

## **Registration Requirements for Weld Procedures**

**IP-2008-07-001**

### **Application Process**

As per *The Boiler & Pressure Vessel Act*, a person who intends to construct, alter or repair a boiler, pressure vessel, fitting or pressure piping system by welding must apply for registration of the welding procedures by:

1. Filling out TSK-2017 Application for the Registration of a Weld Procedure.  
Ensure the contact information is complete and accurate for your organization.
2. Include two hard copies of welding procedure specifications, supporting procedure qualification records, and copies of the destructive testing results.
3. Submit the base fee for review (see fee schedule) .  
TSK-0003 Client Authorization Payment Form details all the acceptable forms of payment.

If the welding procedure is accepted for registration, a copy of the procedure bearing the registration number will be returned to the person who submitted it for registration. Please be aware that the ANSI/AWS Standard Weld Procedures may be accepted for registration without review provided they have still been registered for use. See page 2 for additional information.

The forms and payment can be couriered, mailed, or dropped off in person to the addresses below.

Technical Safety Authority of Saskatchewan  
2202 2nd Ave.  
REGINA SK S4R 1K3

For more information, visit our website at [www.tsask.ca](http://www.tsask.ca) or contact our office at:

Phone: 306-798-7111 or Toll Free: 866-530-8599  
Fax: 306-787-9273 or Toll Free Fax: 866-760-9255

## **A. REQUIREMENTS ASSOCIATED WITH WELD PROCEDURE REVISIONS**

In order to make revisions to a welding procedure specification, the following conditions must be satisfied.

As per the ASME Section IX Code clause QW-200.1(c), changes to a welding procedure specification (WPS) are allowed under the following conditions:

- Changes may be made to nonessential variables without re-qualification provided such changes are documented.
- Changes in essential or supplementary essential variables when required require re-qualification of the WPS. New or additional procedure qualification records to support the changes are required.

As per the ASME Section IX Code clause QW-200.2(c), changes to a procedure qualification record (PQR) are allowed under the following conditions:

- Editorial corrections may be made. Note that an editorial correction is where an incorrect variable was indicated. Editorial corrections are not reformatting, company name changes, nor the listing of new or revised WPS references.
- Addendum changes are permitted. An addendum to the PQR is a change resulting from a code change. An example of an addendum change could be the assigning of a new F-number to a filler metal.
- Additional data may be incorporated into a PQR provided that the information is substantiated as having been a part of the original qualification condition by lab record or similar data.
- All approved changes to a PQR require data re-certification by the manufacturer.

Please note that PQRs are a record indicating past history. Effectively they are a record indicating what happened during a particular welding test. Therefore, as a record of past history, it cannot be revised except under the circumstances listed above. The PQR is not a working document where properly detailed revisions may be made on an on-going basis.

## **B. NAME CHANGE REQUIREMENTS**

Where a company undergoes a change in name or a WPS and supporting PQR fall under different ownership than existed during the original procedure qualification, ASME Section IX Code clause QW-201.1 shall be followed. WPSs and supporting PQRs may be used under the new ownership per this clause without re-qualification provided the following conditions are met.

- The new owner takes responsibility for the WPSs and PQRs.
- The WPSs are revised to reflect the name of the new owner and submitted for registration as a revision
- The quality control / quality assurance program reflects the original source of the PQRs

Be aware that a WPS is required to properly reference all supporting PQRs. However, there is no requirement that the PQR properly reference the WPS number and revision level. This allows the owner to develop new WPSs based on existing PQRs without performing improper revisions to the PQR.