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## BUILDINGS BULLETIN 2015-037

### OTCR

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**Supersedes:** [Pipe Welder Qualification Service Update 10/21/2015](#)

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Director, Office of Technical Certification and Research

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**Effective Date:** March 22, 2016

**Purpose:** This document establishes qualification criteria and submittal requirements for approved pipe welder qualification agencies and the welder's employer.

**Related Code/Zoning Section(s):**

MC	1210.2.2	1 RCNY	101-07
FGC	406.1.1.1		

**Subject(s):** Gas piping systems, welder; High pressure steam piping systems, welder; Pipe welder, approved pipe welder qualifying agency; Pipe welder, qualification criteria

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Welding of gas or high pressure steam piping systems must be performed by welders qualified for all ranges and welding variables in accordance with the NYC Construction Codes Sections MC 1210.2.2 or FGC 406.1.1.1, and Section IX of *ASME Boiler and Pressure Vessel Code*.

#### A. Submittal Requirements for Approved Pipe Welder Qualifying Agencies

Approved pipe welder qualifying agencies shall be approved in accordance with 1 RCNY 101-07 Section (C)(8) and shall comply with the following:

- Required documents.**
  - Initial approval. Approved pipe welder qualifying agencies must submit all welder qualification reports (WQR's), and continuity records as required in accordance with Section (B)(1) of this bulletin.
  - Requalification. Approved pipe welder qualifying agencies must submit all requalification documents as required in accordance with Section (B)(3) of this bulletin.
- Submittal Address.** Forward all submittal requirements to [OTCR@buildings.nyc.gov](mailto:OTCR@buildings.nyc.gov).
- Frequency.** Approved pipe welder qualifying agencies must submit the above referenced required documents twice monthly: on the 1<sup>st</sup> and 15<sup>th</sup> of each month.
- Approval.** The Department will review all qualification reports submitted as required above. Approved agencies will be notified if a qualification report is not accepted. A list of approved welders will be published on the Department's website.

#### B. Welder Qualification Criteria

Qualified pipe welders must comply with the following:

- Proof of Qualification.** The following items are required to demonstrate proof of pipe welder qualifications:

- a. **Welders Qualification Report (WQR)** –Include all information indicated on the QW-484, along with:

<b>Approved Agency information:</b>	<b>Contractor/Employer information:</b>
Agency Name	Company Name
Name of CWI who witnessed weld test	Contractor representative witnessing weld test
CWI Certification Number	Representative signature
CWI Signature	Date of welder qualification
CWI Stamp	
Date of welder qualification	

- b. **Continuity Record.** Continuity records must be maintained by the welder’s employer and shall demonstrate that the pipe welder has performed welding work within the last 6 months, as required.
2. **Date of Qualification.** The date of qualification, as indicated on the WQR, must pre-date any pipe welding activity performed on the project. If a production weld is used for qualification as per ASME Section IX, QW-304.1, then the qualification date may coincide with the welding activity.
3. **Requalification.**
- a. Gas Pipe Welders – must obtain requalification from an Approved Agency every year in accordance with Section FGC 406.1.1.1.
  - b. High Pressure Steam Welders – must obtain requalification from an Approved Agency every 5 years in accordance with Section MC 1210.2.2.
4. **Unacceptable Qualifications.** The following are not acceptable forms of proof for demonstrating pipe welder qualification:
- a. A Department of Buildings Structural Welder License
  - b. Welder certification from a utility
  - c. A WQR from an agency not approved by the Department of Buildings
5. **Transfer of Welder Qualifications.** Qualified welders do not need to obtain requalification when changing employers if:
- a. all employers belong to participating organizations, and
  - b. the employing organization verifies welders continuity by previous employer since qualification date.
6. **Verification of Welder Qualifications.** It is the responsibility of the permit holder to verify the qualifications of pipe welders prior to any welding. A list of approved welders will be published on the Department’s website.