 14732) or 9.1 of EN ISO 13585 etc.; the same renewal methods are also assumed for certifications issued in accordance with ASME IX with PED approval. Different choices must be expressly requested by the requesting Organizations.

The validity of a Certificate of Qualification can be extended as set out in the various standards (UNI EN ISO 9606-1/-2: p. 9; UNI EN ISO 9606-3/-4/-5: p. 10; UNI EN ISO 13585: p. 9.2; UNI EN ISO 14732: p. 5) within the limits of the validity range of the initial qualification, provided that the conditions under p. 7.1 are satisfied together with the following requirements applicable to all the standards mentioned in these Rules:

- a) the Organization (employer) of the permanent joining operator has not changed;
- b) the quality of permanent joints produced by the permanent joining operator is as requested;
- c) any evidence concerning the tests, such as the documentation relevant to radiographic or ultrasonic tests or fracture test reports, conducted in the last six months before the expiry date, are annexed to the Certificate of Qualification of the Welder/Brazer/Welding Operator issued by RINA.

Subject to the positive outcome of the aforementioned checks, generally performed at the Organisation's premises, RINA will grant an extension of validity and sign the relevant Certificate of Qualification in the specific validation spaces.

If the Organisation does not observe the above procedure for the extension of the validity of the Certificate of Qualification, the Welder/Welding Operator can be qualified again in accordance with the procedure laid down in Chapter 4.

In the presence of permanent joining operators who operate under PED Directive 2014/68/EU and who must be certified in accordance with standards other than those specified above, the certificates of qualification will be extended by RINA and their validity shall comply with the specific requirements of the reference harmonized standards only following the repetition of the tests.

CHAPTER 10 - TRANSFER OF CERTIFICATES

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

CHAPTER 11 - SUSPENSION, REINSTATEMENT, REDUCTION AND REVOCATION OF CERTIFICATES

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

CHAPTER 12 - ENROLLMENT IN THE REGISTER OF CERTIFIED PERSONS

Not applicable.

CHAPTER 13 - USE OF RINA CERTIFICATION LOGO

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

CHAPTER 14 - MANAGEMENT OF COMPLAINTS AND APPEALS

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

CHAPTER 15 - CONTRACTUAL CONDITIONS

The provisions of the General Regulation for the certification of Persons RC/C 85 apply.

ANNEX 1 – REQUIREMENTS TO BE FULFILLED TO EXTEND THE VALIDITY OF CERTIFICATES OF QUALIFICATION OF WELDERS/WELDING OPERATORS AS REFERRED TO IN P. 9.3 c) OF THE UNI EN ISO 9606-1 AND UNI EN ISO 14732 STANDARDS

In accordance with Accredia Circular no. 21/2021, in order to proceed with the extension of the validity of the Certification, it is a mandatory condition that the Organization is in possession of a certification issued in accordance with the EN ISO 3834-2 or EN ISO 3834-3 standard by Rina Services.

Furthermore, the following requirements must have been met:

- a) the permanent joint operator must work for the same Organization for which he was originally certified, responsible for the manufacturing of the product
- b) the manufacturer has documented that the permanent joint operator has produced acceptable permanent joints according to the applicable quality requirements based on the application standards.

The examined joints must confirm the following conditions:

- welding positions
- type of joint (BW, FW)
- backing (nb, gb, mb)

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