



Renewal Process
for the Certified Welding Technician (CWT)
Program / Reinforced



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Introduction:

The International Association of Geosynthetic Installers' CWT Renewal Manual has been developed to ensure that the renewal process is administered uniformly. Please follow all the guidelines as written in this manual.

IAGI is continually working to enhance this certification program. If you have suggestions for improving this process, please contact IAGI's Managing Director at +1 (720) 353-4977 or iagi@iagi.org.

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Physical address:

IAGI

8601 W. Cross Drive, Suite F5, #220
Littleton, CO 80123 USA

Telephone: + 1(720) 353-4977

E-mail: iagi@iagi.org



Steps for CWT Renewal:

The CWT renewal process has been updated in 2021. Now each CWT must submit one field-welded reinforced sample for each seam type subject to renewal, made in the presence of a third-party observer, to an approved independent laboratory for testing. IAGI suggests asking a third-party on a job site to oversee this process. The qualifications for a third-party observer are listed on page 5 of this manual.

The renewal process is as follows:

1. Submit CWT renewal order form and renewal fee of 130 USD (per renewal). This price includes fees for the laboratory tests.
2. Fill out the renewal form.
3. Provide a resume showing 500,000 square feet (45,000 meters squared) welded within the past five years.
4. Submit one field-welded polyethylene sample for each seam type subject to renewal, made in the presence of a third-party observer, to one of the two approved independent laboratories. (see page 8)
5. Have third-party observer sign off on renewal form.
6. The renewal will be processed and successful CWTs will have their certification renewed for another five (5) years. A new wallet card and certificate will be sent to them.



Checklist for renewal

The CWT Renewal Process for CWTs requires a renewal application, resume, field welded sample(s), and renewal fee. The following is a checklist of items needed for renewal:

Checklist for renewal:			
✓	<i>Requirements</i>	<i>Responsible party</i>	<i>Notes:</i>
	Renewal fee paid	CWT candidate/ company	CWT Candidate/company to send directly to IAGI. IAGI will then provide a PO Number needed for the application.
	Renewal Application completed	CWT candidate	Be sure the PO Number received from IAGI is filled in on the application.
	Resume showing 500,000 square feet of seam welding	CWT candidate	Candidate to send directly to IAGI. (info@iagi.org)
	Field-welded sample(s) supervised by third-party witness	CWT candidate	One field welded wedge weld and one hot air welded sample.
	Signed renewal application	Third-party observer & CWT candidate	One copy is sent to test lab with field welded sample(s) and one copy is sent to IAGI. <u>Be sure the PO Number received from IAGI is on this form.</u>
	Field-welded sample submitted	Third-party witness	Send directly to laboratory with a copy of the signed renewal application. Shipping is at the expense of the CWT candidate / company.



Rules for Third-party observer:

1. The third-party observer is neither employed by nor has a financial interest in the company where the welding technician is employed.
2. The third-party observer is responsible for checking that the individual taking the exam is also the individual listed on their government issued identification.
3. The third-party observer ensures that only the individual taking the exam makes the weld(s).
4. The third-party observer must provide complete contact information in the event IAGI needs to verify the authenticity of the submission.
5. The third-party is **NOT** responsible for certifying the quality of the weld(s), the proper material usage or equipment suitability. This is the sole responsibility of the technician.
6. Test candidates may test the strength of the weld(s) prior to submission using a field tensiometer. Candidates may weld a total of three samples and choose the one that they want to submit. No other party can influence the candidates decision about which seam should be submitted.
7. Any compensation for this service is privately negotiated between the CWT candidates and the third party. IAGI does not set or recommend rates for this service.

RENEWAL APPLICATION



Third party Information:

Third party observer's name:			
Company Name:			
Address: (no PO Boxes)			
City:		Province/ State:	
Postal Code / Zip Code:		Country:	
Telephone:		Fax:	
e-mail:			
Notes:			
<p>I attest that the welding technician listed on this application has shown me a government issued identification, has performed the weld(s) by himself/herself and has submitted the sample(s) directly to me.</p> <p>Signature:</p>			

CWT Applicant Information:

Date of Weld(s):	Wedge Weld Reinforced _____mil	Hot Air Weld Reinforced _____mil
CWT Renewal Applicant:		
Company Name:		
Address: (no PO Boxes)		
City:		Province / State:
Postal Code / Zip Code:		Country:
Telephone:		Fax:
e-mail:		
Company Contact: (person IAGI can contact with questions.)		
Company contact e-mail:		Company Contact telephone:
Notes:		
<p>I attest that I made the weld(s). I further attest that I am responsible for the selection of material, selection of equipment, I have welded a minimum of 500,000 square feet of geomembrane in the field over the past 5 years, and I have completed this renewal in compliance with the rules of the CWT program.</p> <p>Signature:</p>		
		PO Number from IAGI:

Send one copy of this page to IAGI; One copy of this page to the laboratory with seam sample

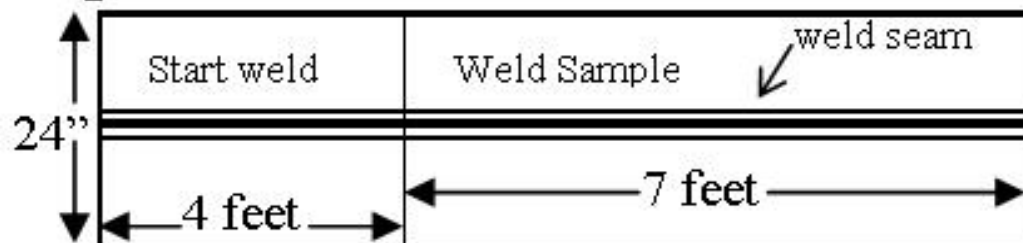


Guidelines for the Hands-on Test

Each candidate can re-weld up to 3 (three) times:

The candidate may seam up to three welds and then choose the best sample to submit. Once the candidate is ready to submit his/her sample(s), have them cut a sample per diagram 1 (below). The submission weld sample(s) should be trimmed to approximately 8-12 inches wide by 24 inches long. The seam will run parallel with the 24-inch edge. Have the candidate label the submission weld sample(s) as described in diagram 2. Place the sample(s) in an envelope / sandbag and send to the laboratory for testing. Also, label the envelope / sandbag with the test candidate's full name and note it is IAGI Certification Renewal Testing.

Diagram 1.



Cut the submission weld sample starting at the four (4) foot mark. This allows for a temperature drop and recovery period on fusion welds.

NOTE: In some companies the welding technicians do not run the field tensiometer. It is acceptable for the quality control person to run the tests. The QC person can only report the value (number) the specimen pulled on the tensiometer. The QC person cannot indicate "pass or fail" to the candidate. It is responsibility of the test candidate to determine if the strength of the weld and / or mode of failure is acceptable for submission. The third-party observer must monitor the QC person for compliance if this method is used. If the QC person states to the test candidate "pass or fail," then the weld cannot be submitted.

All welds will be graded in accordance with GM19 (see pages 9–10 for the tables)

Diagram 2.





Guidelines for the Hands-on Test

Lab selection:

The test candidate or candidate's company can choose the testing laboratory that will perform the destructive testing of submitted samples from the following approved list. Send all labeled materials to one of the labs below and write the name of the sponsoring company on the box and internal packing labels. Indicate that this shipment is for IAGI CWT Renewal exams for Polyethylene.

SAGEOS
Contact: Eric Blond
3000 Boullé Street
Saint-Hyacinthe, QC J2S 1H9
Canada
Phone: + 450 778-1870

TRI/Environmental
Contact: Sam Allen
9063 Bee Caves Road
Austin, TX 78733
USA
Phone: + 512-263-2101

GM-19 Values for Polypropylene.

All other material should be based on the manufacturer's product specification sheet

Table 3(a) – Seam Strength and related Properties of Thermally Bonded Nonreinforced and Reinforced Flexible Polypropylene (fPP) Geomembrane **(English Units)**

Geomembrane Nominal Thickness	30 mil	40 mil	36 mil-R⁴	45mil- R⁴
Hot Wedge Seams ⁽¹⁾				
shear strength ⁽²⁾ , lb/in. (R-lb.)	25	30	200	200
shear elongation at break ⁽³⁾ , %	50	50	n/a	n/a
peel strength ⁽²⁾ , lb/in. (R-lb.)	20	25	50	20
peel separation, %	25	25	n/a	n/a

Notes for Tables 3(a) and 3(b):

1. Also for hot air and ultrasonic seaming methods
2. Value listed for shear and peel strength are for 4 out of 5 test specimens; the 5th specimen can be as low as 80% of the listed values
3. Elongation measurements should be omitted for field testing
4. Values are based on grab tensile strength and elongation per D751 for laboratory specimens

Table 3(b) – Seam Strength and related Properties of Thermally Bonded Nonreinforced and Reinforced Flexible Polypropylene (fPP) Geomembrane **(S.I.Units)**

Geomembrane Nominal Thickness	0.75 mm	1.0 mm	0.91 mm- R⁴	1.14 mm-R⁴
Hot Wedge Seams ⁽¹⁾				
shear strength ⁽²⁾ , N/25mm (NR); N (R)	110	130	890	890
shear elongation at break ⁽³⁾ , %	50	50	n/a	n/a
peel strength ⁽²⁾ , N/25mm N (R)	85	110	90	90
peel separation, %	25	25	n/a	n/a