

Title	Weld steel structures in all positions using the flux cored arc welding processes		
Level	4	Credits	10

Purpose	<p>This unit standard is for people welding steel structures in all positions to Category SP of AS/NZS 1554.1, or equivalent, using the flux cored arc welding (FCAW) process.</p> <p>People credited with this unit standard are able to: prepare to weld steel in all positions using the FCAW process; weld steel structures in all positions using the FCAW process; and inspect and repair FCAW steel 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](#).

Industry Standard - AS/NZS 1554.1:2014, *Structural steel welding – Part 1: Welding of steel structures*, or equivalent. Available at: www.standards.govt.nz.

Welder qualification Standards: AS/NZS 2980:2018, *Qualification of welders for fusion welding of steels - Additional requirements for Australia and New Zealand*.

AS/NZS ISO 9606.1:2017, *Qualification testing of welders - Fusion welding - Part 1: Steels*, 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.

FCAW – flux-cored arc welding (gas shielded).

Industry standard – AS/NZS 1554.1:2014, AS/NZS 2980:2018, or equivalent.

Manufacturer's instructions – 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.

Steel – weldable low-carbon unalloyed (carbon-manganese) steel, also referred to as *mild steel*.

Welding procedure specifications (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 30282, *Weld steel structures in the downhand positions using the gas shielded flux cored arc welding process*, or equivalent skills and knowledge.

Outcomes and performance criteria

Outcome 1

Prepare to weld steel in all positions using the FCAW process.

Performance criteria

1.1 Equipment is selected to meet WPS requirements.

Range power source rating and duty cycle; wire feed system and gun; shielding gas supply if used; welding cables; work clamp.

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

Range wire feed system; gun liner, nozzle and contact tip; shielding gas supply if used; welding cables; work clamp.

1.3 Steel is prepared and assembled in accordance with WPS.

Range cleaning, providing root face where required, tack welding to correct alignment and preset.

1.4 Consumables are selected in accordance with WPS.

Range electrodes by specification and classification;
shielding gases by brand name and composition.

Outcome 2

Weld steel structures in all positions using the FCAW process.

Range 5 welds;
material thickness – 8 to 16 mm;
welds – tee joints in 3F and 4F positions (ISO 6947 PF, PD), butt joints in 2G, 3G, and 4G positions (ISO 6947 PC, PF, PE).

Performance criteria

2.1 Workplace safety procedures are followed.

Range 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 Measures to minimise welding distortion are applied in accordance with accepted industry practice.

Range examples are – weld sequence, restraint, backstepping.

2.3 Welds are deposited on steel to industry standard and in accordance with WPS.

2.4 Welds are cleaned in accordance with accepted industry practice.

Outcome 3

Inspect and repair FCAW steel welds.

Performance criteria

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

Range examples of workshop tests are – nick break, fillet break-over, bend, macro examination. One workshop test is required for each weld from Outcome 2.

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

3.3 A weld defect is repaired to industry standard.

Range one of the following positions 3F, 4F, 2G, 3G, 4G (ISO 6947 PF, PD, PC, PF, PE).

Replacement information	This unit standard and unit standard 30278 replaced unit standard 2684.
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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	20 July 2017	31 December 2020
Revision	2	27 February 2020	31 December 2025
Review	3	26 January 2023	N/A

Consent and Moderation Requirements (CMR) reference	0013
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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.