

UA WELDER CERTIFICATION PROGRAM

Local 539 training center is certified as a United Association Authorized Testing Facility, and is authorized to administer the UA weld program certification tests. Prior to the certification test the welder (if not holding a current UA weld cert in that process) is required to perform a “Welding Proficiency Demonstration” to determine if they are ready for the certification test.

There are a variety of weld certification tests available and are categorized according to material, processes and procedures. The weld certification tests offered for a given test session will be determined by the needs of the industry, some tests may not be available for every test session.

Listed below are tests that may be available, and include important information that should be taken into consideration. Once you determine which weld certification test meets your needs you will need to register for the test. You can register using the journeyman course registration form that is mailed to you, online using the online class registration form, or by calling into the training center to get your name on the waiting list. The test dates will be scheduled when the minimum number of applicants is met.

Things to remember when determining which test meets your needs

1. Type of base metals to be welded together.
2. Diameter and wall thickness of base metal. The qualification range is usually ½ the diameter, and twice the wall thickness of the test coupon.
3. When different weld processes are used, there is a deposited weld material thickness for each process.

Use the test procedure that qualifies you to weld on the widest range of pipe diameter, wall thickness.

Listed below are the UA tests that are available and are listed according to weld process. Highlighted ones are most common.

SMAW (Stick)

UA-R2 (requalification)	UA-21	UA-70 (structural fillet)
UA-1	UA-28	UA-73 (2G-5G)
UA-2	UA-60	UA-76
UA-8	UA-68	

GTAW & SMAW (Tig and Stick)

UA-6

UA-61 (Heavy Wall Stainless)

UA-10

UA-62 (Heavy Wall)

UA-22

UA-63 (Heavy Wall)

UA-42 (Stainless)

UA-78 (Nickel-Chrome)

GTAW (Tig)

UA-R1 (Requalification)

UA-25

UA-45

UA-R3 (Requalification)

UA-33 (Nickel Alloy)

UA-66 (Nickel Alloy)

UA-15

UA-34 (Nickel Alloy)

UA-67

UA-18 (Orbital)

UA-35 (Nickel Alloy)

UA-93

GMAW/FCAW (Wire)

UA-12W

UA-30

UA-72

UA-17W

UA-36

UA-79

UA-20

UA-39

UA-85

UA-27

UA-71

Brazing

UA-50

UA-51

UA-52 (Renewal)

UA Welder Certification Tests

All tests are in the **6G** position unless indicated otherwise in the Special Notes column.

Weld Test	Process	Pipe Coupon Size	Wall Thickness	Filler Metals	Special Notes
UA-R1	GTAW	2" Sch. 80	.218"	ER309	Requalification Test
UA-R2	SMAW	6" Sch. 80	.432"	E6010 / E7018	Requalification Test
UA-R3	GTAW	2" Sch. 80	.218"	ER70S-6	Requalification Test
UA-1	SMAW	6" Sch. 40	.280"	E6010	Downhill Welding
UA-2	SMAW	6" Sch. 40	.280"	E6010 / E7018	—
UA-6	GTAW & SMAW	2" XXS	.436"	ER70S-2 / E7018 / E309	—
UA-8	SMAW	2" Sch. 80	.218"	E6010 / E7018	—
UA-10	GTAW & SMAW	2" Sch. 80	.218"	ER70S-2 / E7018	—
UA-12W	GMAW-S	6" Sch. 80	.432"	ER70S-3 or 6	GMAW-Short Circuiting Mode
UA-15	GTAW	2" Sch. 80	.218"	ER70S-2	—
UA-17W	GMAW-S & FCAW	6" Sch. 80	.432"	ER70S-6 / E71-T1	—
UA-18A	GTAW	0.750" O.D.	.065"	none	Automatic Orbital Welding
UA-20	FCAW	6" Sch. 80	.432"	E71-T1	Using Backing Ring
UA-21	SMAW	2" XXS	.436"	E6010 / E7018	—
UA-22	GTAW & SMAW	2" XXS	.436"	ER70S-2 / E7018	—
UA-25	GTAW	2" XXS	.436"	ER70S-2	—
UA-27	GMAW-S	6" Sch. 80	.432"	ER70S-6	Root-down / Balance-up
UA-28	SMAW	6" Sch. 80	.432"	E6010 / E7018	—
UA-30	GMAW-S & FCAW	6" Sch. 80	.432"	ER70S-6 / E71-T1	IG Rolled Test
UA-33	GTAW	2" Sch. 40	.154"	ER NiCrMo-10	Nickel Alloy Test
UA-34	GTAW	2" Sch. 10	.109"	ER NiCrMo-10	Nickel Alloy Test
UA-35	GTAW	2" Sch. 80	.218"	ER NiCrMo-10	Nickel Alloy Wire / SA-106 Coupon
UA-36	GMAW-S & FCAW	2 3/4" O.D.	.625"	ER70S-6 / E71-T1	Super Coupon Test
UA-39	GMAW-S & GMAW-P	6" Sch. 80	.432"	ER308Si	IG Rolled Test
UA-42	GTAW & SMAW	2" XXS	.436"	ER309 / E309-16	Stainless Test
UA-45	GTAW	2" Sch. 10	.109"	ER308	Stainless Test
UA-50	Brazing	3/4" Tube	.045"	BCuP 2 thru 7	Manual Torch Brazing
UA-51	Brazing	1 1/2" Tube	.060"	BCuP 2 thru 7	Manual Torch Brazing

Weld Test	Process	Pipe Coupon Size	Wall Thickness	Filler Metals	Special Notes
UA-52	Brazing	1 1/2" Tube	.060"	BCuP 2 thru 7	Brazer Qual Renewal Test
UA-60	SMAW	2 3/4" O.D.	.625"	E6010 / E7018	Super Coupon Test
UA-61	GTAW & SMAW	2 3/4" O.D.	.625"	ER309 / E309-16	Stainless Test
UA-62	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E309-16	Super Coupon Test
UA-63	GTAW & SMAW	2 3/4" O.D.	.625"	ER70S-2 / E7018	Super Coupon Test
UA-66	GTAW	2 3/4" O.D.	.625"	ER NiCr-3	Nickel Alloy Wire / SA-106 Coupon
UA-67	GTAW	2 3/4" O.D.	.625"	ER70S-2	Super Coupon Test
UA-68	SMAW	2 3/4" O.D.	.625"	E6010 / E7018	Root-down / Balance-up
UA-70	SMAW	2" pipe & 3/16" plate	.154"	E7018	Structural Steel Fillet Weld Test
UA-71	GMAW-S & GMAW	6" Sch. 80	.432"	ER70S-3 or 6	Short Arc Root / Spray or Pulse Fill
UA-72	GMAW-S & GMAW	6" Sch. 80	.432"	ER70S-2 or 3	IG Rolled Test
UA-73	SMAW	6" Sch. 80	.432"	E6010 / E7018	Flip Flop Test (2G & 5G)
UA-76	SMAW	2" XXS	.436"	E6010 / E7018	Two Coupons (2G & 5G)
UA-78	GTAW & SMAW	2 3/4" O.D.	.625"	ERNiCr-3 / ENiCr-3	Nickel Chrome Super Coupon Test
UA-79	GMAW-S & GMAW	6" Sch. 80	.432"	ER70S-3 or 6	Mixed Gas - 90% Argon / 10% CO2
UA-85	GMAW-S & GMAW	2 3/4" O.D.	.625"	ER70S-6	Mixed Gas - 90% Argon / 10% CO2
UA-93	GTAW	4" Sch. 5	.083"	none	Manual Fusion