



Department of Development Services Building Division

4701 W Russell Rd. • Las Vegas NV 89118
(702) 455-3000 • Fax (702) 221-0630

Ronald L. Lynn, Director/Building Official • Gregory J. Franklin, Assistant Director

LETTER TO INDUSTRY

Revised February 27, 2009

WELDER QUALIFICATION RECORD (WQR) UPDATE

The American Welding Society Structural Welding Code-Steel (AWS D1.1) addresses a welder's and welding operator's qualification record "Period of Effectiveness." Section 4, Paragraph 4.1.3 of the AWS D1.1-08 Welding Code states that a WQR shall be considered as remaining in effect indefinitely unless (1) the welder has not engaged in a given welding process, that the welder is qualified in, for a period exceeding six (6) months, or (2) there is a reason to question the welder's ability.

Previously, it was acceptable to have the welding inspector on the project sign and/or stamp the back of the WQR to verify that a welder was without a lapse of greater than 6 months for a qualified welding process. The problem with this reporting method is that accountability is lacking for this type of WQR update. In many cases, the signatures are illegible due to the age of the WQR, poor copy quality, or damaged WQR originals. With all the technical advances made in the last 10 years, it is not a difficult task to create a WQR that would indicate that this requirement has been met.

A WQR is intended to serve as an official document to identify the welder's ability to produce welds meeting a prescribed standard. A WQR, like any other official document, must identify who is verifying and attesting to the welder's ability. As defined by Webster's II Dictionary, a Record is "an account officially written and kept as evidence or testimony." It is for this reason that some accountability is needed for attesting to a welder's continued service, without a lapse greater than 6 months, for a given welding process.

The Clark County Department of Development Services-Building Division (CCDDS-BD) requires the welder to provide documentation addressing the Period of Effectiveness requirements. This documentation shall show that the welder has not had a lapse in welding, greater than six months for the welding process qualified. If it is determined that a time period of greater than six (6) months has lapsed, the welder shall be re-tested in accordance with AWS D1.1 Section 4 Paragraph 4.32.

A welder's WQR period of effectiveness requirement, for welders performing field welding, shall be documented by one of the following CCDDS-BD approved reporting methods:

1. A welder who's Welder Qualification Record (WQR) period of effectiveness requirement has not been documented or can't be verified shall re-test (Reference AWS D1.1 Section 4.32) at a testing agency, and a new WQR shall be issued, upon an acceptable re-test. The testing agency shall issue a new WQR that shall be stamped and signed by the testing agencies American Welding Society Certified Welding Inspector (AWS/CWI).
2. A welder who is employed by a contracting company shall have his/her original WQR updated by the welder's current employer. The employer shall attest to the entire period of time covered, commencing from the original WQR date to the present date. The WQR update letter

(*Sample Attached*) shall be on the company letterhead and shall be signed by a company official. All of the attachments requested on the sample update letter shall be provided.

3. A union welder who has obtained their WQR from a CCDDS-BD approved testing agency or by an out of state testing agency shall have his/her WQR updated by the same testing agency. The testing agency shall attest to the entire period of time covered commencing from the original WQR date to the present date. The WQR update letter (*Sample Copy Attached*) shall be on the testing agencies letterhead and shall be signed and stamped by the testing agencies AWS/CWI. All of the attachments requested on the sample update letter shall be provided.
4. A welder who is a union member of Ironworkers Local 433 or a brother of the International Union of Ironworkers shall utilize the ironworkers local training center, located at 2485 Marco Street, Las Vegas, NV for his/her WQR updates and re-testing. Out-of-town union welders shall report to the Ironworkers Local 433 training center to verify all required WQR documentation is in order, prior to performing any welding. Welders holding a WQR from the local training center, or an affiliate training center recognized by Ironworkers Local 433, shall be updated or re-tested by the ironworker's local training center. The ironworker's local training center employs Rick Adams and Scott Vick, both of whom are AWS/CWI accredited. The original WQR shall be accompanied by his/her "Continuity Log Book" (Blue Book) not to be confused with the "National Ironworker Continuity Log Book" (Tan or Light Grey Book). The Blue Book contains the written update information stamped and signed by one of the ironworkers local training center CWI's, verifying the welders "Period of Effectiveness". The ironworker's local training center will not update a WQR that was issued by a testing agency or an affiliate ironworker training center not recognized by Ironworkers Local 433.
5. A welder who is a self-employed individual shall use the WQR update letter (*Sample Copy Attached*) and attest to the entire period of time covered commencing from the original WQR date to the present date. The letter shall be on his/her company letterhead and signed by the individual welder. All of the attachments requested on the sample update letter shall be answered. Self-employed individuals shall also include a copy of their current State Contractors Board wallet card.

CCDDS-BD approved third party inspection/testing agencies, providing special inspections in accordance with a CCDDS-BD Quality Assurance Agreement (QAA), shall maintain in alphabetical order legible copies of the WQR Card (Front & Back Sides), WQR update letter(s) or a copy of the union ironworkers "Blue Book Continuity Log" in the agencies project file. The agency shall complete the CCDDS-BD WQR Verification form (*Copy Attached*) for all welders performing welding on the project and shall include a copy of this form in the agencies final QAA report in accordance with CCDDS-BD TG-50.

Please feel free to contact me at (702) 455-8089 if you have any questions regarding this issue.



Mark J. Hayes
Building Inspection Specialist

Attachments: Sample Copy of WQR Update Letter - Form 846
Copy of WQR Verification - Form 829



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WELDER QUALIFICATION RECORD (WQR) VERIFICATION

QAA Company _____ **Project Name** _____

Project Address _____ **Permit Number** _____

Company performing the welding _____

| Welder Name | Qualified Welding Process | Qualified Thickness & Position | Original Qualification Date | Update Letter Rec'd Date |
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The inspector shall review all Welder Qualification Records (WQR) to verify that the welder is qualified to weld using the welding process qualified, the joint types, materials and material thicknesses specified in the approved project plans. The inspector shall also review welder documentation to verify that the welder's qualification is current and is in accordance with the applicable AWS welding code. The inspector certifies, by signing and dating this form, that he or she has reviewed and verified the WQR information is complete and in compliance with Clark County codes and the applicable AWS welding code.

Inspector Name _____ Signature _____ Date _____

***Note:** This form shall be included in the QAA's final report. WQR documents are not required to be included in the QAA's final report, but are required to be maintained in the QAA's project files for future reference.*

