



# ISO 3834 - QUALITY REQUIREMENT

Welding Requirement



## BCK CONSULTING COMPANY LIMITED

NGUYỄN DUY BIÊN

Quality and Inspection Services

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- Bachelor's Degree in Mechanical Engineering.
- IIW IWE – International Welding Engineer (VN/IWE/00020)
- Conventional NDT methods of VT, MT, PT, RI, PMI.
- CSWIP 3.2.1 - Senior Welding Inspector (TWI #381469)
- ISO 9001:2015 CQI | IRCA Lead Auditor
- ISO 31000 – Risk Assessment.

## Cored services



### Third Party Inspector

- Independent inspector (3rd)
- Vendor inspection
- Second party inspector
- Expediting
- External audit
- Material verification and testing
- Witnessing and endorsing document



### Technical Supports

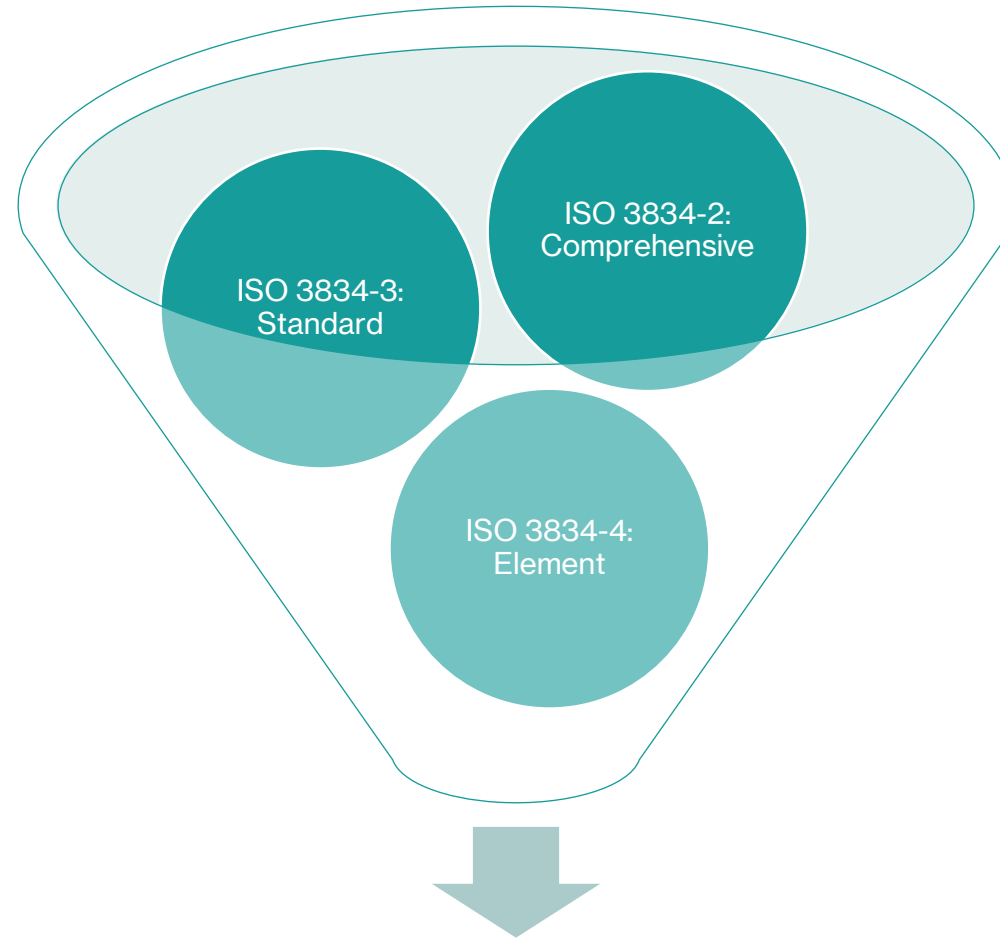
- Engineering supports
- Preparing method statement, procedure/instruction, ITP, other project document to compliance with code/standards
- Filling gap and problem solving
- Review procedure and drawing
- Consulting WPS / PQR / WQT



### Training

- Visual inspection
- Internal/External
- Development procedure and form application
- Reporting
- Quality management system

# ISO 3834 – Selecting Level of Quality Requirement



**Selection Quality Level**

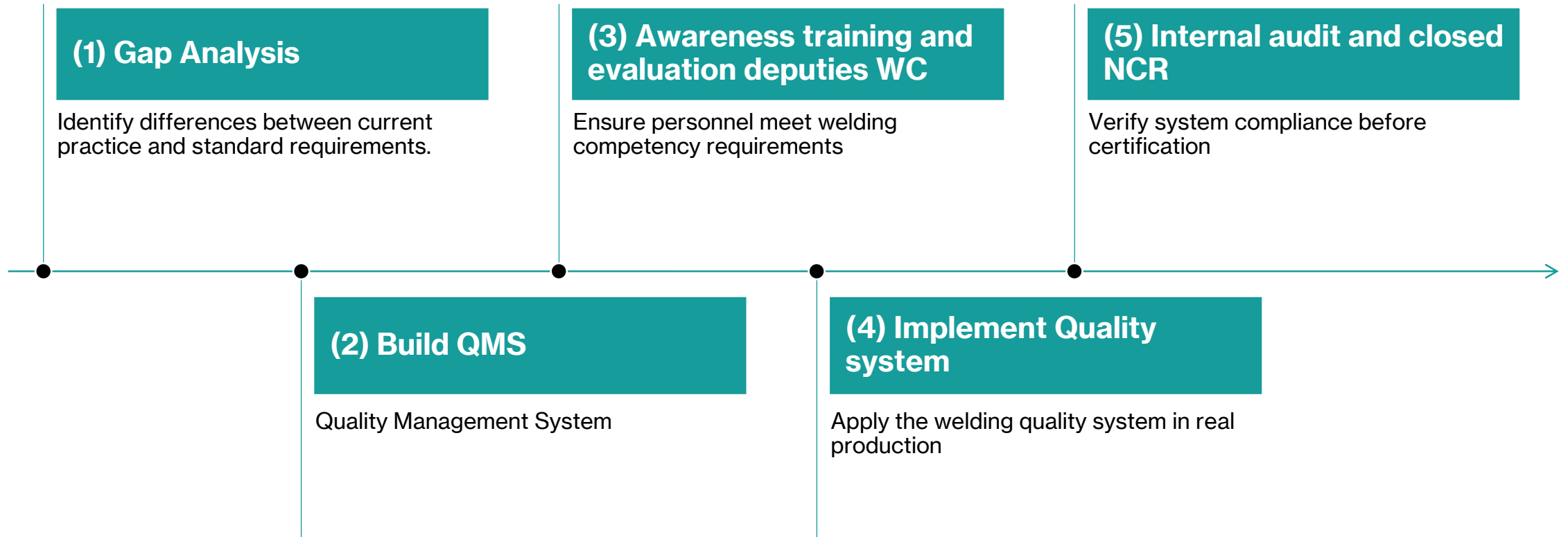
**...a which assist in the selection of ISO 3834-2, ISO 3834-3, ISO 3834-4**

No.	Element	ISO 3834-2	ISO 3834-3	ISO 3834-4
1	Review of requirements	Review required		
		Record is required	Record can be required	Record is not required
2	Technical review	Review required		
		Record is required	Record can be required	Record is not required
3	Sub-contracting/ sub-contractor	Treat like a manufacturer for the specific subcontracted product, services and/or activities. However, final responsibility for quality remains with the manufacturer.		
4	Welders and welding operators	Qualification is required		
5	Welding coordination personnel	Required		No specific requirement
6	Inspection and testing personnel	Qualification is required		
7	Production and testing equipment	Suitable and available as required for preparation, process execution, testing, transport, lifting in combination with safety equipment and protective clothes.		
8	Equipment maintenance	Required to provide, maintain and achieve product conformity		No specific requirement
		Documented plans and records are required	Records are recommended	
9	Description of equipment	List is required		No specific requirement
10	Production planning	Required		
		Documented plans and records are required	Documented plans and records are recommended	
11	Welding procedure specifications	Required		No specific requirement
12	Qualification of the welding procedures	Required		No specific requirement
13	Batch testing of consumables	Required		No specific requirement
14	Storage and handling of welding consumables	If required	No specific requirement	
		A procedure is required in accordance with supplier recommendations		In accordance with supplier recommendations
	Storage of parent material	Protection required from influence by environment. Identification shall be maintained through storage.		No specific requirement

# A quality management system ISO 9001 to complement the ISO 3834 series

- a) control of documents and records (see ISO 9001:2015, 7.5);
- b) management responsibilities (see ISO 9001:2015, 5.3);**
- c) provision of resources (see ISO 9001:2015, 7.1);
- d) competence, awareness and training of operational personnel (see ISO 9001:2015, 7.2, 7.3 and Clause 10);**
- e) planning of product realization (see ISO 9001:2015, 8.2, 8.3, 8.4 and 8.5, and ISO 10005);
- f) determination of requirements related to the product (see ISO 9001:2015, 8.2.2 and 8.2.4);**
- g) review of requirements related to the product (see ISO 9001:2015, 8.2.3);
- h) purchasing (see ISO 9001:2015, 8.4);**
- i) validation of processes (see ISO 9001:2015, 8.4 and 8.5.1);
- j) customer property (see ISO 9001:2015, 8.5.3);**
- k) internal audit (see ISO 9001:2015, 9.2);
- l) monitoring and measurement of product (see ISO 9001:2015, 9.1.3);**
- m) control of externally provided processes, products and services (see ISO 9001:2015, 8.4);
- n) control of production and service provision (see ISO 9001:2015, 8.5.1).**

# Implement



# Documentation

Type of document	Description <sup>a</sup>	Examples of welding coordinator
Procedure	Description of welding-related activity	Description of the role (tasks, responsibilities and authority) of welding coordinator Description of the handling of welding consumables and parent metals Description of how welding procedure tests are carried out Description of how welder's qualification is carried out
Record	Report of welding-related activity	Record from a procedure test (WPQR) Record from a welder qualification test Welding record
Instruction	Description of welding-related operation	Welding procedure specification (WPS) Work instructions
Certificate	Verification of welding-related operation	Welder's qualification test certificate Material test report

<sup>a</sup> Not to be confused with a definition of the terms.

# Documentation

Doc No. Số hồ sơ	Manual / Procedures/ Instructions Sổ tay / Quy trình / Hướng dẫn	Department Bộ phận Chủ quản
1	M01 Quality Management System Sổ tay Hệ thống Quản lý Chất lượng	
2	- Quality Objectives Mục tiêu chất lượng	
3	- Department Quality Objectives Mục tiêu chất lượng	
4	P01 Document Control Procedure Quy Trình Kiểm Soát Tài Liệu	
5	P02 Records Control Procedure Quy Trình Kiểm Soát Hồ Sơ	
6	P03 Sales Process Control Procedure Quy Trình Kiểm Soát Quá Trình Bán Hàng	
7	P04 Non-Conformance and Corrective & Preventive Action Management Procedure Quy Trình Quản Lý Sự Không Phù Hợp, Hành Động Khắc Phục & Phòng Ngừa	
8	P05 Resource Management & Training Procedure Quy Trình Quản Lý Nguồn Lực & Đào Tạo	
9	P06 Management Review Procedure Quy Trình Xem Xét Của Lãnh Đạo	
10	P07 Risk Assessment and Determining Controls Procedure Quy Trình Đánh Giá Rủi Ro & Xác Định Biện Pháp Kiểm Soát	
11	P08 Internal Audit Procedure Quy Trình Đánh Giá Nội Bộ	
12	P09 Welding Coordination Procedure Quy Trình Điều Phối Viên Hàn	
13	P10 Quality Control Procedure Quy Trình Kiểm Soát Chất Lượng	
14	P11 Visual Examination Procedure Quy Trình Kiểm Tra Trực Quan	
P12	Dimensional Inspection and Distortion Control Procedure Quy Trình Kiểm Soát Kích Thước và Biến Dạng	
13	Evaluation of Compliance Procedure Quy Trình Đánh giá Tuân thủ	
	Management of Change Procedure Quy Trình Quản Lý Sự Thay Đổi	
	Storage, Handling, Identification, and Use of Welding Consumables Procedure Quy trình Lưu trữ, Xử lý, Nhận dạng và Sử dụng Vật tư Hàn	

# Stt	Doc No. Số hồ sơ	Manual / Procedures/ Instructions Sổ tay / Quy trình / Hướng dẫn	Department Bộ phận Chủ quản
19	P16	Validation of Welding Machines Quy Trình Kiểm Tra và Hiệu Chuẩn Máy Hàn	
20	W01	Project Document Control Instruction Hướng dẫn Kiểm soát Hồ sơ Dự án	
21	W02	Planning Maintenance and Calibration Instruction for Equipment Hướng Dẫn Lập Kế Hoạch và Hiệu Chuẩn Thiết Bị	
22	W03	Responsibility, Authority and Communication Trách Nhiệm, Quyền Hạn và Truyền Thông	
23	W04	Purchasing Instruction Hướng Dẫn Mua Hàng	
24	W05	Supplier Evaluation & Monitoring Instruction Hướng Dẫn Đánh Giá và Theo Dõi Nhà Cung Cấp	
25	W06	Goods Receiving Instruction Hướng Dẫn Tiếp Nhận Hàng Hóa	
26	W07	Welding Consumable Control Instruction Hướng Dẫn Kiểm Soát Vật Liệu Hàn	
27	W08	Coating Application Instruction Hướng dẫn Thi Công Sơn Phủ	
28	W09	Welding Procedure Qualification Instruction Hướng Dẫn Chứng Nhận Quy Trình Hàn	
29	W10	Welding Performance Qualification Instruction Hướng Dẫn Sác Hạch Tay Nghề Thợ Hàn	

# Responsible Welding Coordinator

ISO 3834	Requirement	Welding Coordinator	Remarks
Part 2	Comprehensive	Level C (IIW IWE)	Non-qualified personnel shall be evaluation according to ISO 14731 by IWE
Part 3	Standard	Level S (IIW IWS)	Non-qualified personnel shall be evaluation according to ISO 14731 by IWE
Part 4	Element	Level B (IIW IWI)	Non-qualified personnel shall be evaluation according to ISO 14731 by IWE

# International Welding Engineer



## LOẠI KIỂM TRA TYPE OF TEST

Visual examination  
Macroscopic examination  
Ultrasonic testing

## ĐÃ THỰC HIỆN/CHẤP NHẬN PERFORMED & ACCEPTED

X  
X  
X

## BÁO CÁO

REPORT NUMBER

25C02-VT-02

250590

25C02-UT-102

Ngày thi (Date of testing): **21-Apr-25**

Gia hạn (Revalidation): **9.3 a**

Hiệu lực đến (Valid until): **20-Apr-28**

Ghi chú:  
(Remarks)

[1] Visual examination was accepted by NGUYEN DUY BIEN (VN/IWE/00020).

[2] Mechanical test performed by THT Mechanical Testing Laboratory, qualified ISO 17025, Cert. No. Vilas 814.

Người kiểm tra hoặc cơ quan kiểm tra (Examiner/Examining Body):

Số của người kiểm tra/Cơ quan kiểm tra (Reference No.):

Ngày và chữ ký (Date & Signagure):



2025-May-12

Chúng tôi chứng nhận rằng các tuyên bố ghi nhận trong hồ sơ này là đúng và các mối hàn thử nghiệm đã được chuẩn bị, hàn, thử nghiệm và đã đáp ứng các yêu cầu theo tiêu chuẩn ISO 15614-1.  
(We confirm that the statements in this record are correct and that the test pieces were prepared, welded, tested and have fulfilled the requirements in accordance with ISO 15614-1).



Người kiểm tra hoặc cơ quan kiểm tra  
(Tên, chữ ký và ngày)

Examiner or examining body  
(Name, date and signature)

# Welding Coordinator

## WELDING COORDINATOR QUALIFICATION RECORDS

### 1. GENERAL INFORMATION

Full name: NGUYEN DUY BIEN  
 Position: RWC  
 Department: QA/QC  
 Company: BCK CONSULTING C., LTD.  
 Year of Experience: 15 Years  
 Employee ID: B001

### 2. EDUCATION & TRAINING

Qualification	Institute	Year	Certificates No.
Mechanical Engineering	HUI	2010	00084949
CSWIP 3.2 Senior Welding Inspector	TWI	2019	381469/2
CQI   IRCA Lead Auditor	BSI	2019	ENR-00702973
Risk Assessment	BSI	2021	ENR-0106529
IWE (International Welding Engineer)	IIW	2023	VN/IWE/00020

### 3. KNOWLEDGE AREAS COVERED

- Welding processes and equipment.
- Weld design and construction standards (ISO, ASME, AWS, AS/NZS).
- Materials and their weldability.
- Inspection, testing (VT, PT, MT, UT, RT).
- Welding defects and acceptance criteria.
- Calibration, traceability, and documentation control.

### 4. WORK EXPERIENCE IN WELDING COORDINATION

Project/Job	Client	Role	Duration	Remarks
Consulting Services for WPS/PQR/WQT	-	Welding Engineer Lead Auditor	2022~	
West Gate Tunnel	BestFab Pty.	Welding Engineer	2024	
Thermal Oxidizer Package	BWO	Welding Engineer	2022-2023	
Autoclave and WorkTank	Moldrup IWT	Welding Engineer	2020-2022	
HSVC 1 PP4 / PP5	eTEC E&C	Inspector	2018~2020	
CO2 Removal, Pressure Equipment and Steel Structure	UOP, JZHC, Posco, ...	Welding Engineer Inspector	2010~2017	

POS-FD1\_00

## 5. EVALUATION AND APPROVAL

Criteria	Evaluation Results	Comments
Technical Competence	Level C	
Quality Control & Documentation	Level C	
Leadership & Communication	Level C	
Standards Compliance	Level C	
Safety Awareness	Level C	
Training & Development	Level C	
Theory Exam Paper	Level C	

Evaluated by NGUYEN DUY BIEN

Date \_\_\_\_\_

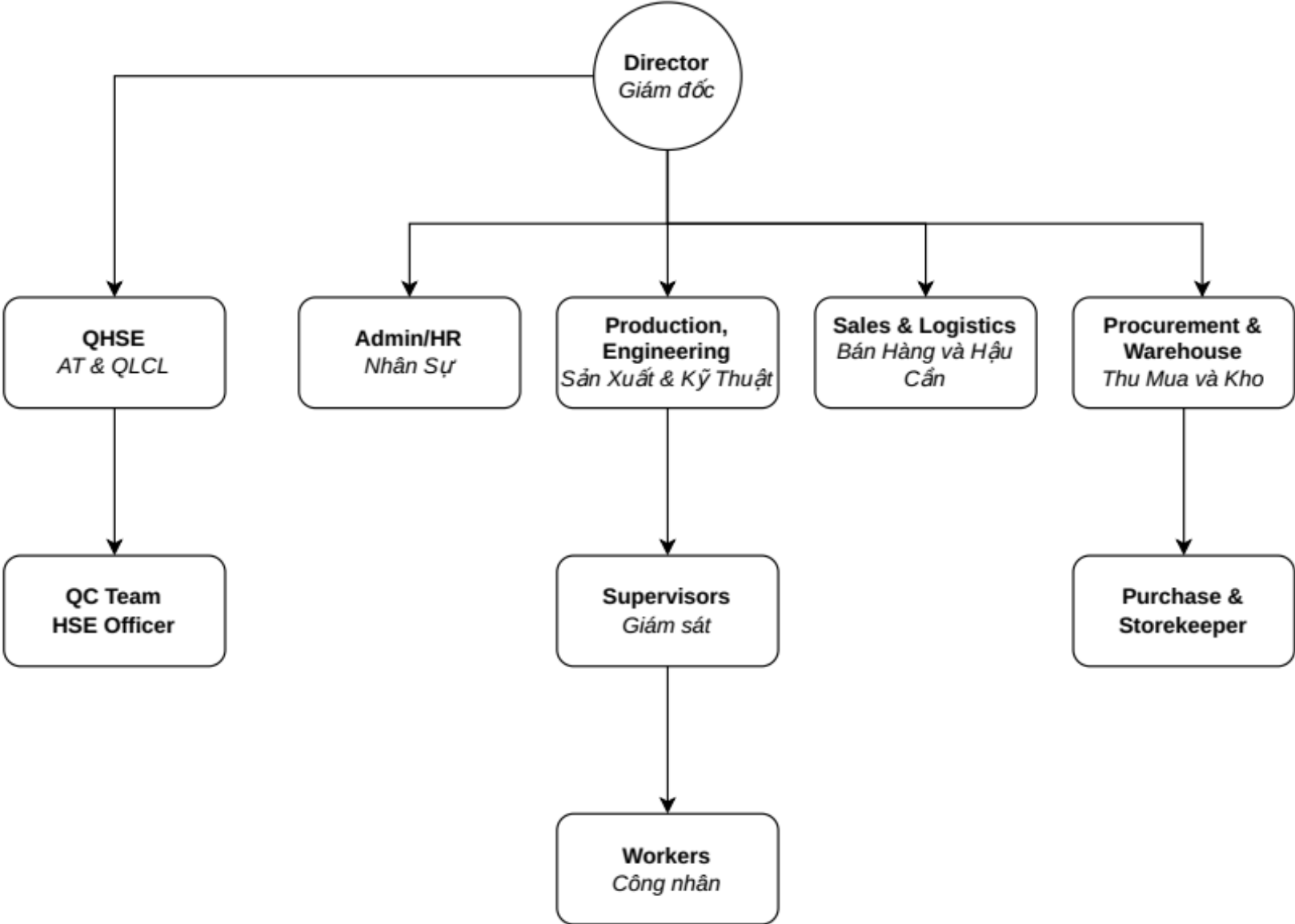
Remarks

Signature \_\_\_\_\_

Periodic Evaluation	By			
	Date			
	Results			

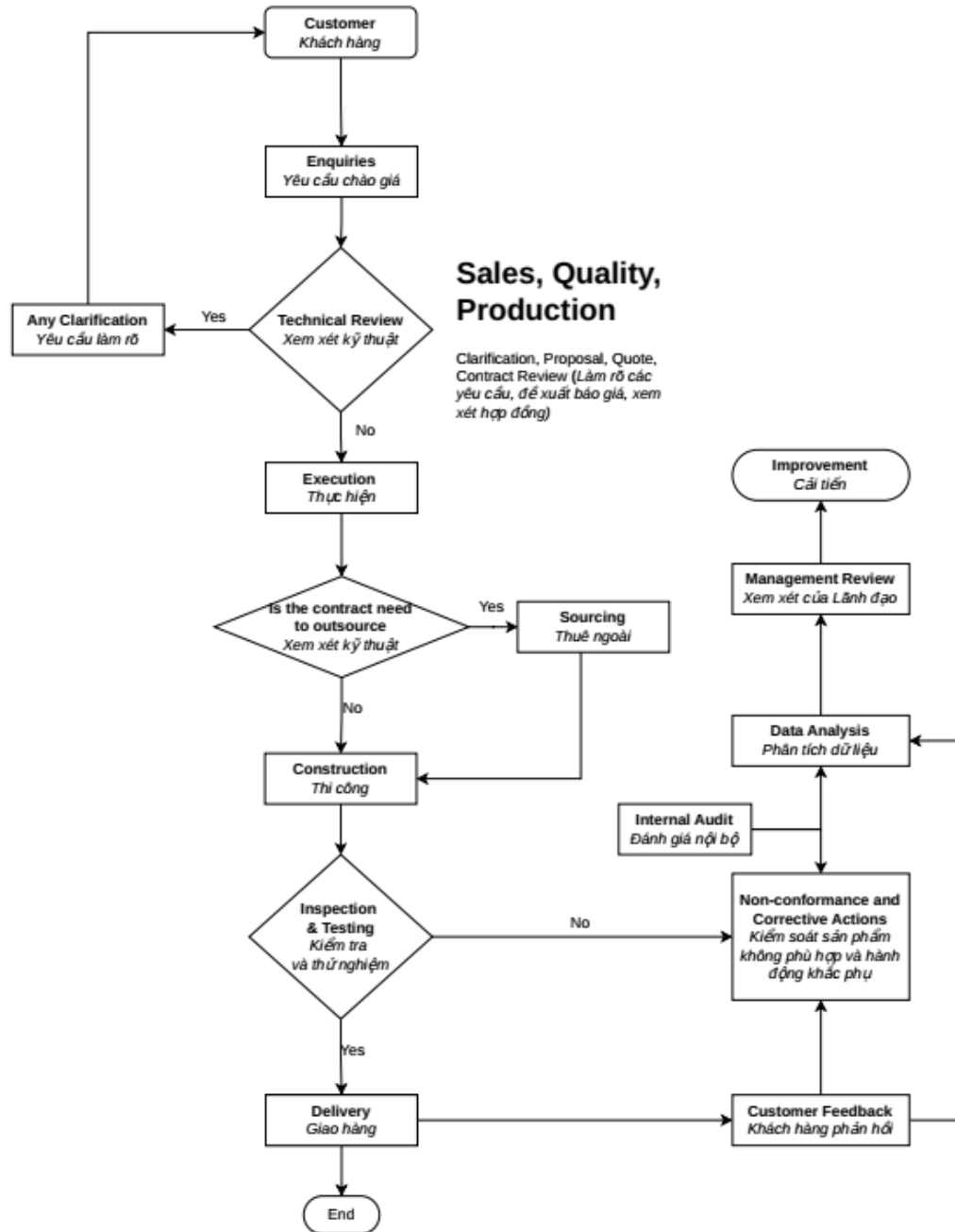
ORGANIZATION CHART  
*Sơ Đồ Tổ Chức*

# Organization



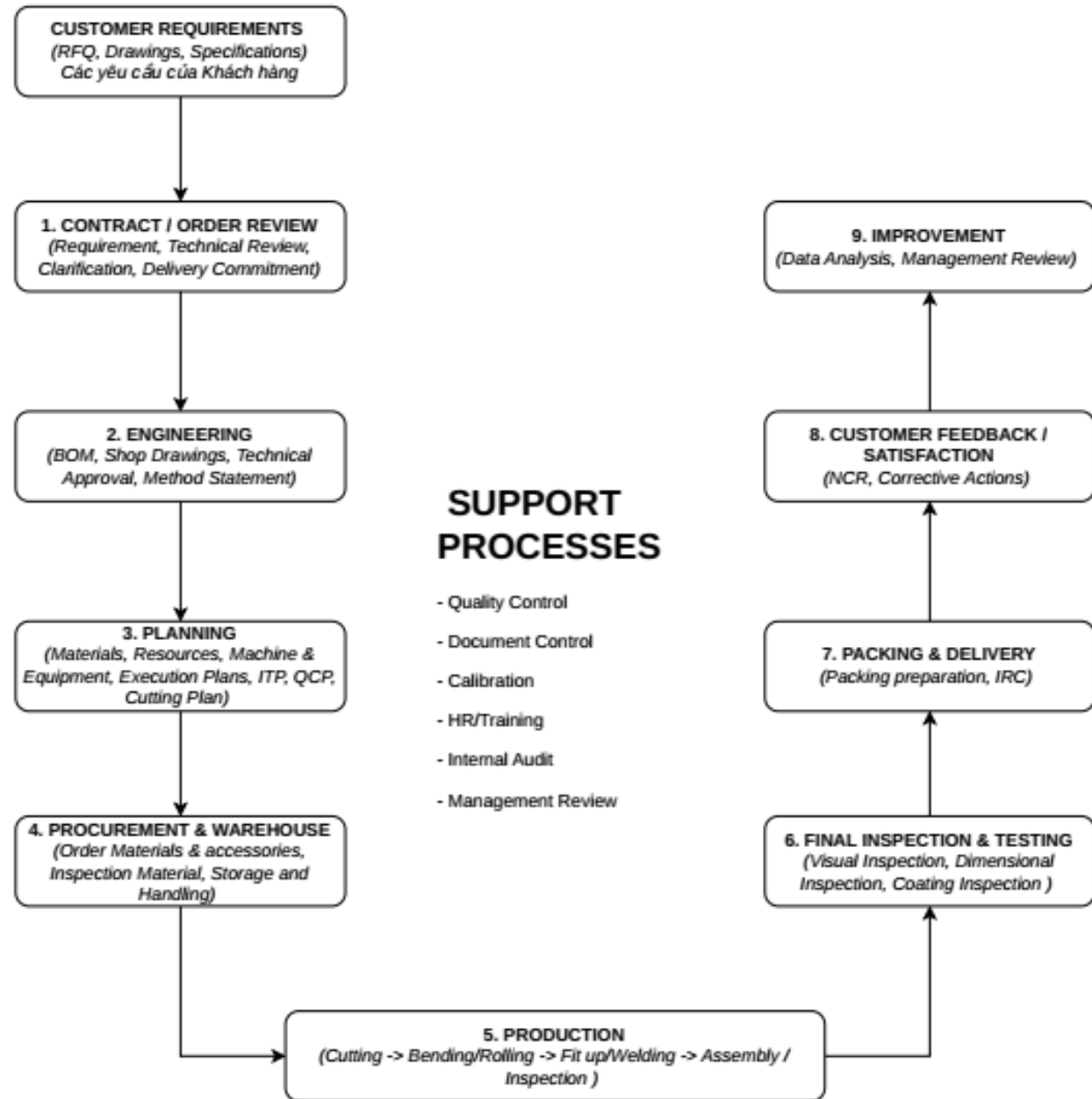
## FLOWCHART FOR BUSSINESS CORE

Lưu Đồ Kinh Doanh



## QMS Processes and Interactions

Sơ đồ tương tác các quá trình trong Hệ thống Quản lý Chất lượng



# Step-by-step training plan for a new manufacturer

## 1. Stage 1 — Management awareness

Directors, Head Department.

## 2. Stage 2 — QMS training

Welding coordinator, QA/QC, production, engineering, document control.

## 3. Stage 3 — Welding coordination training

Welding coordinator and deputies according to ISO 14731 & ISO 3834

## 4. Stage 4 — Shop-floor training

Welders, fitters, supervisors, stores personnel for WPS, Welder qualification

## 5. Stage 5 — Inspector and QC training

QC inspectors, visual inspectors, production supervisors

## 6. Stage 6 — Internal auditor training

Auditor

## 7. Stage 7 — Close NCR and invite for official assessment by Certify Body

Close the findings, NCRs and update to QMS

# 12-week implementation schedule

## Weeks 1–2

- Define scope and approach process
- Select ISO 3834 level
- Gap assessment
- Appoint responsible persons

## Weeks 3–4

- Build responsibility matrix
- Create manual and procedures
- Identify missing qualifications and records

## Weeks 5–6

- Prepare WPS/PQR/welder qualification registers
- Establish traceability and consumable controls
- Create forms and checklists

## Weeks 7–8

- Train management, RWC, welders, QC
- Apply system to run a demo job

## Weeks 9–10

- Correct gaps from demo job & implementation
- Complete objective evidence and registers
- **Qualify personnel/procedures if needed**

# 12-week implementation schedule

## **Weeks 11–12**

- Internal audit
- Management review
- Certification readiness review
- External audit booking



# Questions