

EN 1090. Pre-certification Checklist.



We have prepared an easy-to-follow checklist outlining the path to EN 1090 certification to ensure a successful outcome for your business.

Please note your welding processes may possibly already be compliant with EN 1090 if you already follow/adhere to EN ISO 3834 (welding quality requirements) but you will still need to be audited. Requalification and initial type testing will probably not be required if you have qualified welding procedures. However, some processes such as cutting may still require written procedures and initial type testing (as they are not covered by 3834).

Similarly, if you are certified to EN ISO 9001, then your factory production control system is probably EN 1090-compliant. However, to be on the safe side, we nonetheless recommend that you work through this checklist and ensure you have covered all action items. You will still need to be audited for EN 1090 – but the process will be a lot faster and possibly cheaper.

Steps to EN 1090

- Understanding EN 1090**
 - EN 1090 – 1: Requirements for conformity assessment of structural components
 - EN 1090 – 2: Technical requirements for the execution of steel structures
 - EN 1090 – 3: Technical requirements for the execution of aluminium structures

- Selecting the right execution class**
 - Do you understand what markets you generally supply and what execution class they would require?
 - Review your capabilities against Table A.3 in EN1090 – 2
 - Select execution class to be tested to

- Engaging the services of a notified body (NB)**

- Implementing and documenting a factory production control (FPC) system?**
 - **Personnel** – can you demonstrate competencies, responsibilities and authority?
 - Tasks & responsibilities documented
 - Competence and training recorded
 - Training requirements identified

- **Equipment** – can you show that equipment is calibrated, inspected and maintained?
 - Maintenance and calibration procedure documented
 - Inspections and maintenance recorded
- **Constituent products** – do they conform to the specifications, are they traceable and are records kept?
 - Purchasing procedure documented
 - Goods inwards procedure documented
 - Products identified and are traceable
 - Records stored
- **Component specification** – can you provide fabrication drawings prepared from design information and written procedures to check conformity?
 - Quality plan available
 - Drawings produced
 - Procedures written
- **Manufacturing procedure** – including welding procedure specification (WPS) and initial type testing (ITT)
 - Identify each process, including material thickness and grade processed
 - Identify testing requirements, including initial type tests
 - Write/obtain procedures for each process (preliminary WPS for welding)
 - Conduct initial type tests with NB (welding procedure tests)
 - Document results
 - Complete welding procedure specification record (WPSR)
 - Prepare welding procedure specifications
- **Product evaluation** – are procedures in place to ensure that product characteristics are maintained? Sampling methods are provided in EN 1090-1 Table 2.
 - Quality control procedure documented
 - Records stored
- **Non-conforming products** – do you have written procedures on how non-conforming products are handled, including record-keeping?
 - Process documented
 - Records stored

Training requirements completed

Audit / initial inspection

Certification

Declaration of conformity

CE marking and labelling

Following certification, the designated authority will provide continuous surveillance to ensure that the manufacturing standards are maintained. The testing periods are defined by your designated execution class.

For more help or information please contact EN1090@linde.com or visit www.linde-gas.com/EN1090



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