



NCDOL / Boiler Safety Bureau  
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Raleigh, NC 27699  
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## **North Carolina Historic Boiler Welder Qualification**

This document provides information to the individual wanting to be qualified as a Welder on Historic Boilers in the state of North Carolina.

### **Limitations on a Qualified Historic Boiler Welder are:**

- The BSB will be involved with all welding.
- Qualification is limited to **Historic Boilers only**.
- Welding shall be done using a Weld Procedure Specification (WPS) supplied by the BSB.

### **An outline of the process is as follows:**

1. The interested party will contact the BSB.
2. BSB will provide the information required to complete the process.
3. A BSB Inspector will schedule a weld test at your facility.
4. The BSB Inspector will witness the welder during the weld test to verify he/she is following the provided WPS.
5. The Inspector will visually inspect the finished weld.
6. If acceptable, the weld shall be cut into specimens for bend testing. (as specified on the Welder Performance Qualification Test)
7. If you have the means, the Inspector will instruct and witness you performing the bend tests. If not, you may send the finished weld to a facility approved by the BSB to have the tests performed.
8. The Inspector will verify the bends meet the requirements of ASME Section IX.
9. A record of the test will be documented on Form NC-484. You will be supplied a copy for your records.

### **Maintenance of Qualification:**

- A copy of your qualification, as documented on Form NC-484, is required on sight when you are welding.
- You are required to maintain a log or diary attesting to the fact that you have welded, using the welding process for which you are qualified, within the last six (6) months. This log shall be furnished to the BSB upon request.