



General Rules for the Certification of Persons

Specific Requirements for the Certification of Persons

Welders of polyethylene pipes and fittings

1. GENERAL

This document defines any supplementary and/or substitutive procedures applied by RINA to the certification of Welders of polyethylene pipes and fittings, with reference 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.

This document defines the requirements and modalities for the certification of Welders in accordance with the UNI 9737 and EN 13067 standards.

2. DEFINITIONS

CdA: Training Centre recognized by RINA

Examination Board: a Body made up of one or more examiners, qualified by RINA

In addition to the above definitions, reference should be made to the definitions under p. 2 of document RC/C 85 and the UNI 9737:2021 and EN 13067:2021 standards.

3. REFERENCE DOCUMENTS

- General Rules for the Certification of Persons, RC/C 85, issued by RINA Services SpA
- UNI 9737:2021
- EN 13067:2021

4. EXAMINATION ADMISSION REQUIREMENTS

In order to start the certification procedure, the candidate shall provide the evidence, depending on the selected standard, of meeting one of the following requirements:

UNI 9737:

- 1- the candidate must have completed an apprenticeship period, provided by a manufacturer of components for polyethylene piping systems, on the welding processes described in this standard, with special reference to those processes for which the Welder requests certification; to provide the evidence of the fulfillment of this requirement the candidate must submit a manufacturer's declaration attesting the above apprenticeship;
- 2- during the last four years, the candidate must have worked for at least two years (equal to a total of 730 calendar days) as a welder of plastic materials; to provide the evidence of the fulfillment of this requirement the candidate must submit an employer's declaration, in compliance with the applicable laws and with annex C of the UNI 9737 standard, which contains at least the following elements:
 - a. name, surname, date and place of birth of the welder;
 - b. the jobs carried out with reference to the activities described in this standard;
 - c. the start date and end date of said jobs;
 - d. the Purchaser/Client.
- 3- the candidate must have attended a training course provided by a training centre operating in conformity with the requirements of appendix A; to provide the evidence of the fulfillment of this requirement the candidate must submit:
 - a. a certificate attesting participation in a training course as per p. B.7, Appendix B of the UNI 9737 standard;



- b. a report on the welding tests performed during the course, in accordance with p. B.4, Appendix B of the UNI 9737 standard.

EN 13067:

1. The candidate must have completed an apprenticeship period as plastic material operator
2. The candidate must have acquired at least two years of experience as plastic welder, and must provide the evidence of this experience by submitting an employer's declaration
3. The candidate must have completed a theoretical and practical course to prepare for the qualification test of plastic welders

5. ASSESSMENT AND CERTIFICATION PROCESS

To be admitted to the certification process, a candidate shall provide RINA with the "Application" form duly filled in and complete with all requested annexes; upon receiving the documentation, RINA checks for its completeness and reserves the right to request and examine further documents/additional information, as an integration and support to the previously received information.

If the examination result is positive, RINA shall inform the candidate of the start of the certification procedure and the examination date together with the relevant Examination Board (qualified by RINA according to its own instructions).

The candidates and the examination board will be present at the examination, which will be held at one of the CdA recognized by RINA or at another suitable centre.

The examination shall be generally held in one day, except in the presence of a high number of candidates and/or special agreements with the Examination Board.

Before the examination starts, the Examination Board shall check that each candidate:

- shows a valid identity document,
- signs the "List of Attendees" sheet, which is previously provided by RINA to the examination board.

The examination test consists of a theoretical and a practical test as indicated in the p. 5 of the UNI 9737:2021 and EN 13067:2021 standards.

Theoretical test: a questionnaire with at least 20 multiple-choice questions, defined in accordance with the requirements of the topics defined in the p. 5.3.2 of the EN 13067 standard and the subgroups for which certification is requested; it is possible to add more questions if the candidate applies for further welding processes (5 questions for each welding process listed in table 3 of the EN 13067 standard, up to a maximum of 45 questions). The maximum time allowed for the 20 questions theoretical test is one hour; 3 minutes are allowed for any further question.

The above questions are randomly selected from RINA's set of questions.

The theoretical test is successfully completed, with the subsequent admission to the practical test, if at least 80% of the answers are correct.

Practical test: it consists of producing a specimen as defined in the p. 5.2 of the EN 13067 standard, considering the subgroup or class for which certification is sought. The materials to use during the practical test must comply with the reference technical rules; conformity (CE marking) is verified by the examiner. The welding times, which are determined by the technical sheets of the machines according to the specific process, must be increased with the times required for cleaning and milling the parts to weld, calculated each time by the examiner. The quality of the welded specimen is verified by a visual and dimensional check. If deemed to be good, the specimen, which must show the names of the examiner and the candidate, shall be subject to the destructive tests envisaged by the reference standard, in structures operating in accordance with the UNI CEI EN ISO/IEC 17025 standard, chosen by RINA or by the Client. The practical test is deemed to be successfully completed if the requirements of each of the assessment sections are satisfied (refer to p. 8 and p. 10 of EN 13067:2021). To obtain the requested certification, the welder must have completed both the theoretical and the practical tests.



If any of the examination tests is not successfully passed, the candidate can repeat said test(s) during a subsequent examination session after attending a further training course, within one calendar year; if this term is exceeded, the candidate shall repeat the entire examination.

6 – ISSUE OF CERTIFICATES

The result of the Examination Board assessment is sent to RINA for an independent check and the decision about certificate issue; if the assessment result is positive, RINA issues, for each examined candidate, a specific certificate with a validity of 2 years that attests that the candidate has successfully passed the assessment examination.

7 – CERTIFICATION VALIDITY

The period of validity of the certificate issued by RINA is two years. Extendable for a further 2 years, provided that the requirements established in the following chapter 8 are met.

8 – CERTIFICATION MAINTENANCE AND EXTENSION

The validity of the certification obtained is subject to the maintenance of the following requirements:

- the welder must perform the welding activity for which he/she is certified on a regular basis (no interruptions for a period greater than six months are allowed);
- there are no specific reasons to question the welder's ability and technical knowledge;
- every year the manufacturer confirms the physical fitness of the welder, with reference to certification conditions.

Within the expiry date of the Certificate, preferably with a certain advance (not less than two months), the person who intends to request an extension of the validity must provide RINA with the "Application" form duly filled in and complete with the following annexes:

- expiring certificate with the six-monthly signatures attesting uninterrupted working activity
- annual declarations stating the welder's fitness

Upon successful completion of the verification above, carried out within the expiry of the certificate, RINA will issue a new certificate certifying the extension of the validity of the previous one; if these conditions are not satisfied, it is necessary to start a recertification process.

If any claims or legal disputes arise, RINA will evaluate their management and decide whether to maintain, suspend or revoke certification.

9 – RECERTIFICATION

Within the expiry date of the extended Certificate (4 years), preferably with a certain advance (not less than two months), the person who intends to renew certification must provide RINA with the "Application" form duly filled in. The certified person shall repeat the tests under p. 13.2 of the EN 13067:2021 standard.

The certified person must satisfy the provisions of chapter 4 and carry out the entire exam, as described in chapter 5.

If any claims or legal disputes arise, RINA will evaluate their management and decide whether to maintain, suspend or revoke certification.

RINA informs the candidate of the assessment result and, if positive, extends the certificate validity for 2 more years.

9.1 – TRANSFER OF CERTIFICATES TO A DIFFERENT ORGANIZATION

RINA can transfer a Welder's Certificate to an Organization different from the one that requested and obtained the Welder's certification if the latter provides a written authorization.

10 – TRANSFER OF CERTIFICATES FROM/TO ANOTHER CB

The requirements set out in the General Rules for the Certification of Persons RC/C 85 apply.



11 - SUSPENSION, REINSTATEMENT, REDUCTION AND REVOCATION OF A CERTIFICATE

The requirements set out in the General Rules for the Certification of Persons RC/C 85 apply.

12 - ENROLLMENT IN THE REGISTER OF CERTIFIED PERSONS

The requirements set out in the General Rules for the Certification of Persons RC/C 85 apply.

13 - USE OF CERTIFICATION LOGOTYPES

The requirements set out in the General Rules for the Certification of Persons RC/C 85 apply.

14 - MANAGEMENT OF CLAIMS

The requirements set out in the General Rules for the Certification of Persons RC/C 85 apply.

15 - CONTRACTUAL TERMS AND CONDITIONS

The requirements set out in the General Rules for the Certification of Persons RC/C 85 apply.