



BE A WORLD CLASS MANUFACTURER IN FABRICATION

The Indian Institute of Welding (IIW - ANBCC)

**Introduces to Welding Related Industries
The Survival Strategy for the 21st Century**

In a globalised business environment where the cost and quality competitiveness are increasingly playing the dominant roles, the Indian fabricators using welding should not only be prepared to face more challenges at home from imports of finished fabricated products but also be able to compete overseas in order to grow and sustain their viability.

Manufacturer Certification Scheme – The Quality Requirement for the 21st Century

Many companies have achieved certification to **ISO:9001** for their quality management systems. But where significant use of it towards the **special process** (a process where the conformity to the resulting product cannot be readily or economically verified is referred to as a 'special process') like welding, such certification is unlikely to provide the required demonstration of company capability to manufacture products with the 'required' product quality. In such cases compliance to **ISO:3834** is the recommended solution. The International Institute of Welding (IIW), as a tool for achieving **substantial quality**, has introduced a specific **Manufacturers Certification Scheme (MCS)** referring to **ISO:3834** for world wide implementation.

Introduction to ISO : 3834

Processes such as fusion welding are widely used to manufacture many products. In some companies, they are the key process of production. Products may range from simple assemblies to complex fabrication. Examples include pressure vessels, domestic and agricultural equipment, cranes, bridges, transport vehicles, construction of plants and many such other items. It is important, therefore, to ensure that the operational processes are carried out in the most effective way and that appropriate control is exercised on overall aspects of the operation. *Quality cannot be inspected in to a product; it has to be built in.* Even the most extensive and sophisticated non-destructive testing does not improve the quality of the product.

It is emphasized that **ISO:3834** entitled "Quality requirements for fusion welding of metallic materials" is not a quality management system standard replacing **ISO:9001**, but supplements this. **ISO:3834** identifies measures that are applicable for different situations for fusion welding application.

IIW Manufacturer Certification System Benefits – By Compliance to ISO : 3834

Benefits for Certified Organizations

- ✓ Clear, high profile, independent verification of compliance by the world's leading authority on Welding.
- ✓ Confirmation of welding and fabricating capability and staff competence,
- ✓ Improved client confidence leading to a reduction in external audits.
- ✓ Entry of the company's details on well-publicised International Web site register.
- ✓ Quality management and fabrication capability assessments are carried out by IIW recognised assessors.
- ✓ Increased national and international business potential.
- ✓ Cost savings through reduction of rejection/rework in production.
- ✓ Improved delivery with 'first time right' approach.

- For many products, mandatory requirement for suppliers to EU and many other countries, and also for the sub-suppliers. Facilitates compliance with emerging European and International standards that call up ISO : 3834 namely the EU Directives, and the Harmonised Product Standards.



Who can certify ?

International Institute of Welding (IIW) appoints an Authorised National Body for Company Certification (ANBCC) under its Manufacturers Certification Scheme (MCS) for Compliance to ISO:3834.

IIW-India has obtained accreditation as ANBCC from the International Institute of Welding through its International Authorisation Board (IAB) for the **exclusive rights within India** to operate its MCS for certification of companies for compliance to the requirements of ISO: 3834.



Levels of Certification

ISO:3834 certification can be achieved in 3 levels of quality requirements:



ISO:3834-2: Comprehensive quality requirements



ISO:3834-3: Standard quality requirements



ISO:3834-4: Elementary quality requirements



STEPS TOWARDS CERTIFICATION AS PER ISO : 3834

- ✓ Gap analysis
- ✓ Documentation as per code requirement
- ✓ Awareness Program, including suppliers
- ✓ Finalization of RWC from human resource within the organization or otherwise from external source.
- ✓ Review, decision on new approved suppliers
- ✓ Arrange or identify welding related personnel qualification as per code requirement
- ✓ Certification of welders, certification of inspectors.
- ✓ Qualification of welding procedures
- ✓ Review and upgrade present systems
- ✓ Internal Audit / review of systems as per code requirement
- ✓ Invitation to Certification Body for Certification



How is ISO : 3834 certification achieved?

Steps to be followed

Pre-application Stage

- 1 Step 1** - The intending client sends an enquiry to IIW India ANBCC
- 2 Step 2** - IIW India sends to the client a letter explaining the pre-application stage, information brochure on ISO 3834, a preliminary form (RFQ).
- 3 Step 3** - The client sends back the filled-in RFQ form and request for awareness Programme (optional).
- 4 Step 4** - Based on the data provided by the client, the ANBCC sends to the client a formal techno-commercial offer/agreement for certification the exact scope of work, technical requirements and contract requirements. For implementation of other relevant standard like EN : 15085, EN:1090, EN:13445 etc. and CE making. The client sends back the formal acceptance of the contract.
- 5 Step 5** - The customer sends back filled-in detailed application form and the quality documents along with the applicable fees to ANBCC.

- Establish the base for implementation of other relevant standards like EN:15085, EN:1090, EN:13445 etc. & CE making.



Document Audit

The basic documents such as manuals, work instructions etc. which are submitted along with the application, are reviewed for adequacy. At this stage, more documents may be asked by the auditor as necessary. Only after satisfying about the adequacy of documentation, site audit will start.



N.B. It is often possible to combine undertake adequacy often audit at the discretion of the auditor and if agreed to by the manufacturer.



Corrective action requests

The applicant will be required to take corrective actions within the committed and mutually agreed time for any minor non - conformance found before certification can be granted.

The certification can be granted only after satisfactory closure NCs, as verified by auditor, which may require additional site visit by auditor. If there is any major non-conformance, additional site audit may be required. It is also possible that the audit process will be terminated and the manufacturer has to start the process all over again from application. In case of more than one major non-conformance the case may be closed and fresh application process from client shall start.



Certification :

ANBCC will issue a certificate of registration to the applicant once the corrective actions have been accepted and/ or implemented. The certificate carries a validity of up to five years (max.) from the date of issue.



Surveillance:

During the certificate validity period, surveillance assessments are carried out at an interval of **12 months** (max.) at the end of first, second, third and fourth year of the certificate validity.



Renewal:

The client's quality system is required to be re-assessed for the renewal of certificate. The re-assessment is carried out before the end of the validity period of certificate. The process steps are same as Certification process.



Other Services - Direct or through empanelled experts.

At the discretion of the client, Training can be offered by IIW India - ANBCC in the following areas:



i) Awareness program on ISO:3834 : 1 ----- 1 day



ii) Internal auditor Training on ISO:3834 : 2 ----- 2 days



iii) Auditing of suppliers : 2-3 ----- 2-3 days



iv) Comprehensive Training on implementation of ISO:3834 including the above and gap analysis : 4-5 days ----- 4-5 days



v) Customized modules to suit manufacturers requirement

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IIW India is committed to the cause of supporting the Indian Fabricating industry, a key player in projecting India's manufacturing sector as world class with ability to compete on equal terms with global competitors. ”



“ISO : 3834 Certification”

PROCESS FLOW CHART : STEPS TO CERTIFICATION

