

# TRAINING REGULATIONS



## FLUX-CORED ARC WELDING (FCAW) NCII

**METALS AND ENGINEERING SECTOR**

**TECHNICAL EDUCATION AND SKILLS DEVELOPMENT AUTHORITY**  
East Service Road, South Superhighway, Taguig City, Metro Manila

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## TRAINING REGULATIONS FOR FLUX-CORED ARC WELDING (FCAW) NC II

### SECTION 1 FLUX-CORED ARC WELDING (FCAW) NC II

The Flux-Cored Arc Welding (FCAW) NC II Qualification consists of competencies that a person must achieve to weld carbon steel pipes components as specified by layout, blueprints, diagrams, work order, welding procedure or oral instructions using FCAW welding equipment.

This Qualification conforms with American Welding Society (AWS) D 1.1 Structural Welding Code; American Society of Mechanical Engineers (ASME) IX Boiler and Pressure Vessel Code; American Petroleum Institute (API) 1104 Code for Gas and Oil Pipeline Facilities; and International Standards Organization (ISO) 9606-1 Qualification of Welders for Steel.

The Units of Competency comprising this qualification include the following:

Code No.	BASIC COMPETENCIES
5 00 311 1 05	Participate in workplace communication
5 00 311 1 06	Work in team environment
5 00 311 1 07	Practice career professionalism
5 00 311 1 08	Practice occupational health and safety procedures

Code No.	COMMON COMPETENCIES
MEE721201	Apply Safety Practices
MEE721202	Interpret Drawings and Sketches
MEE721203	Perform Industry Calculations
MEE721204	Contribute to Quality System
MEE721205	Use Hand Tools
MEE721206	Prepare Weld Materials
MEE721207	Setup Welding Equipment
MEE721208	Fit up Weld Materials
MEE721209	Repair Welds

Code No.	CORE COMPETENCY
MEE721310	Weld Carbon Steel Pipes Using FCAW

A person who has achieved this Qualification is competent to be:

- Plate Welder (FCAW)
- Pipe Welder (FCAW)

## SECTION 2 COMPETENCY STANDARDS

This section gives the details of the contents of the core units of competency required in FLUX-CORED ARC WELDING (FCAW) NC II.

### BASIC COMPETENCIES

**UNIT OF COMPETENCY :** PARTICIPATE IN WORKPLACE COMMUNICATION

**UNIT CODE :** 500311105

**UNIT DESCRIPTOR :** This unit covers the knowledge, skills and attitudes required to gather, interpret and convey information in response to workplace requirements.

ELEMENT	PERFORMANCE CRITERIA <i>Italicized</i> terms are elaborated in the Range of Variables
1. Obtain and convey workplace information	1.1 Specific and relevant information is accessed from <b>appropriate sources</b> 1.2 Effective questioning , active listening and speaking skills are used to gather and convey information 1.3 Appropriate <b>medium</b> is used to transfer information and ideas 1.4 Appropriate non- verbal communication is used 1.5 Appropriate lines of communication with supervisors and colleagues are identified and followed 1.6 Defined workplace procedures for the location and <b>storage</b> of information are used 1.7 Personal interaction is carried out clearly and concisely
2. Participate in workplace meetings and discussions	2.1 Team meetings are attended on time 2.2 Own opinions are clearly expressed and those of others are listened to without interruption 2.3 Meeting inputs are consistent with the meeting purpose and established <b>protocols</b> 2.4 <b>Workplace interactions</b> are conducted in a courteous manner 2.5 Questions about simple routine workplace procedures and matters concerning working conditions of employment are asked and responded to 2.6 Meetings outcomes are interpreted and implemented
3. Complete relevant work related documents	3.1 Range of <b>forms</b> relating to conditions of employment are completed accurately and legibly 3.2 Workplace data are recorded on standard workplace forms and documents 3.3 Basic mathematical processes are used for routine calculations 3.4 Errors in recording information on forms/ documents are identified and properly acted upon 3.5 Reporting requirements to supervisor are completed according to organizational guidelines

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Appropriate sources	1.1. Team members 1.2. Suppliers 1.3. Trade personnel 1.4. Local government 1.5. Industry bodies
2. Medium	2.1. Memorandum 2.2. Circular 2.3. Notice 2.4. Information discussion 2.5. Follow-up or verbal instructions 2.6. Face to face communication
3. Storage	3.1. Manual filing system 3.2. Computer-based filing system
4. Forms	4.1. Personnel forms, telephone message forms, safety reports
5. Workplace interactions	5.1. Face to face 5.2. Telephone 5.3. Electronic and two way radio 5.4. Written including electronic, memos, instruction and forms, non-verbal including gestures, signals, signs and diagrams
6. Protocols	6.1. Observing meeting 6.2. Compliance with meeting decisions 6.3. Obeying meeting instructions

## EVIDENCE GUIDE

<p>1. Critical Aspects of Competency</p>	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1. Prepared written communication following standard format of the organization</li> <li>1.2. Accessed information using communication equipment</li> <li>1.3. Made use of relevant terms as an aid to transfer information effectively</li> <li>1.4. Conveyed information effectively adopting the formal or informal communication</li> </ul>
<p>2. Underpinning Knowledge and Attitudes</p>	<ul style="list-style-type: none"> <li>2.1. Effective communication</li> <li>2.2. Different modes of communication</li> <li>2.3. Written communication</li> <li>2.4. Organizational policies</li> <li>2.5. Communication procedures and systems</li> <li>2.6. Technology relevant to the enterprise and the individual's work responsibilities</li> </ul>
<p>3. Underpinning Skills</p>	<ul style="list-style-type: none"> <li>3.1. Follow simple spoken language</li> <li>3.2. Perform routine workplace duties following simple written notices</li> <li>3.3. Participate in workplace meetings and discussions</li> <li>3.4. Complete work related documents</li> <li>3.5. Estimate, calculate and record routine workplace measures</li> <li>3.6. Basic mathematical processes of addition, subtraction, division and multiplication</li> <li>3.7. Ability to relate to people of social range in the workplace</li> <li>3.8. Gather and provide information in response to workplace Requirements</li> </ul>
<p>4. Resource Implications</p>	<ul style="list-style-type: none"> <li>4.1. Fax machine</li> <li>4.2. Telephone</li> <li>4.3. Writing materials</li> <li>4.4. Internet</li> </ul>
<p>5. Methods of Assessment</p>	<ul style="list-style-type: none"> <li>5.1. Direct Observation</li> <li>5.2. Oral interview and written test</li> </ul>
<p>6. Context of Assessment</p>	<ul style="list-style-type: none"> <li>6.1. Competency may be assessed individually in the actual workplace or through accredited institution</li> </ul>

**UNIT OF COMPETENCY: WORK IN TEAM ENVIRONMENT****UNIT CODE : 500311106****UNIT DESCRIPTOR :** This unit covers the skills, knowledge and attitudes to identify role and responsibility as a member of a team.

<b>ELEMENT</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the Range of Variables
1. Describe team role and scope	1.1. The <b><i>role and objective of the team</i></b> is identified from available <b><i>sources of information</i></b>  1.2. Team parameters, reporting relationships and responsibilities are identified from team discussions and appropriate external sources
2. Identify own role and responsibility within team	2.1. Individual role and responsibilities within the team environment are identified  2.2. Roles and responsibility of other team members are identified and recognized  2.3. Reporting relationships within team and external to team are identified
3. Work as a team member	3.1. Effective and appropriate forms of communications are used and interactions are undertaken with team members who contribute to known team activities and objectives  3.2. Effective and appropriate contributions are made to complement team activities and objectives, based on individual skills and competencies and <b><i>workplace context</i></b>  3.3. Protocols are observed in reporting based on standard operating procedures  3.4. Contribute to the development of team work plans based on an understanding of team's role and objectives and individual competencies of the members. ....

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Role and objective of team	1.1. Work activities in a team environment with enterprise or specific sector 1.2. Limited discretion, initiative and judgement maybe demonstrated on the job, either individually or in a team environment
2. Sources of information	2.1. Standard operating and/or other workplace procedures 2.2. Job procedures 2.3. Machine/equipment manufacturer's specifications and instructions 2.4. Organizational or external personnel 2.5. Client/supplier instructions 2.6. Quality standards 2.7. OHS and environmental standards
3. Workplace context	3.1. Work procedures and practices 3.2. Conditions of work environments 3.3. Legislation and industrial agreements 3.4. Standard work practice including the storage, safe handling and disposal of chemicals 3.5. Safety, environmental, housekeeping and quality guidelines

## EVIDENCE GUIDE

<p>1. Critical aspects of competency</p>	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1. Operated in a team to complete workplace activity</li> <li>1.2. Worked effectively with others</li> <li>1.3. Conveyed information in written or oral form</li> <li>1.4. Selected and used appropriate workplace language</li> <li>1.5. Followed designated work plan for the job</li> <li>1.6. Reported outcomes</li> </ul>
<p>2. Underpinning Knowledge and Attitude</p>	<ul style="list-style-type: none"> <li>2.1. Communication process</li> <li>2.2. Team structure</li> <li>2.3. Team roles</li> <li>2.4. Group planning and decision making</li> </ul>
<p>3. Underpinning Skills</p>	<ul style="list-style-type: none"> <li>3.1. Communicate appropriately, consistent with the culture of the workplace</li> </ul>
<p>4. Resource Implications</p>	<p>The following resources <b>MUST</b> be provided:</p> <ul style="list-style-type: none"> <li>4.1. Access to relevant workplace or appropriately simulated environment where assessment can take place</li> <li>4.2. Materials relevant to the proposed activity or tasks</li> </ul>
<p>5. Methods of Assessment</p>	<p>Competency may be assessed through:</p> <ul style="list-style-type: none"> <li>5.1. Observation of the individual member in relation to the work activities of the group</li> <li>5.2. Observation of simulation and or role play involving the participation of individual member to the attainment of organizational goal</li> <li>5.3. Case studies and scenarios as a basis for discussion of issues and strategies in teamwork</li> </ul>
<p>6. Context for Assessment</p>	<ul style="list-style-type: none"> <li>6.1. Competency may be assessed in workplace or in a simulated workplace setting</li> <li>6.2. Assessment shall be observed while task are being undertaken whether individually or in group</li> </ul>

**UNIT OF COMPETENCY: PRACTICE CAREER PROFESSIONALISM**

**UNIT CODE : 500311107**

**UNIT DESCRIPTOR :** This unit covers the knowledge, skills and attitudes in promoting career growth and advancement.

<b>ELEMENT</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the Range of Variables
1. Integrate personal objectives with organizational goals	1.1 Personal growth and work plans are pursued towards improving the qualifications set for the profession 1.2 Intra- and interpersonal relationships are maintained in the course of managing oneself based on performance <b>evaluation</b> 1.3 Commitment to the organization and its goal is demonstrated in the performance of duties
1. Set and meet work priorities	2.1 Competing demands are prioritized to achieve personal, team and organizational goals and objectives. 2.2 <b>Resources</b> are utilized efficiently and effectively to manage work priorities and commitments 2.3 Practices along economic use and maintenance of equipment and facilities are followed as per established procedures
2. Maintain professional growth and development	3.1 <b>Trainings and career opportunities</b> are identified and availed of based on job requirements 3.2 <b>Recognitions</b> are -sought/received and demonstrated as proof of career advancement 3.3 <b>Licenses and/or certifications</b> relevant to job and career are obtained and renewed

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Evaluation	1.1 Performance Appraisal 1.2 Psychological Profile 1.3 Aptitude Tests
2. Resources	2.1 Human 2.2 Financial 2.3 Technology 2.3.1 Hardware 2.3.2 Software
3. Trainings and career opportunities	3.1 Participation in training programs 3.1.1 Technical 3.1.2 Supervisory 3.1.3 Managerial 3.1.4 Continuing Education 3.2 Serving as Resource Persons in conferences and workshops
4. Recognitions	4.1 Recommendations 4.2 Citations 4.3 Certificate of Appreciations 4.4 Commendations 4.5 Awards 4.6 Tangible and Intangible Rewards
5. Licenses and/or certifications	5.1 National Certificates 5.2 Certificate of Competency 5.3 Support Level Licenses 5.4 Professional Licenses

## EVIDENCE GUIDE

<p>1. Critical Aspects of Competency</p>	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1 Attained job targets within key result areas (KRAs)</li> <li>1.2 Maintained intra - and interpersonal relationship in the course of managing oneself based on performance evaluation</li> <li>1.3 Completed trainings and career opportunities which are based on the requirements of the industries</li> <li>1.4 Acquired and maintained licenses and/or certifications according to the requirement of the qualification</li> </ul>
<p>2. Underpinning Knowledge</p>	<ul style="list-style-type: none"> <li>2.1 Work values and ethics (Code of Conduct, Code of Ethics, etc.)</li> <li>2.2 Company policies</li> <li>2.3 Company-operations, procedures and standards</li> <li>2.4 Fundamental rights at work including gender sensitivity</li> <li>2.5 Personal hygiene practices</li> </ul>
<p>3. Underpinning Skills</p>	<ul style="list-style-type: none"> <li>3.1 Appropriate practice of personal hygiene</li> <li>3.2 Intra and Interpersonal skills</li> <li>3.3 Communication skills</li> </ul>
<p>4. Resource Implications</p>	<p>The following resources <b>MUST</b> be provided:</p> <ul style="list-style-type: none"> <li>4.1 Workplace or assessment location</li> <li>4.2 Case studies/scenarios</li> </ul>
<p>5. Methods of Assessment</p>	<p>Competency may be assessed through:</p> <ul style="list-style-type: none"> <li>5.1 Portfolio Assessment</li> <li>5.2 Interview</li> <li>5.3 Simulation/Role-plays</li> <li>5.4 Observation</li> <li>5.5 Third Party Reports</li> <li>5.6 Exams and Tests</li> </ul>
<p>6. Context of Assessment</p>	<ul style="list-style-type: none"> <li>6.1 Competency may be assessed in the work place or in a simulated environment.</li> </ul>

**UNIT OF COMPETENCY :** PRACTICE OCCUPATIONAL HEALTH AND SAFETY PROCEDURES

**UNIT CODE :** 500311108

**UNIT DESCRIPTOR :** This unit covers the outcomes required to comply with regulatory and organizational requirements for occupational health and safety.

<b>ELEMENT</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the Range of Variables
1. Identify hazards and risks	1.1 <b>Safety regulations</b> and workplace safety and hazard control practices and procedures are clarified and explained based on organization procedures 1.2 <b>Hazards/risks</b> in the workplace and their corresponding indicators are identified to minimize or eliminate risk to co-workers, workplace and environment in accordance with organization procedures 1.3 <b>Contingency measures</b> during workplace accidents, fire and other emergencies are recognized and established in accordance with organization procedures
2. Evaluate hazards and risks	2.1 Terms of maximum tolerable limits which when exceeded will result in harm or damage are identified based on threshold limit values (TLV) 2.2 Effects of the hazards are determined 2.3 OHS issues and/or concerns and identified safety hazards are reported to designated personnel in accordance with workplace requirements and relevant workplace OHS legislation

<b>ELEMENT</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the Range of Variables
3. Control hazards and risks	3.1 Occupational Health and Safety (OHS) procedures for controlling hazards/risks in workplace are consistently followed 3.2 Procedures for dealing with workplace accidents, fire and emergencies are followed in accordance with organization OHS policies 3.3 <b>Personal protective equipment (PPE)</b> is correctly used in accordance with organization OHS procedures and practices 3.4 Appropriate assistance is provided in the event of a workplace emergency in accordance with established organization protocol
4. Maintain OHS awareness	4.1 <b>Emergency-related drills and trainings</b> are participated in as per established organization guidelines and procedures 4.2 <b>OHS personal records</b> are completed and updated in accordance with workplace requirements

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Safety regulations	May include but are not limited to: 1.1 Clean Air Act 1.2 Building code 1.3 National Electrical and Fire Safety Codes 1.4 Waste management statutes and rules 1.5 Philippine Occupational Safety and Health Standards 1.6 DOLE regulations on safety legal requirements 1.7 ECC regulations
2. Hazards/Risks	May include but are not limited to: 2.1 Physical hazards – impact, illumination, pressure, noise, vibration, temperature, radiation 2.2 Biological hazards- bacteria, viruses, plants, parasites, mites, molds, fungi, insects 2.3 Chemical hazards – dusts, fibers, mists, fumes, smoke, gasses, vapors 2.4 Ergonomics <ul style="list-style-type: none"> <li>• Psychological factors – over exertion/ excessive force, awkward/static positions, fatigue, direct pressure, varying metabolic cycles</li> <li>• Physiological factors – monotony, personal relationship, work out cycle</li> </ul>
3. Contingency measures	May include but are not limited to: 3.1 Evacuation 3.2 Isolation 3.3 Decontamination 3.4 (Calling designed) emergency personnel
4. PPE	May include but are not limited to: 4.1 Mask 4.2 Gloves 4.3 Goggles 4.4 Hair Net/cap/bonnet 4.5 Face mask/shield 4.6 Ear muffs 4.7 Apron/Gown/coverall/jump suit 4.8 Anti-static suits

VARIABLE	RANGE
5. Emergency-related drills and training	5.1 Fire drill 5.2 Earthquake drill 5.3 Basic life support/CPR 5.4 First aid 5.5 Spillage control 5.6 Decontamination of chemical and toxic 5.7 Disaster preparedness/management
6. OHS personal records	6.1 Medical/Health records 6.2 Incident reports 6.3 Accident reports 6.4 OHS-related training completed

## EVIDENCE GUIDE

<p>1. Critical Aspects of Competency</p>	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1 Explained clearly established workplace safety and hazard control practices and procedures</li> <li>1.2 Identified hazards/risks in the workplace and its corresponding indicators in accordance with company procedures</li> <li>1.3 Recognized contingency measures during workplace accidents, fire and other emergencies</li> <li>1.4 Identified terms of maximum tolerable limits based on threshold limit value- TLV.</li> <li>1.5 Followed Occupational Health and Safety (OHS) procedures for controlling hazards/risks in workplace</li> <li>1.6 Used Personal Protective Equipment (PPE) in accordance with company OHS procedures and practices</li> <li>1.7 Completed and updated OHS personal records in accordance with workplace requirements</li> </ul>
<p>2. Underpinning Knowledge and Attitude</p>	<ul style="list-style-type: none"> <li>2.1 OHS procedures and practices and regulations</li> <li>2.2 PPE types and uses</li> <li>2.3 Personal hygiene practices</li> <li>2.4 Hazards/risks identification and control</li> <li>2.5 Threshold Limit Value -TLV</li> <li>2.6 OHS indicators</li> <li>2.7 Organization safety and health protocol</li> <li>2.8 Safety consciousness</li> <li>2.9 Health consciousness</li> </ul>
<p>3. Underpinning Skills</p>	<ul style="list-style-type: none"> <li>3.1 Practice of personal hygiene</li> <li>3.2 Hazards/risks identification and control skills</li> <li>3.3 Interpersonal skills</li> <li>3.4 Communication skills</li> </ul>
<p>3. Resource Implications</p>	<p>The following resources must be provided:</p> <ul style="list-style-type: none"> <li>4.1 Workplace or assessment location</li> <li>4.2 OHS personal records</li> <li>4.3 PPE</li> <li>4.4 Health records</li> </ul>
<p>4. Methods of Assessment</p>	<p>Competency may be assessed through:</p> <ul style="list-style-type: none"> <li>5.1 Portfolio Assessment</li> <li>5.2 Interview</li> <li>5.3 Case Study/Situation</li> </ul>
<p>5. Context for Assessment</p>	<ul style="list-style-type: none"> <li>6.1 Competency may be assessed in the work place or in a simulated work place setting</li> </ul>

## COMMON COMPETENCIES

**UNIT OF COMPETENCY : APPLY SAFETY PRACTICES**

**UNIT CODE : MEE721201**

**UNIT DESCRIPTOR : This unit covers the competencies required to apply safety practices in the workplace.**

<b>ELEMENTS</b>		<b>PERFORMANCE CRITERIA</b>	
		<i>Italicized</i> terms are elaborated in the Range of Variables	
1.	Identify hazardous area	1.1 1.2	<i>Hazards</i> are identified correctly in accordance with OHS principles. Safety signs and symbols are identified and adhered to.
2.	Use protective clothing and devices	2.1	Appropriate <i>protective clothing and devices</i> are correctly selected and used in accordance with OHS requirements or industry/company policy
3.	Perform safe handling of tools, equipment and materials	3.1 3.2	Safety procedures for pre-use check and operation of tools and equipment are followed in accordance with industry/ company policies. Tools, equipment and materials are handled safely in accordance with OHS requirements and industry/ company policies.
4.	Perform first aid	4.1	First aid treatment of <i>injuries</i> are carried out according to recommended procedures
5.	Use fire extinguisher	5.1	Fire extinguisher is selected and operated correctly according to the <i>types of fire</i> .

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Hazards	1.1 Cluttered tools and materials 1.2 Slippery floors (caused by oil, grease or any liquid) 1.3 Exposed electrical wires 1.4 Sharp edges 1.5 Machine without guards or with exposed moving parts
2. Protective clothing and devices	Protective clothing and devices may include but are not limited to: 2.1 safety glasses/goggles 2.2 safety shoes 2.3 overalls 2.4 cap 2.5 gloves
3. Injuries	Injuries may include: 3.1 burns/scalds 3.2 fractures 3.3 cuts and abrasions 3.4 poisoning 3.5 foreign bodies in the eye 3.6 concussion 3.7 shock
4. Types of fire	Fire involving or caused by: 4.1 common combustibles (wood, cloth, paper, rubber and plastic) 4.2 flammable liquids (gasoline, oil, solvents, paints, etc.) 4.3 energized electrical equipment (wiring, fuse boxes, circuit breakers, appliances, etc.) 4.4 combustible metals (magnesium, sodium, etc.)

## EVIDENCE GUIDE

<p>1. Critical aspects of competency</p>	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1 identified hazardous area</li> <li>1.2 used protective clothing and devices</li> <li>1.3 handled tools, equipment and materials properly</li> <li>1.4 performed first aid</li> <li>1.5 used fire extinguisher</li> </ul>
<p>2. Underpinning knowledge and attitude</p>	<ul style="list-style-type: none"> <li>2.1 Shop safety signs, symbols and alarms</li> <li>2.2 Safety precautionary measures</li> <li>2.3 Housekeeping</li> <li>2.4 Machine tools</li> <li>2.5 First aid</li> <li>2.6 Engineering materials</li> <li>2.7 Fire extinguishers</li> </ul>
<p>3. Underpinning skills</p>	<ul style="list-style-type: none"> <li>3.1 Operating machine tools</li> <li>3.2 Handling tools and materials</li> <li>3.3 Communicating with superiors and co-workers</li> <li>3.4 Interpreting instructions</li> </ul>
<p>4. Resource implications</p>	<p>The following resources must be provided</p> <ul style="list-style-type: none"> <li>4.1 Tools, equipment and facilities appropriate to processes or activity</li> <li>4.2 Materials relevant to the proposed activity</li> </ul>
<p>5. Method of assessment</p>	<p>Competency must be assessed through:</p> <ul style="list-style-type: none"> <li>5.1 Demonstration</li> <li>5.2 Written or oral short answer questions</li> <li>5.3 Practical exercises</li> </ul>
<p>6. Context for assessment</p>	<ul style="list-style-type: none"> <li>• Competency may be assessed in the workplace or in simulated workplace environment.</li> </ul>

**UNIT OF COMPETENCY : INTERPRET DRAWINGS AND SKETCHES**

**UNIT CODE : MEE721202**

**UNIT DESCRIPTOR : This unit covers the competencies required to read and interpret drawings and sketches.**

<b>ELEMENTS</b>		<b>PERFORMANCE CRITERIA</b>	
		<i>Italicized</i> terms are elaborated in the Range of Variables	
1.	Identify standard alphabet of lines	1.1	Alphabet of lines are identified based on procedures
		1.2	Uses of the alphabet of lines are explained
2.	Identify orthographic/ isometric views	2.1	Orthographic and isometric <i>drawing</i> are identified
		2.2	Orthographic and isometric views are explained
3.	Interpret standard drawing symbols, dimensional tolerances and notations	3.1	Drawing symbols are interpreted according to drawing standards
		3.2	Dimensional <i>tolerances</i> , notations are interpreted according to specifications

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Drawing	Drawing technique include 1.1 Perspective 1.2 Exploded view 1.3 Hidden view technique  Projections 1.4 First angle projections 1.5 Third angle projections
2. Tolerance	2.1 General tolerance 2.2 Angular tolerance 2.3 Geometric tolerance

## EVIDENCE GUIDE

1. Critical aspects of competency	Assessment requires evidence that the candidate interpreted technical drawings and sketches.
2. Underpinning knowledge	2.1 Alphabet of lines 2.2 Projections 2.3 Drawing symbols 2.4 Dimensioning techniques 2.5 Tolerances
3. Underpinning skills	3.1 Communication skills (reading and comprehension) 3.2 Computation skills
4. Resource implications	The following resources must be provided 4.1 Working drawing or plans or sketches 4.2 Measuring tools 4.3 Drawings, sketches or blueprint 4.4 Specimen parts/components
5. Method of assessment	Competency must be assessed through: 5.1 direct observation 5.2 written or oral short answer questions 5.3 demonstration 5.4 project/work sample 5.5 portfolio
6. Context for assessment	<ul style="list-style-type: none"> <li>Competency may be assessed in the workplace or in simulated workplace environment.</li> </ul>

**UNIT OF COMPETENCY : PERFORM INDUSTRY CALCULATIONS**

**UNIT CODE : MEE721203**

**UNIT DESCRIPTOR :** This unit covers the competencies required to perform basic calculations using the four fundamental operation.

<b>ELEMENTS</b>		<b>PERFORMANCE CRITERIA</b>	
		<i>Italicized</i> terms are elaborated in the Range of Variables	
1.	Perform four fundamental operations.	1.1	Simple calculations involving whole numbers, mixed numbers, fraction and decimal are performed using <i>four fundamental operations</i> .
2.	Perform conversion of units	2.1	<i>Units</i> are converted to the required figure using the given formulae
		2.2	<i>English measurements</i> are converted to <i>metric measurements</i> according to procedure.
3.	Perform calculations on algebraic expressions	3.1	Simple calculations are performed on algebraic expressions using four fundamental operations.
		3.2	Simple transposition of formulae are carried out to isolate the variable required, involving the four fundamental operations.
		3.3	Where appropriate, formulae are constructed to enable problems to be solved.
		3.4	Equations involving on unknown solved correctly.
4.	Compute percentage and ratio	4.1	Percentages are computed using appropriate formula.
		4.2	Ratio and proportion are computed using appropriate formula.

**RANGE OF VARIABLES**

<b>VARIABLE</b>	<b>RANGE</b>
1. Four fundamental operations	1.1 Addition 1.2 Subtraction 1.3 Multiplication 1.4 Division
2. Units	2.1 Fractions 2.2 Mixed numbers 2.3 decimal

## EVIDENCE GUIDE

1. Critical aspects of competency	Assessment requires evidence that the candidate performed calculations: 1.1 using four fundamental operations 1.2 involving fractions and mixed numbers 1.3 involving fractions and decimals 1.4 on algebraic expressions 1.5 involving ratio and proportion
2. Underpinning knowledge and attitude	2.1 English and metric system of measurements 2.2 Four fundamental operations 2.3 Method of transposing formulae 2.4 Equation formulation
3. Underpinning skills	3.1 Performing calculations using pen and paper or with the use of calculator
4. Resource implications	The following resources must be provided 4.1 Tools and facilities appropriate to processes or activity 4.2 Materials relevant to the proposed activity
5. Method of assessment	Competency must be assessed through: 5.1 written or oral short answer questions 5.2 practical exercises
6. Context for assessment	Competency may be assessed in the workplace or in simulated workplace environment.

**UNIT OF COMPETENCY : CONTRIBUTE TO QUALITY SYSTEM**

**UNIT CODE : MEE721204**

**UNIT DESCRIPTOR : This unit involves competence required to inspect work against specification and standards and apply quality standards to work.**

<b>ELEMENTS</b>		<b>PERFORMANCE CRITERIA</b>	
		<i>Italicized</i> terms are elaborated in the Range of Variables	
1.	Inspect work done	1.1	Appropriate inspections are conducted to ensure company <b>quality systems and procedures</b> are maintained/ followed.
		1.2	Job specifications/work order and quality standards are identified based on procedure
		1.3	Faults/Defects are identified and rectified according to company procedures.
2.	Apply quality standards to work	2.1	Inspections are conducted throughout the manufacturing processes to ensure quality standards are maintained.
		2.2	Appropriate quality standards are applied throughout the production/fabrication process.
		2.3	All activities are coordinated throughout the workplace to ensure efficient quality work outcomes.
		2.4	Records of work quality are maintained according to the company requirements.
3	Protect company property and customer interests	3.1	Possible damage to <b>company property</b> is avoided by adherence to company quality procedures.
		3.2	Quality of work is reviewed based on customer requirements and company standards.

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Quality system and procedures	Quality system and procedures may be contained in: 1.1 work instructions 1.2 safe work procedures 1.3 product specifications 1.4 equipment maintenance schedules 1.5 technical procedures adopted or specifically prepared standards 1.6 company/industry rules
2. Company property	Company properties include : 2.1 production and/or fabrication equipment 2.2 hand and power tools 2.3 OH&S paraphernalia 2.4 facilities

## EVIDENCE GUIDE

<p>1. Critical aspects of competency</p>	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1 inspected work done against specification</li> <li>1.2 applied quality standards to work</li> <li>1.3 protected company property and customer interests</li> </ul>
<p>2. Underpinning knowledge and attitude</p>	<ul style="list-style-type: none"> <li>2.1 Communication/feedback methods-written and verbal</li> <li>2.2 Company systems, processes and work quality requirements</li> <li>2.3 Work inspection techniques</li> <li>2.4 Quality assurance principles</li> <li>2.5 Safety precautionary measures</li> <li>2.6 Handling materials, tools and equipment</li> </ul>
<p>3. Underpinning skills</p>	<ul style="list-style-type: none"> <li>3.1 Problem solving skills</li> <li>3.2 Communicating with superiors and co-workers</li> <li>3.3 Interpreting job specification and work order</li> </ul>
<p>4. Resource implications</p>	<p>The following resources must be provided</p> <ul style="list-style-type: none"> <li>4.1 Tools, equipment and facilities appropriate to processes or activity</li> <li>4.2 Materials relevant to the proposed activity</li> </ul>
<p>5. Method of assessment</p>	<p>Competency must be assessed through:</p> <ul style="list-style-type: none"> <li>5.1 Demonstration</li> <li>5.2 Written or oral short answer questions</li> <li>5.3 Practical exercises</li> </ul>
<p>6. Context for assessment</p>	<p>Competency may be assessed in the workplace or in simulated workplace environment.</p>

**UNIT OF COMPETENCY : USE HAND TOOLS**

**UNIT CODE : MEE721205**

**UNIT DESCRIPTOR : This unit covers the competencies required to use hand tools.**

<b>ELEMENTS</b>		<b>PERFORMANCE CRITERIA</b>	
		<i>Italicized</i> terms are elaborated in the Range of Variables	
1.	Select hand tools	1.1	<b>Hand tools</b> are selected based on the requirements of the <b>task</b> .
		1.2	Unsafe or defective tools are identified and marked for repair according to procedure.
2.	Use hand tools	2.1	Hand tools are used to produce the desired outcomes to job specifications.
		2.2	Tasks are performed in accordance with company or industry safety procedure.
3.	Maintain hand tools	3.1	<b>Routine maintenance</b> of hand tools is undertaken according to standard operating procedures, principles and techniques.
		3.2	Hand tools are stored in accordance with manufacturer's instruction/standard operating procedure.

## RANGE OF VARIABLES

VARIABLE	RANGE
1. Hand tools	Hand tools include but not limited to: 1.1 Hacksaws 1.2 Hammers (ball peen, chipping) 1.3 Punches 1.4 Screwdrivers 1.5 Wrenches 1.6 Scrapers 1.7 Chisels 1.8 Gouges 1.9 Files 1.10 Clamps
2. Task	Tasks may include: 2.1 Adjusting 2.2 Dismantling 2.3 Assembling 2.4 Finishing of item or components
3. Routine maintenance	<b><i>Routine maintenance may include:</i></b> 3.1 Cleaning 3.2 Lubricating 3.3 Tightening 3.4 Simple tool repair 3.5 Hand sharpening

## EVIDENCE GUIDE

1. Critical aspects of competency	Assessment requires evidence that the candidate: 1.1 Selected and used hand tools appropriate to the job 1.2 Performed routine maintenance and storage of hand tools
2. Underpinning knowledge and attitude	2.1 Types and uses of hand tools 2.2 Hand tool defects 2.3 Procedure, principles and techniques in maintenance of hand tools
3. Underpinning skills	3.1 Handling tools and materials 3.2 Communicating with superiors and co-workers 3.3 Interpreting instructions
4. Resource implications	The following resources must be provided 4.1 Tools, equipment and facilities appropriate to the process or activity 4.2 Materials relevant to the proposed activity
5. Method of assessment	Competency must be assessed through: 5.1 Demonstration 5.2 Written or oral short answer questions 5.3 Practical exercises
6. Context for assessment	Competency may be assessed in the workplace or in simulated workplace environment.

**UNIT TITLE** : **PREPARE WELD MATERIALS**

**UNIT CODE** : **MEE721206**

**DESCRIPTOR** : This unit covers the skills, knowledge and attitudes in preparing welding materials.

<b>ELEMENTS</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the range of Variables
1. Set up cutting equipment	1.1 Cutting equipment is set based on acceptable OH&S standards 1.2 Set up cutting equipment is appropriate for operation intended
2. Cut and prepare edge of materials	2.1 <i>Materials</i> are <i>cut</i> based on specified dimension/ <i>specifications</i> . 2.2 Task is performed in accordance with company or industry requirements and safety procedure.
3. Clean surfaces and edges	3.1 Surfaces are cleaned based on required specifications. 3.2 Task is performed in accordance with company or industry requirements and safety procedure
4. Prepare welding consumables	4.1 Consumables are prepared in accordance with required specifications 4.2 Welding consumables are prepared in accordance with manufacturer's instructions
5. Prepare welding safety and protective equipment	5.1 PPE are prepared based on acceptable OH&S requirements and standards

## RANGE OF VARIABLE

VARIABLE	RANGE
1. Materials and consumables	1.1 Mild steel 1.2 Carbon steel 1.3 Alloy steel (level III ) 1.4 Cutting gases 1.5 Gouging electrodes 1.6 Grinding/cutting discs 1.7 Run on/run off, backing plates/ring 1.8 Cutting accessories
2. Cut	Cut material using 2.1 Oxy-acetylene gas cutting equipment (manual and /or automatic) 2.2 Plasma cutting equipment 2.3 Shearing machine 2.4 Disc cutter
3. Specification	Specifications based on 3.1 Welding codes 3.2 Reference Industry standards 3.3 Client specification
4. Cleaned	Surfaces and edges are cleaned by 4.1 Grinding or sanding 4.2 Filing 4.3 Chemical washing (Degreaser)
5. Safety procedures	5.1 Wearing of required PPE 5.2 Securing oxy-acetylene tanks before, during and after use 5.3 Checking oxy-acetylene hose for gas leaks 5.4 Switch off equipment after use 5.5 Checking electrical equipment and devices

## EVIDENCE GUIDE

1. Critical aspects of competency	<p>Assessment requires evidence that the candidate:</p> <ul style="list-style-type: none"> <li>1.1 Performed edge preparation in accordance with WPS and safety procedures</li> <li>1.2 Used edge preparation equipment and tools in accordance with the requirements or manufacturer's instructions</li> </ul>
2. Underpinning knowledge	<ul style="list-style-type: none"> <li>2.1 Interpretation of plans and drawings</li> <li>2.2 Selection of appropriate method of edge preparation</li> <li>2.3 Selection of appropriate cutting equipment, accessories and supplies</li> <li>2.4 Operation of cutting equipment such as mechanical, gas and plasma</li> <li>2.5 Operation of grinding equipment</li> <li>2.6 Safety procedures for cutting and grinding</li> </ul>
3. Underpinning skills	<ul style="list-style-type: none"> <li>3.1 Measuring and communication skills</li> <li>3.2 Set up of cutting equipment such as mechanical, gas and plasma</li> <li>3.3 Cutting techniques</li> <li>3.4 Grinding techniques</li> <li>3.5 Observance of safety procedures</li> </ul>
4. Resource implications	<p>The following resources must be provided:</p> <ul style="list-style-type: none"> <li>4.1 Relevant documentation such as WPS and working drawing</li> <li>4.2 Supplies and materials</li> <li>4.3 Cutting equipment and facilities</li> <li>4.4 Grinding equipment and facilities</li> <li>4.5 Measuring tools</li> <li>4.6 PPE</li> <li>4.7 Stand-by fire fighting equipment</li> </ul>
5. Method of assessment	<p>Competency must be assessed through:</p> <ul style="list-style-type: none"> <li>5.1 Observation/evaluation</li> <li>5.2 Oral questioning</li> <li>5.3 Inspection of prepared edges</li> </ul>
6. Context of assessment	<p>Assessment may be conducted in the workplace or in a simulated work environment</p>

**UNIT TITLE** : **SET UP WELDING EQUIPMENT**

**UNIT CODE** : **MEE721207**

**DESCRIPTOR** : This unit covers the skills, knowledge and attitudes in preparing equipment for welding.

<b>ELEMENTS</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized terms</i> are elaborated in the Range of Variables
1.1 Set up welding machine	1.1 Requirements for welding are determined based on welding procedures and job specifications and/or technical drawings. 1.2 Welding machine is set up in accordance with job requirements, welding procedures and specifications, technical drawings and manufacturer's instructions. 1.3 Welding machine should be connected to an independent power supply and wired up or set to the polarity indicated in the welding procedures /specifications or as recommended by the manufacturer. 1.4 Current, voltage, and wire feed settings are fine-tuned or adjusted consistent with job requirements. 1.5 Task is completed without causing damage to the tools, equipment and materials and injury to self and others.
2. Set up welding accessories	2.1 Welding machine accessories and consumables are identified from job requirements, welding procedures and specifications. 2.1 Welding machine accessories and consumables are set up in accordance with job requirements, welding procedures and specifications and/or manufacturer's instructions. 2.2 Spools firmly locked to holder, rollers adjusted to correct tension. 2.3 Purging hoses, dampers, flow meter, regulators, torches and guns are properly installed where needed. 2.4 Gas tanks properly secured where needed.
3. Set up welding positioners, jigs and fixtures	3.1 Braces, stiffeners, rails and other jigs are provided in conformity with job requirements. 3.2 Work items/materials are protected from strong winds, drafts and rainfall
4. Set up pre-heating tools/equipment as required	4.1 Pre-heating equipment is set up based on job requirements and specifications 4.2 Equipment is operated in conformance with the manufacturer's instructions.

**RANGE OF VARIABLE**

<b>VARIABLE</b>	<b>RANGE</b>
1. Welding machine	Types, kind and uses of FCAW welding machines 1.1 Alternating current (AC) 1.2 Direct current (DC) 1.3 Constant current 1.4 Constant voltage
2. Polarity	Application and uses 2.1 Direct current – electrode positive (reverse polarity) 2.2 Direct current – electrode negative (straight polarity) 2.3 Alternating current
3. Accessories	3.1. welding guns 3.2 regulators and flow meters 3.3 gas hoses and adaptors 3.4 gas cylinders and gas heaters 3.5 filters, gas nozzle and insulators 3.6 contact tips 3.7 wire feeders and wire cutter 3.8 cable liners and gas diffusers
4. Gases	4.1 Pure inert gas (argon, etc.) 4.2 Mixed gases 4.3 Pure CO <sub>2</sub>

## EVIDENCE GUIDE

<p>1. Critical aspects of competency</p>	<p>Assessment requires evidence that the candidate</p> <ol style="list-style-type: none"> <li>1.1 Set up and install welding machine, accessories, welding positioners, jigs and fixtures and pre- heating equipment within allotted time and in accordance with OH&amp;S rules and accessible and convenient location.</li> <li>1.2 Applied housekeeping and 5S practices</li> </ol>
<p>2. Underpinning knowledge</p>	<ol style="list-style-type: none"> <li>2.1 Types and uses of welding equipment and accessories</li> <li>2.2 Power requirement and capacity of welding machine and its accessories</li> <li>2.3 Operating capacity of welding machine and accessories</li> <li>2.4 Basic electricity</li> <li>2.5 Shop safety, housekeeping and 5S procedures</li> </ol>
<p>3. Underpinning skills</p>	<ol style="list-style-type: none"> <li>3.1 Setting and operating welding machine and accessories</li> <li>3.2 Communication skills</li> <li>3.3 Recognizing operational abnormalities and faults in welding machine and accessories</li> <li>3.4 Fine tuning of welding machine and accessories for optimum operation</li> <li>3.5 Minor repairs/maintenance of welding machine and accessories</li> <li>3.6 Use of PPE</li> </ol>
<p>4. Resource implications</p>	<p>The following resources must be provided:</p> <ol style="list-style-type: none"> <li>4.1 Appropriately ventilated work area/shop with welding facilities, machines and accessories</li> <li>4.2 PPE</li> </ol>
<p>5. Method of assessment</p>	<p>Competency must be assessed through:</p> <ol style="list-style-type: none"> <li>5.1 Observation/evaluation</li> <li>5.2 Oral questioning</li> </ol>
<p>6. Context of assessment</p>	<p>Assessment may be conducted in the workplace or in a simulated work environment.</p>

**UNIT TITLE** : **FIT UP WELD MATERIALS**

**UNIT CODE** : **MEE721208**

**DESCRIPTOR** : This unit covers the skills, knowledge and attitudes in fitting up welding materials.

<b>ELEMENTS</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the Range of Variables
1. Perform tack welding	1.1 Tack welding is <i>performed in accordance with the requirements of WPS and client's specifications.</i> 1.2 Tack welding is performed <i>visually and dimensionally acceptable.</i> . 1.3 <i>Backing plate, stiffener, running plate is installed as required.</i> 1.4 <i>Joints are free from rust, paints, grease and other foreign materials prior to fit up or tacking.</i>
2. Check gap and alignment	2.1 <i>Root gap</i> is performed in accordance with the requirements of WPS. 2.2 <i>Alignment</i> is checked within the range of acceptability of code and standard. 2.3 Fitted materials are visually free from stresses
3. Set up welding positioner	3.1 <i>Weld specimen is positioned and secured according to the requirements.</i>

**RANGE OF VARIABLE**

<b>VARIABLE</b>	<b>RANGE</b>
1. Tack welding	Kinds of tacking 1.1 Bridge tacking 1.2 Permanent tacking 1.3 Temporary tacking
2. Visually and dimensionally acceptable	2.1 Acceptable tack welds 2.2 Fully fused to the base metal 2.3 Free from defects and discontinuities 2.4 Evenly distributed
3. Root gap	3.1 WPS requirements 3.2 Client requirements
4. Backing materials	4.1 Stiffeners 4.2 Backing plate 4.3 Strong back
5. Alignment	5.1 Codes and specifications 5.2 Client requirements

## EVIDENCE GUIDE

1. Critical aspects of competency	Assessment requires evidence that the candidate 1.1 performed tack welding 1.2 checked gap and alignment 1.3 set up welding positioners
2. Underpinning knowledge	2.1 Fit up tolerances 2.2 Mensuration 2.3 WPS 2.4 Welding materials and consumables 2.5 Drawing and plan interpretation 2.6 Welding codes (symbols) 2.7 Identification of weld defects 2.8 Fit up
3. Underpinning skills	3.1 Applying weld techniques 3.2 Handling welding materials and consumables 3.3 Rectifying weld defects 3.4 Measuring skills 3.5 Communication skills 3.6 Pre-heating technique 3.7 Observance of safety procedures
4. Resource implications	The following resources must be provided: 4.1 Drawing and plans 4.2 Appropriately ventilated work area/shop with welding facilities, machines and accessories 4.3 PPE
5. Method of assessment	Competency must be assessed through: 5.1 Observation/evaluation 5.2 Oral questioning
6. Context of assessment	Assessment may be conducted in the workplace or in a simulated work environment.

**UNIT TITLE** : **REPAIR WELDS**

**UNIT CODE** : **MEE721209**

**DESCRIPTOR** : This unit covers the skills, knowledge and attitudes in repairing welds.

<b>ELEMENTS</b>	<b>PERFORMANCE CRITERIA</b> <i>Italicized</i> terms are elaborated in the Range of Variables
1. Mark/locate weld defects	1.1 <i>Weld defects</i> are identified according to recommended practice 1.2 weld defects are located and marked according to procedures
2. Prepare tools and equipment	2.1 Tools and equipment <i>are prepared based on job requirements and provision of wind barriers.</i> 2.2 <i>Task is performed in accordance with company or industry requirements and safety procedure</i>
3. Remove defects	3.1 Weld defects are <i>removed/excavated</i> in accordance with approved industry procedures or client requirements. 3.2 Removal of non-defective welds is minimized and cleaned. 3.3 Visual and dye-penetrant test is performed to verify the extent of removal of defects, where applicable 3.4 Welding inspector is informed to verify the extent of defect removal. 3.5 Task is performed in accordance with company or industry requirement and safety procedure
4. Perform re-welding	4.1 Re-welding is performed in accordance with approved repair procedure. 4.2 Task is performed in accordance with company or industry requirement and safety procedure 4.3 Re-welding is performed with no new weld defects or damages occurred 4.4 Weld is visually checked after re-welding for acceptability

**RANGE OF VARIABLE**

<b>VARIABLE</b>	<b>RANGE</b>
1. Weld defects	1.1 Porosity 1.2 Root undercut 1.3 and solid material inclusion 1.4 Concavity/convexity 1.5 Degree of reinforcement 1.6 Burn Through 1.7 Crater cracks 1.8 Cracks 1.9 Lack of Fusion (tie-in) 1.10 Pinholes/Blowholes 1.11 Under Fill 1.12 Excess/incomplete penetration 1.13 Slag / inclusion 1.14 Overlap 1.15 Misalignment 1.16 Distortion
2. Tools and equipment	2.1 Welding machine and accessories 2.2 Gouging outfit and accessories 2.3 Portable grinder 2.4 Chipping hammer 2.5 Files 2.6 Extension cord and lightings 2.7 Barriers 2.8 Dye-penetrant kit
3. Removed/excavated	Defects removed by 3.1 Grinding 3.2 Arc/air Gouging 3.3 Cutting (mechanical, gas) 3.4 Plasma gouging

## EVIDENCE GUIDE

1. Critical aspects of competency	Assessment requires evidence that the candidate repaired weld defects within the approved weld repair procedures
2. Underpinning knowledge	2.1 Interpretation of weld repair procedures and WPS 2.2 Causes and identification of weld defects 2.3 Materials and consumables 2.4 Welding Equipment and Tools 2.5 Welding Codes (symbols) 2.6 Repair techniques 2.7 Selection and use of PPE
3. Underpinning skills	3.1 Operating weld defect removal tools and equipment 3.2 Applying correct weld techniques 3.3 Measuring skills 3.4 Communication skills 3.5 Rectifying weld defects 3.6 Handling welding tools and equipment 3.7 Handling materials and consumables 3.8 Identifying weld defects
4. Resource implications	The following resources must be provided: 4.1 Weld defect removal and repair facilities and equipment 4.2 Supplies and materials 4.3 PPE 4.4 Relevant documentation such as WPS and approved repair procedure
5. Method of assessment	Competency must be assessed through: 5.1 Observation and interview 5.2 Performance record
6. Context of assessment	Assessment may be conducted in the workplace or in a simulated work environment.

## CORE COMPETENCY

**UNIT OF COMPETENCY:** Weld carbon steel pipes using FCAW

**UNIT CODE:** MEE721310

**DESCRIPTOR:** This unit covers the skills, knowledge and attitudes required in welding carbon steel pipes using FCAW process.

ELEMENTS	PERFORMANCE CRITERIA
1. Perform root pass (backing material)	<p><i>Italicized terms</i> are elaborated in the Range of Variables</p> <p>1.1 Root pass is performed in accordance with <i>WPS</i> and/or client specifications.</p> <p>1.2 Weld is visually checked for <i>defects</i> and repaired, as required (root pass is performed without defects)</p> <p>1.3 Weld is visually acceptable in accordance with applicable codes and standards</p>
2. Clean root pass	<p>2.1 Root pass is cleaned and is free from defects and discontinuities (root pass is cleaned without defects and discontinuities)</p> <p>2.2 Task is performed in accordance with approved WPS</p>
3. Weld subsequent/ filling passes	<p>3.1 Subsequent/ filling passes are performed in accordance with approved WPS</p> <p>3.2 Weld is visually checked for defects and repaired, as required</p> <p>3.3 Weld is visually acceptable in accordance with applicable codes and standards</p>
4. Perform capping	<p>4.1 Capping is performed in accordance with WPS and/or client specifications</p> <p>4.2 Weld is visually checked for defects and repaired, as required</p> <p>4.3 Weld is visually acceptable in accordance with applicable codes and standards</p>

**RANGE OF VARIABLE**

VARIABLE	RANGE
1. WPS	WPS Requirements 1.1 Welding positions 1.1.1 2G and 5G and/or 6G 1.2 Wall thickness 1.2.1 1.6mm and above 1.3 Type of material 1.3.1 Carbon and mild steel pipes 1.3.2 Diameter 25.4mm (1inch) and above 1.4 Type and size of flux cored electrode 1.5 Travel speed 1.6 Current setting (polarity, amperage, voltage) 1.7 Backing materials (weld metal, backing ring or ceramics) 1.8 Welding accessories 1.8.1 Transformer Rectifier Type 1.8.2 Wire feeder 1.9 Joint preparation
2. Defects	2.1 Porosity 2.2 Undercut 2.3 Arc Strike 2.4 Spatters 2.5 Wire, solid and slag inclusion 2.6 Concavity/convexity 2.7 Degree of reinforcement 2.8 Burn Through 2.9 Crater cracks 2.10 Cracks 2.11 Lack of Fusion (tie-in) 2.12 Pinholes/Blowholes 2.13 Under Fill 2.14 Overlap 2.15 Misalignment 2.16 Distortion

## EVIDENCE GUIDE

<b>1 Critical Aspects of Competency</b>	Assessment requires evidence that the candidate welded carbon steel pipes using FCAW in 2G, 5G and/or 6G positions to acceptable standard following the approved WPS.
<b>2 Underpinning Knowledge</b>	2.1 Drawing/Plan/WPS interpretation 2.2 Materials and consumables 2.2.1 Flux cored electrode (self-shielded and gas shielded) 2.2.2 Shielding gases 2.3 Welding Equipment and Tools 2.4 Basic Mathematics (MDAS) 2.5 Welding Codes and symbols 2.6 Identification of weld defects
<b>3 Underpinning Skills</b>	3.1 Measuring skills 3.2 Communication skills 3.3 Rectifying weld defects 3.4 Applying welding techniques for FCAW 3.5 Handling welding tools and equipment 3.6 Handling materials and consumables and checking purity of shielding gas 3.7 Philippine OH&S Rules and/or client's safety procedure
<b>4 Resource Implications</b>	The following resources must be provided: 4.1 Well ventilated work area/shop with FCAW facilities and equipment 4.2 Supplies and materials 4.3 PPE 4.4 Fumes extractor, if applicable 4.4 Relevant documentation such as WPS and working drawing 4.5 Stand-by fire fighting equipment
<b>5 Method of Assessment</b>	Competency must be assessed through: 5.1 Demonstration/ observation and oral questioning 5.2 Written test 5.3 Portfolio (awards, records, certificates, endorsements, etc.)
<b>6 Context of Assessment</b>	Assessment may be conducted in the workplace or in a simulated work environment.

## SECTION 3 TRAINING STANDARDS

These guidelines are set to provide the Technical and Vocational Education and Training (TVET) providers with information and other important requirements to consider when designing training programs for FLUX CORED ARC WELDING (FCAW) NC II.

### 3.1 CURRICULUM DESIGN

Course Title: **FLUX CORED ARC WELDING**

**NC Level II**

Suggested Nominal Training Hours: 18 hrs. ( Basic Competencies)  
56 hrs. ( Common Competencies)  
194 hrs. ( Core Competencies)

Course Description:

This course is designed to enhance the knowledge, skills and attitudes in Flux Cored Arc Welding NCII in accordance with industry standards. It covers core competencies such as Setting-up Welding Equipment, Preparing Weld Materials, Fitting up Weld Materials, Welding Carbon Steel Plates Using FCAW, Welding Carbon Steel Plates and Pipes Using FCAW and Repairing Welds.

### BASIC COMPETENCIES

Unit of Competency	Learning Outcomes	Methodology	Assessment Approach
1. Participate in workplace communication	1.1 Obtain and convey workplace information. 1.2 Complete relevant work related documents. 1.3 Participate in workplace meeting and discussion	<ul style="list-style-type: none"> <li>• Group discussion</li> <li>• Interaction</li> </ul>	<ul style="list-style-type: none"> <li>• Demonstration</li> <li>• Observation</li> <li>• Interviews/ questioning</li> </ul>
2. Work in a team environment	2.1 Describe and identify team role and responsibility in a team. 2.2 Describe work as a team member.	<ul style="list-style-type: none"> <li>• Discussion</li> <li>• Interaction</li> </ul>	<ul style="list-style-type: none"> <li>• Demonstration</li> <li>• Observation</li> <li>• Interviews/ questioning</li> </ul>
3. Practice career professionalism	3.1 Integrate personal objectives with organizational goals. 3.2 Set and meet work priorities. 3.3 Maintain professional growth & development.	<ul style="list-style-type: none"> <li>• Discussion</li> <li>• Interaction</li> </ul>	<ul style="list-style-type: none"> <li>• Demonstration</li> <li>• Observation</li> <li>• Interviews/ questioning</li> </ul>

4. Practice occupational health and safety	8.1 Evaluate hazard and risks 8.2 Control hazards and risks 8.3 Maintain occupational health and safety awareness	<ul style="list-style-type: none"> <li>• Discussion</li> <li>• Plant tour</li> <li>• Symposium</li> </ul>	<ul style="list-style-type: none"> <li>• Observation</li> <li>• Interview</li> </ul>
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### COMMON COMPETENCIES

Unit of Competency	Learning Outcomes	Methodology	Assessment Approach
1. Perform work safely	1.1 Identify hazardous areas and conditions 1.2 Use protective clothing and devices 1.3 Perform safe handling of tools, equipment and materials 1.4 Explain/perform first aid procedure 1.5 Use fire extinguisher	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Practical application</li> </ul>	<ul style="list-style-type: none"> <li>• Oral questioning</li> <li>• Written</li> <li>• demonstration</li> </ul>
2. Contribute to quality system	2.1 Inspect work done 2.2 Apply quality standards to work 2.3 Protect company/ institution properties 2.4 Protect customer interest	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Practical application</li> </ul>	<ul style="list-style-type: none"> <li>• Oral questioning</li> <li>• Written</li> <li>• Demonstration</li> </ul>
3. Use hand tools	3.1 Use different handtools 3.2 Maintain handtools	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Practical application</li> </ul>	<ul style="list-style-type: none"> <li>• Oral questioning</li> <li>• Written</li> <li>• Demonstration</li> </ul>
4. Interpret blueprints	4.1 Interpret technical drawing. 4.2 Interpret welding symbols	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Practical application</li> </ul>	<ul style="list-style-type: none"> <li>• Oral questioning</li> <li>• Written test</li> </ul>
5. Perform Industry calculations	5.1 Solve mathematical problems 5.2 Convert systems of measurement 5.3 Measure workpiece	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Practical application</li> </ul>	<ul style="list-style-type: none"> <li>• Oral questioning</li> <li>• Written test</li> </ul>

<p>6. Prepare weld materials</p>	<p>6.1 Identify the different cutting equipment and accessories          6.2 Identify types of mild steel electrodes          6.3 Identify types of joints and edge preparation          6.4 Identify protective equipment          6.5 Prepare welding consumables, tools and accessories          6.6 Layout on materials          6.7 Set-up cutting equipment          6.8 Cut and prepare edge of materials</p>	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Practical application</li> </ul>	<ul style="list-style-type: none"> <li>• Observation</li> <li>• Demonstration and oral questioning</li> <li>• Written test</li> </ul>
<p>7. Set-up Welding Equipment</p>	<p>7.1 Explain welding principles and concepts.          7.2 Identify the parts of welding machine          7.3 Set up welding machine and accessories          7.4 Set up welding positioners, jigs and fixtures          7.5 Set up pre-heating equipment (<i>as required</i>)</p>	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Demonstration</li> </ul>	<ul style="list-style-type: none"> <li>• Observation and oral questioning</li> <li>• Demonstration and oral questioning</li> <li>• Written test</li> </ul>
<p>8. Fit up Weld Materials</p>	<p>8.1 Explain the importance of backing plate and stiffener.          8.2 Explain the methods of striking an arc          8.3 Perform striking an arc          8.4 Tack weld specimen, backing plate and stiffener.</p>	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Demonstration</li> </ul>	<ul style="list-style-type: none"> <li>• Observation and oral questioning</li> <li>• Demonstration and oral questioning</li> <li>• Written test</li> </ul>
<p>9. Repair Welds</p>	<p>9.1 Identify causes and prevention of the different weld defects          9.2 Mark/locate weld defects          9.3 Prepare tools and equipment          9.4 Remove defects          9.5 Perform re-welding</p>	<ul style="list-style-type: none"> <li>• Lecturette</li> <li>• Demonstration</li> </ul>	<ul style="list-style-type: none"> <li>• Observation and oral questioning</li> <li>• Demonstration and oral questioning</li> <li>• Written test</li> </ul>

## CORE COMPETENCIES

<b>Unit of Competency</b>	<b>Learning Outcomes</b>	<b>Methodology</b>	<b>Assessment Approach</b>
1. Weld carbon steel pipes using FCAW	1.1 Perform groove weld on pipe in different positions <ul style="list-style-type: none"><li>• 2G</li><li>• 5G</li><li>• 6G</li></ul>	<ul style="list-style-type: none"><li>• Lecturette</li><li>• Demonstration</li></ul>	<ul style="list-style-type: none"><li>• Observation and oral questioning</li><li>• Demonstration and oral questioning</li><li>• Written test</li></ul>

### 3.2 TRAINING DELIVERY

The delivery of training should adhere to the design of the curriculum. Delivery should be guided by the 10 basic principles of competency-based TVET.

- The training is based on curriculum developed from the competency standards;
- Learning is modular in its structure;
- Training delivery is individualized and self-paced;
- Training is based on work that must be performed;
- Training materials are directly related to the competency standards and the curriculum modules;
- Assessment is based in the collection of evidence of the performance of work to the industry required standard;
- Training is based both on and off-the-job components;
- Allows for recognition of prior learning (RPL) or current competencies;
- Training allows for multiple entry and exit; and
- Approved training programs are Nationally Accredited

*The competency-based TVET system recognizes various types of delivery modes, both on and off-the-job as long as the learning is driven by the competency standards specified by the industry. The following training modalities may be adopted when designing training programs:*

- The dualized mode of training delivery is preferred and recommended. Thus programs would contain both in-school and in-industry training or fieldwork components. Details can be referred to the Dual Training System (DTS) Implementing Rules and Regulations.
- Modular/self-paced learning is a competency-based training modality wherein the trainee is allowed to progress at his own pace. The trainer just facilitates the training delivery.
- Peer teaching/mentoring is a training modality wherein fast learners are given the opportunity to assist the slow learners.
- Supervised industry training or on-the-job training is an approach in training designed to enhance the knowledge and skills of the trainee through actual experience in the workplace to acquire specific competencies prescribed in the training regulations.
- Distance learning is a formal education process in which majority of the instruction occurs when the students and instructor are not in the same place. Distance learning may employ correspondence study, audio, video or computer technologies.

### 3.3 TRAINEE ENTRY REQUIREMENTS

Trainees or students wishing to gain entry into this course should possess the following requirements:

- completed training in FCAW NC I or a holder of FCAW NC I
- can communicate either oral and written
- physically and mentally fit
- can perform basic mathematical computation

### 3.4 LIST OF TOOLS, EQUIPMENT AND MATERIALS FLUX CORED ARC WELDING - NC II

Recommended list of tools and materials per trainee for **FLUX CORED ARC WELDING - NC II**

TOOLS (for 25 trainees)		EQUIPMENT (for 25 trainees)		MATERIAL (per trainee)	
Qty.	Description	Qty.	Description	Qty.	Description
25 pcs.	Chipping Hammer	12 units	FCAW Welding machine, FCAW gun and accessories	1 reel	Filler wire E71T-I (or equivalent) 1mm dia.
75 pcs.	Steel brush	12 pcs.	Welding positioners	30 pcs	Carbon steel pipe, schedule 40, 150mm dia. X 150mm
12 pcs.	Plier/tongs	12 units	Portable disc grinder	18 pcs	Carbon steel pipe, schedule 80, 150mm dia. X 150mm
20 pcs.	Files-bastard cut	1 unit	Exhaust fan	72 pcs.	Cutting disc 3/32" x 5/8" x 4" dia.
25 pcs.	Welding Mask	2 units	Work bench w/ bench vice on 4 corners	36 pcs.	Grinding disc 1/4" x 5/8" x 4" dia.
25 sets	Leather apron/jacket	2 sets	Oxy-acetylene/Oxy-LPG cutting outfit	5 cyl.	Shielding gas (75% argon 25% CO2)
50 sets	Leather gloves, long	1 unit	Pedestal /bench grinding machine	1 cyl.	oxygen
5 pcs.	Safety goggles, wide vision, clear	1 unit	Industrial fan	1 cyl.	LPG or Acetylene
5 pcs.	Oxy-acetylene Goggles			3 pcs.	Dark glass
12 pcs.	Try square 300 mm. Long			46 pcs.	Lens clear glass

12 pcs.	Steel square 300 mm. long			1 tube	Metal marker
12 pcs.	Files-half round				
5 pcs.	Fillet gauge				
1 pc.	Wire Cutter				
1 pc.	Hand Hacksaw				

Note: Tools and equipment for all welding process.  
\* for FCAW welding process

### 3.5 TRAINING FACILITIES FLUX CORED ARC WELDING - NC II

The welding workshop must be of concrete structure. Based on class size of 25 students/trainees the space requirements for the teaching/learning and circulation areas are as follows:

TEACHING/LEARNING AREAS	SIZE IN METERS	AREA IN SQ. METERS	QTY	TOTAL AREA IN SQ. METERS
<b>Welding Booth</b>	2 X 1.5	3	5	15
Grinding Booth*	2 X 1.5	3	2	6
Materials/Preparation Area*	2 X 2	4		4
Bench work Area*	1.5 X 2.5	4	2	8
Tool Room & S/M Storage Area*	4 X 5	20		20
Learning Resource Area*	5 X 9	45		45
Wash Area /Comfort Room (male & female) *	2.5 X 4	10		10
Total				108
Circulation Area**				32
<b>Total Workshop Area</b>				<b>140</b>

\* This area can also be used by other welding courses.

\*\* Area requirement is equivalent to 30% of the total teaching/learning areas

### **3.6 TRAINERS QUALIFICATIONS FOR FCAW WELDER**

#### **FLUX CORED ARC WELDING - NC II**

##### **TRAINER QUALIFICATION (TQ II)**

- Must be a holder of FCAW NC II
- Must have undergone training on Training Methodology II (TM II)
- Must be physically and mentally fit
- \*Must have at least 2 years job/industry experience
- Must be a civil service eligible (for government position or appropriate professional license issued by the Professional Regulatory Commission)

\* Optional. Only when required by the hiring institution

Reference: TESDA Board Resolution No. 2004 03

### **3.7 INSTITUTIONAL ASSESSMENT**

Institutional Assessment is to be undertaken by trainees to determine their achievement of units of competencies. A certificate of achievement is issued for each unit of competency.

## **SECTION 4 NATIONAL ASSESSMENT AND CERTIFICATION ARRANGEMENTS**

- 4.1 To attain the Qualification of FCAW Welding NC II, the candidate must demonstrate competence in all the units of competency listed in Section 1. Successful candidates shall be awarded a National Certificate signed by the TESDA Director General.
- 4.2 Assessment shall focus on the core unit of competency, weld carbon steel pipes using FCAW. The basic and common units shall be integrated or assessed concurrently with the core units.
- 4.3 The following are qualified to apply for assessment and certification:
  - 4.3.1 Graduates of formal, non-formal and informal including enterprise-based training programs.
  - 4.3.2 Experienced workers (wage employed or self employed)
- 4.4 The guidelines on assessment and certification are discussed in detail in the "Procedures Manual on Assessment and Certification" and "Guidelines on the Implementation of the Philippine TVET Qualification and Certification System (PTOQS)".

## Competency Map Metals and Engineering Sector (WELDING)

<b>CORE COMPETENCIES</b>	Weld carbon steel plates using SMAW	Weld carbon steel plates and pipes using SMAW	Weld alloy steel plates using SMAW	Weld alloy steel pipes using SMAW	Weld carbon steel plates using GTAW	Weld carbon steel pipes using GTAW	Weld carbon steel plates using GMAW
	Perform gas welding in carbon steel plates and tubes	Perform gas welding in alloy steel plates and tubes	Weld plates using SAW	Weld pipes using SAW	Weld alloy steel plates using GTAW	Weld carbon steel pipes using GMAW	Weld alloy steel pipes using GMAW
	Weld carbon steel plates using FCAW	Weld carbon steel pipes using FCAW	Weld alloy steel plates using FCAW	Weld alloy steel pipes using FCAW	Weld alloy steel pipes using GTAW	Weld alloy steel plates using GMAW	
<b>COMMON COMPETENCIES</b>	Apply safety practices	Interpret drawing and sketches	Perform industry calculations	Contributes to quality system	Use hand tools		
	Prepare weld materials	Set-up welding equipment	Fit up weld materials	Repair welds			
<b>BASIC COMPETENCIES</b>	Receive and respond to workplace communication	Demonstrate work values	Participate in workplace communication	Work in team environment	Lead in workplace communication	Develop and practice negotiation skills	Use mathematical concepts and techniques
	Work with others	Practice basic housekeeping procedures	Practice career professionalism	Practice occupational health and safety procedures	Lead small teams	Solve problems related to work activities	Use relevant technologies
	Utilize specialist communication skills	Develop team and individual	Apply problem-solving techniques in the workplace	Collect, analyze and organize information	Plan and organize work	Promote environmental protection	

**Legend**  
**FCAW NC II**

## DEFINITION OF TERMS

- 1) **base metal** – the metal that is to be worked or welded
- 2) **weld bead** – a deposit of filler metal from a single welding pass
- 3) **weld defect**– an irregularity that spoils the weld appearance or impairs the effectiveness of the weld or weldment by causing weakness or failure
- 4) **weld line** – the junction of weld metal and the base metal, or the junction of base metal parts when filler metal is not used
- 5) **weldment** – an assembly or structure whose component parts are joined by welding
- 6) **welding** – joining two metals by applying heat to melt and fuse them, with or without filler metal
- 7) **welding electrode** – the current-carrying rod used to strike an arc between rod and metal
- 8) **welding rod** – filler metal in the form of a rod or heavy wire
- 9) **welding torch** – a gas mixing and burning tool for the welding of metal

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