

Title	Weld stainless steel tube using the gas tungsten arc welding process		
Level	4	Credits	12

Purpose	<p>This unit standard is for people welding in position stainless steel tube using the gas tungsten arc welding (GTAW) process.</p> <p>People credited with this unit standard are able to: prepare to weld stainless steel tube in position using the GTAW process; weld stainless steel tube in position using the GTAW process; and inspect and repair stainless steel GTAW tube welds.</p>
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Classification	Mechanical Engineering > Welding
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Available grade	Achieved
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Guidance Information

1 Legislation and references

Legislation, regulations and/or industry standards relevant to this unit standard include but are not limited to the:

Health and Safety at Work Act 2015.

WorkSafe Good Practice Guide “Health and Safety in Welding.” Available at:

<https://www.worksafe.govt.nz/assets/dmsassets/WKS-13-Welding-GPG.pdf>

Weld Australia (formerly Welding Technology Institute of Australia (WTIA) Technical Note 7 – Health and Safety in Welding. Available at: [Product Details Weld Australia Member Portal](#).

Welder qualification Standard - AS/NZS 2980:2018 Appendix C, *Qualification of welders for fusion welding of steels - Additional requirements for Australia and New Zealand*, or equivalent. Available at: www.standards.govt.nz.

ISO 6947:2019, *Welding and allied processes – Welding positions*. Available at: www.standards.govt.nz.

Any new, amended or replacement Acts, regulations, standards, codes of practice, guidelines, or authority requirements or conditions affecting this unit standard will take precedence for assessment purposes.

2 Definitions

Accepted industry practice – approved codes of practice and standardised procedures accepted by the engineering industry as examples of best practice.

GTAW – Gas Tungsten Arc Welding, also referred to as *Tungsten Inert Gas* (TIG) welding.

Industry standard – AS/NZS 2980:2018 Appendix C, or equivalent.

Manufacturer's instructions are instructions provided by manufacturers of substances, equipment, and machinery. These instructions may include details on safe and correct handling, use and storage of substances and/or details on substance properties. Examples are labels on substance containers, product data sheets, and operator's manuals.

Stainless steel – typically the austenitic stainless steel grades AISI 304L and 316L, but may also include other materials such as the duplex stainless steels.

Welding procedure specification (WPS) – written specification providing all the necessary technical details for a specific welding application meeting the requirements of the appropriate industry standard.

3 Assessment information

Evidence presented for assessment against this unit standard must be consistent with safe working practices and be in accordance with legislative requirements and workplace procedures, and meet accepted industry practice. This includes but is not limited to the knowledge, use and maintenance of relevant tools and equipment.

4 Recommended skills and knowledge

It is recommended that people seeking credit for this unit standard first hold credit for Unit 2676, *Weld stainless steel sheet using the gas tungsten arc welding process*, or equivalent skills and knowledge.

Outcomes and performance criteria

Outcome 1

Prepare to weld stainless steel tube in position using the GTAW process.

Performance criteria

1.1 Equipment is selected to meet WPS requirements.

Range power source rating and duty cycle, torch, shielding gas supply, welding cables, work clamp.

1.2 Equipment is assembled, set up, and maintained ready for use in accordance with manufacturer's instructions.

Range torch, tungsten electrode, nozzle, collet, and cap; shielding and purge gas supplies; welding cables; work clamp.

1.3 Stainless steel tube is prepared and assembled in accordance with WPS, and purging gas connected as required.

Range cleaning, edge preparation, tack welding to correct alignment.

1.4 Consumables are selected in accordance with welding procedure specification WPS.

Range filler metal specification and classification; shielding and purge gases by brand name and composition.

Outcome 2

Weld stainless steel tube in position using the GTAW process.

Range 2 welds;
tube – 50-100 mm diameter, 1.5 mm nominal wall thickness;
positions – butt welds in 2G and 5G positions, or in 6G position (ISO 6947 PC, PH, H-L045).

Performance criteria

2.1 Workplace safety procedures are followed.

Range examples are – use of personal protective equipment, checking of equipment for faults, use of fume extraction equipment, elimination of risk of fire or explosion, protection from arc radiation, protection from electrocution.

2.2 Welds are deposited on stainless steel tube to industry standard and in accordance with WPS.

2.3 Welds are cleaned in accordance with accepted industry practice.

Outcome 3

Inspect and repair stainless steel GTAW tube welds.

Performance criteria

3.1 Weld imperfections are identified by visual examination and workshop tests.

Range one visual external and internal examination for each weld;
one face bend and one root bend test for each weld.

3.2 Weld imperfections are evaluated using acceptance levels in industry standard.

3.3 A weld defect is repaired in accordance with WPS and to industry standard.

Planned review date	31 December 2027
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Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	30 November 1994	31 December 2022
Revision	2	14 April 1997	31 December 2022
Revision	3	5 January 1999	31 December 2022
Review	4	28 October 1999	31 December 2022
Review	5	4 April 2001	31 December 2022
Rollover and Revision	6	20 April 2006	31 December 2022
Review	7	22 May 2009	31 December 2022
Review	8	20 July 2017	31 December 2025
Review	9	26 January 2023	N/A

Consent and Moderation Requirements (CMR) reference

0013

This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.

Comments on this unit standard

Please contact Hanga-Aro-Rau Manufacturing, Engineering and Logistics Workforce Development Council qualifications@hangaarorau.nz if you wish to suggest changes to the content of this unit standard.