

SAPPMA GUIDANCE DOCUMENT

Rev 8

January 2023

Re: IFPA Audits

Dear IFPA member,

In conformance with IFPA's Code of Conduct and relevant SANS, IFPA's members shall conform to the following:

1. Welding operations shall be conducted in a controlled environment – factory, workshop, or welding tent.
2. Welding machine files to be in place and machines maintained in line with the relevant part of SANS 1671 and OEM (Original Equipment Manufacturer) specifications – inspection documents have been circulated to assist in this matter.
3. Equipment used to verify welding machines and ovens compliance shall be calibrated – Vernier, OD tape, scale, pyrometer and pressure gauge.
4. Calibrated equipment shall only be issued to trained and competent staff.
5. The welder's credentials shall be available, and the welder's qualifications and destructive test reports on completed welds shall be included to demonstrate competency.
6. Welding processes shall conform to the relevant part of SANS 10268.
7. Every weld shall be marked with the company's and welder's unique IFPA weld marker.
8. Works Orders/Job Cards shall include QC checks – visual inspection, workmanship, and dimensions – a printed copy of weld defects (SANS 10268 – 10) shall be available in the workshop to assist with the inspections.
9. Fabrication shall conform to the standard product or client-issued drawings that shall indicate tolerances.
10. Weld protocols shall be recorded for every weld – maybe on the back of the job card to minimise documentation.
11. Use of non-conforming/non-traceable pipe, fittings, sheeting, welding rods and fillers, generic welding tables, methylated spirits and welding machines not conforming to the relevant SANS 1671 is prohibited or any part of the relevant product standards and welding standards, e.g. SANS ISO 4427, SANS ISO 21138 and associated normative reference standards.

12. Stub holders shall be used when ending the pipe to ensure accurate alignment.
13. Copies of the relevant standards and standard drawings shall be available for reference.
14. Materials shall conform to the applicable SANS, e.g. SANS 4427, and COC and COA must be obtained and validated before being filed for all bought-out materials – pipe, fittings, flanges, etc. Therefore, a validated procurement process needs to be implemented.
15. Fabricated items shall be marked in conformance with SANS 4427 Part 3: Table 8.
16. Derating of fittings in conformance with the applicable standard, e.g., SANS 4427 Part 3, shall be applied.
17. Conforming handling and storage of material and finished goods shall be implemented and maintained.
18. A “Non-conformance File” shall be implemented and maintained.
19. Members will be subject to announced and unannounced audits – that shall not be punitive but assist in reducing, or eliminating, nonconformances and achieving improvements.

Please note that these are the current IFPA minimum audit requirements; the end user may have more stringent requirements that will take precedence. This document will be revised as necessary to conform to standard revisions, procedures, and audit findings to ensure the longevity of our members’ businesses.

We trust this clarifies IFPA’s intentions in this matter. If you have any questions, or we can be of any further assistance, don’t hesitate to get in touch with us.

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