

Title	Weld steel structures in the downhand positions using the gas shielded flux cored arc welding process		
Level	3	Credits	6

Purpose	<p>This unit standard is for people welding steel structures in the downhand positions using the gas shielded flux cored arc welding (FCAW) process.</p> <p>People credited with this unit standard are able to: prepare to weld steel in the downhand positions using the FCAW process; weld steel in the downhand 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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Prerequisites	Unit 33135, <i>Demonstrate knowledge of safety and health while welding and thermal cutting</i> , or demonstrate equivalent knowledge and skills.
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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 – Part1: 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, pending review of this unit standard.

2 Definitions

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

Downhand positions – flat, and horizontal-vertical welding positions

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 – a work instruction providing all the necessary technical details for a specific welding application.

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.

Outcomes and performance criteria

Outcome 1

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

Performance criteria

1.1 Equipment is selected to meet welding procedure requirements.

Range power source rating and duty cycle, wire feed system and gun, 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 wire feed system; gun liner, nozzle and contact tip; shielding gas supply; welding cables; work clamp.

1.3 Steel is prepared and assembled in accordance with welding procedure.

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

1.4 Consumables are selected in accordance with welding procedure.

Range consumables are identified by specification and classification; shielding gases are identified by brand name and composition.

Outcome 2

Weld steel in the downhand positions using the FCAW process.

Range 3 welds;
material thickness – 8 to 16 mm;
positions – 1F, 2F, 1G (ISO 6947 PA, PB, PA).

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 Consumables are handled in accordance with manufacturer's instructions.

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

2.4 Damage to structural components is minimised and distortion is controlled during welding and handling in accordance with accepted industry practice.

2.5 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;
evidence of two tests is required.

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

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

Replacement information	This unit standard and unit standard 30283 replaced unit standard 2673.
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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 2025
Review	2	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.