
Overview

This standard identifies the competencies you need to prepare and operate manual metal arc (MMA) welding equipment in accordance with approved welding procedures. You will be required to set up and check the welding equipment and associated workholding and manipulating devices required. In setting up the equipment you will need to connect all the required leads/cables, electrode holder and workpiece earthing arrangements ready for use, and set and adjust the welding conditions in line with the welding procedure specification. You must operate the equipment safely and correctly and make any necessary adjustments to settings in order to produce the welded joints to the required specification.

Your responsibilities will require you to comply with organisational policy and procedures for the welding activities undertaken and to report any problems with the welding equipment or welding activities that you cannot resolve, or are outside your permitted authority, to the relevant person. You will be expected to work with minimum supervision, taking personal responsibility for your own actions and for the quality and accuracy of the work that you produce.

Your underpinning knowledge will provide a good understanding of your work, and provide an informed approach to applying welding procedures and instructions. You will understand the manual metal-arc welding process, and its application, and will know about the equipment, materials and consumables in adequate depth to provide a sound basis for setting up and operating the equipment, recognising and correcting faults and ensuring the work output is produced to the required specification. Non-destructive testing of your completed work is implied. You will understand the safety precautions required when working with the welding equipment. You will be required to demonstrate safe working practices throughout, and will understand the responsibility you owe to yourself and others in the workplace.

Behaviours:

You will be able to apply the appropriate behaviours required in the workplace to meet the job profile and overall company objectives, such as:

- strong work ethic
- positive attitude
- team player
- dependability
- responsibility
- honesty
- integrity
- motivation
- commitment

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Performance criteria

You must be able to:

- P1 work safely at all times, complying with health and safety and other relevant regulations, directives and guidelines
- P2 follow the relevant joining procedure and job instructions
- P3 check that the joint preparation complies with the specification
- P4 check that joining and related equipment and consumables are as specified and fit for purpose
- P5 make the joints as specified using the appropriate thermal joining technique
- P6 produce welded joints of the required quality and of specified dimensional accuracy
- P7 shut down the equipment to a safe condition on completion of joining activities
- P8 deal promptly with excess and waste materials and temporary attachments, in line with approved and agreed procedures
- P9 deal promptly and effectively with problems within your control and report those that cannot be solved

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Knowledge and understanding

You need to know and understand:

- K1 the safe working practices and procedures to be observed when working with MMA welding equipment (general workshop and site safety; appropriate personal protective equipment (PPE); fire prevention; protecting other workers from effects of the arc; safety in enclosed/confined spaces; fume control; accident procedure; statutory requirements, risk assessment procedures and relevant requirements of HASAWA, COSHH and Work Equipment Regulations; safe disposal of waste materials)
- K2 the hazards associated with MMA welding and how they can be minimised (live electrical components; poor earthing; the electric arc; fumes and gases; spatter; hot slag and metal; grinding and mechanical metal/slag removal; elevated working; enclosed spaces)
- K3 principles of MMA welding, the equipment and its operation (fusion welding principles, characteristics of the metal arc, AC and DC power sources, typical equipment and power ranges, care of equipment, terminology used in welding)
- K4 extracting information required from drawings and welding procedure specifications (interpretation of welding symbols; scope, content and application of the welding procedure specification) to include symbols and conventions to appropriate British, European or relevant International standards in relation to work undertaken
- K5 types and classification of electrodes (flux coverings, correct control, storage and drying of electrodes)
- K6 types and features of welded joints in plate, tube and sections (fillet and butt welds, single and multi-run welds, welding positions, weld quality)
- K7 problems that can occur with the welding activities and how these can be overcome (causes of distortion and methods of control, effects of welding on materials and sources of weld defects; methods of prevention)
- K8 methods of setting up the joint to achieve correct location of components and control of distortion (edge preparation, use of jigs/fixtures; manipulators and positioners, tack welding, size and spacing in relationship to material thickness and component size, use of temporary attachments, pre-setting)
- K9 setting up the welding equipment and checks that need to be made to ensure that it is safe and ready to use (electrical connections, power return and earthing arrangements; equipment calibration, setting welding parameters, care and maintenance of equipment)
- K10 the techniques of operating the welding equipment to produce a range of joints in the various joint positions (fine tuning parameters, correct manipulation of electrode, safe closing down of the welding equipment)

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- K11 the organisational quality systems used and weld standards to be achieved
- K12 weld inspection and test procedures used including destructive and non-destructive methods
- K13 personal approval tests and their applicability to your work
- K14 the extent of your own responsibility and whom you should report to if you have problems that you cannot resolve

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Additional Information

Scope/range related to performance criteria

You must be able to:

1. Prepare for the manual metal arc welding process, to include carrying out **all** of the following:
 - 1.1 obtaining the appropriate equipment for the welding activities to be carried out (type, current capacity)
 - 1.2 checking the condition of and correctly connecting welding leads, earthing arrangements and electrode holder
 - 1.3 setting and adjusting welding conditions/parameters, in accordance with welding procedure specification
 - 1.4 preparing the work area for the welding activities (such as sighting welding screens, positioning fume extraction equipment)
 - 1.5 ensuring that the workpiece is correctly set up with regard to specified joint preparation and is secure
 - 1.6 obtaining and wearing appropriate personal protective equipment
2. Set up, check, adjust and use manual metal-arc welding and related equipment to include **either**:
 - 2.1 alternating current equipment (AC)
 - 2.2 direct current equipment (DC)
3. Use **two** types and **two** sizes of electrode from the following:
 - 3.1 rutile
 - 3.2 basic
 - 3.3 nickel alloy
 - 3.4 cellulosic
 - 3.5 stainless steel
 - 3.6 other electrodes
4. Produce welded joints which incorporate **both**:
 - 4.1 butt welds
 - 4.2 fillet welds
5. Produce joints in **two** of the following forms in specified materials from different material groups:
 - 5.1 plate
 - 5.2 section
 - 5.3 pipe/tube

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5.4 other specific forms

6. Weld joints according to approved welding procedures in good access situations in the following BS EN ISO 6947 positions:

- 6.1 Vertical upwards (PF) butt weld

and **four** other positions chosen from:

- 6.2 flat (PA)

- 6.3 horizontal (PC)

- 6.4 overhead (PE)

- 6.5 horizontal vertical (PB)

- 6.6 vertical downwards (PG)

- 6.7 inclined tube/pipe (H-LO45 or J-LO45)

7. Produce welded components which:

- 7.1 achieve a weld quality acceptable to quality level B of BS EN ISO 5817 except for excessive weld metal, excessive convexity, excessive throat thickness and excessive penetration for which quality level C shall apply (for aluminium, BS EN ISO10042 applies)

- 7.2 meet the required dimensional accuracy within specified tolerances

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