



Step 1		
Research I.S. EN 1090 -1 <ul style="list-style-type: none"> Legislation Find Execution Class relevant to you 	→	Under the Construction Products Regulation (CPR) CE marking of structural steelwork to I.S. EN 1090-1 has become mandatory <ul style="list-style-type: none"> All Buildings must have an assigned certifier Requirement on all Public Contracts
Step 2		Action
Factory Production Control (FPC) <ul style="list-style-type: none"> Employee qualifications Equipment calibration and maintenance Structural design capabilities Purchasing specifications Fabrication controls and checks Treatment of non-conforming products Welding Quality Management System 	→	The Welding Quality Management System (WQMS) should comply to the standard as specified in I.S.EN 1090-2 2008 Section 7. 1. Welding. EN ISO 3834: 2005 The Welding QMS covers: <ul style="list-style-type: none"> Materials Control Welders Inspection Welding Equipment Technical review Sub Contract Traceability There may be similar companies in your area who may be interested in group training from a consultant at a reduced rate. Contact your Local Enterprise Office which may be able to assist (www.localenterprise.ie).
Step 3		Action
Staff Training: Responsible Welding Coordinator (RWC) EN ISO 14731 2006 <ul style="list-style-type: none"> Technical Review Sub-contracting Certification of welding personnel Equipment Production Planning Inspection testing, before, during and after welding Identification and traceability Quality control management Qualification of the welding procedures Welding procedures specifications Work instructions Welding consumables Materials Testing Welders must be qualified to IS EN ISO 9606 <ul style="list-style-type: none"> Product type(plate or pipe) Type of Weld(butt or fillet) Filler material grouping Welding Positions Weld Details. Dimensions Visual Weld Inspection	→	RWC Training courses are 2-3 days duration and can be sourced through commercial companies, alternately there may be limited availability via Education Training Boards (ETBs) (www.etbi.ie) or Skillnets: <ul style="list-style-type: none"> TechNorth West Skillnet IIE Manufacturing Skillnet Details of these networks and links to the courses are: TechNorthWest Skillnet http://www.skillnets.ie/network/tech-north-west-skillnet Course http://www.skillnets.ie/courses/tech-north-west-skillnet/responsible-welding-coordinator IIE Manufacturing Skillnet http://www.skillnets.ie/network/iie-manufacturing-engineering-skillnet http://www.skillnets.ie/courses/iie-manufacturing-engineering-skillnet/responsible-welding-coordinator-and-visual-inspection
	→	Further training opportunities may arise depending on demand from industry sectors for training in new areas. Irish Association of Steel Fabricators (IASF) can also advise (www.irishsteel.com).
	→	To achieve the CE Mark a visual weld inspection is performed on each type of weld. Contact IASF for testing providers.
Step 4		Action
Drafting Welding Process Specification (WPS)	→	In order to be certified, a producer must have a Welding Procedure Specification (WPS) in which all the welding steps of an assembly are listed i.e. welding parameters, passes, gas, consumables etc. Each WPS must be qualified by a test laboratory and every welder who welds to the procedure must be qualified to do so (contact IASF for testing providers).
Step 5 (Final Step)		Action
NSAI Apply to NSAI for audit and Certification after implementation of 4 steps above <ul style="list-style-type: none"> Application Assessment – stage 1 Assessment – stage 2 Certification 	→	The National Standards Authority of Ireland (NSAI) is a notified body which can carry out the necessary audits to ensure that you can legally place your products on the market. Compliance with all areas of the audit is required for certification to be awarded. The I.S.EN 1090 certification will give the right to use the CE marking on all the metallic products that the factory want to commercialise in the Europe Union (http://www.nσαι.ie/Steel-Fabrication-CE-Marking.aspx).