



Australian Government

PMBWELD302 Electrofusion weld polyethylene pipelines

Release: 1

PMBWELD302 Electrofusion weld polyethylene pipelines

Modification History

Release 1. Supersedes and is equivalent to PMBWELD302B Electrofusion weld polyethylene pipelines

Application

This unit of competency covers the skills and knowledge required to weld polyethylene (PE) plastic pipes using electrofusion. It applies to welding of pipes and pipelines undertaken in the field and in factory conditions. Pipelines may be for transmission of gas or liquids.

This unit of competency applies to experienced operators who are required to select welding parameters to be used, set up equipment, perform electrofusion weld, assess joints against specifications and solve problems within area of responsibility.

This unit of competency applies to an experienced operator demonstrating theoretical and technical knowledge and well developed skills in situations that require some discretion and judgement. The operator may work alone or as a member of a team or group and will work in liaison with other shift team members, team leader and supervisor, as appropriate.

No licensing, legislative or certification requirements apply to this unit at the time of publication.

Pre-requisite Unit

Nil

Competency Field

Welding

Unit Sector

Not applicable

Elements and Performance Criteria

Elements describe the essential outcomes.

Performance criteria describe the performance needed to demonstrate achievement of the element.

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|---|---|-----|--|
| 1 | Identify compatibility of commercial electrofusion | 1.1 | Identify electrofusion welding control unit type and operating data |
| | | 1.2 | Identify pipe material and dimension compatibility with electrofusion fittings |

	control systems	1.3	Identify control unit compatibility with electrofusion fitting control
2	Maintain and calibrate electrofusion control unit equipment	2.1	Set up electrofusion welding equipment and work area according to enterprise procedures
		2.2	Ensure safety equipment is available and operational according to enterprise procedures
		2.3	Identify non-conformance, report and rectify according to enterprise procedures
		2.4	Determine equipment is operational according to specifications
3	Perform electrofusion welding to required standard	3.1	Prepare pipe and fitting according to specification
		3.2	Perform heating, welding and cooling phases using selected electrofusion welding parameters
		3.3	Monitor and record achieved electrofusion weld parameters for each joint according to enterprise procedures
		3.4	Clean up equipment when completed according to enterprise procedures
		3.5	Clean up work site, dispose of scrap materials according to operational procedures
4	Assess quality of completed electrofusion joints	4.1	Identify quality requirements for electrofusion joints according to specifications
		4.2	Assess joints against specification requirements and report results
		4.3	Identify and report non-conformances according to enterprise requirements
5	Identify compatibility of	5.1	Identify electrofusion welding control unit type and operating data

**commercial
electrofusion
control systems**

- | | |
|-----|--|
| 5.2 | Identify pipe material and dimension compatibility with electrofusion fittings |
| 5.3 | Identify control unit compatibility with electrofusion fitting control |

Foundation Skills

This section describes those required skills (language, literacy and numeracy) that are essential to performance.

Foundation skills essential to performance are explicit in the performance criteria of this unit of competency.

Range of Conditions

This field allows for different work environments and conditions that may affect performance. Essential operating conditions that may be present (depending on the work situation, needs of the candidate, accessibility of the item, and local industry and regional contexts) are included.

Regulatory framework The latest version of all legislation, regulations, industry codes of practice and Australian/international standards, or the version specified by the local regulatory authority, must be used.

Applicable legislation, regulations, standards and codes of practice include:

- health, safety and environmental (HSE) legislation, regulations and codes of practice relevant to the workplace, manual handling and hazardous materials
- Australian/international standards relevant to the materials being used and products being made, including one or more of:
 - AS/NZS 4129:2000 Fittings for polyethylene (PE) pipes for pressure applications, or its replacement
 - AS/NZS 4130:2009 Polyethylene (PE) pipes for pressure applications, or its replacement
 - AS/NZS 4131:2010 Polyethylene (PE) compounds for pressure pipes and fittings, or its replacement
 - AS/NZS 4401:2006 Plastics piping systems for soil and waste discharge (low and high temperature) inside buildings - Polyethylene (PE), or its replacement
 - ISO 21307:2011 Plastics pipes and fittings—Butt fusion jointing procedures for polyethylene (PE) pipes and fittings used in the construction of gas and water distribution systems, or its replacement
- any relevant licence and certification requirements.

All operations to which this unit applies are subject to stringent HSE requirements, which may be imposed through state/territory or federal legislation, and these must not be compromised at any time. Where there is an apparent conflict between performance criteria and such requirements the legislative requirements take precedence.

Procedures All operations must be performed in accordance with relevant procedures.

Procedures are written, verbal, visual, computer-based or in some other form, and include one or any combination of:

- emergency procedures
- work instructions
- standard operating procedures (SOPs)
- safe work method statements (SWMS)
- formulas/recipes
- batch sheets
- temporary instructions
- any similar instructions provided for the smooth running of the plant.

Tools and equipment

Tools and equipment include:

- calibrated output electrofusion control units
- pipe clamp supports
- measurement devices, including one or more of:
 - timers
 - temperature probes
 - callipers
 - computer-based output monitors
- cleaning equipment
- spray equipment.

Additional tools and equipment will be selected as required from:

- hand tools used in this process
- hoists/lifting equipment not requiring any special permits or licences
- manual handling aids, such as hand carts and trolleys
- relevant personal protective equipment (PPE).

Hazards Hazards must be identified and controlled. Identifying hazards requires consideration of:

- power tools, leads and power supplies
- hazardous products and materials
- cutting equipment
- sharp edges, swarf and scrap
- protrusions or obstructions
- slippery surfaces, spills or leaks
- rotational equipment or vibration
- smoke, dust, vapours or other atmospheric hazards
- high temperatures
- electricity
- gas
- gases and liquids under pressure
- structural hazards
- equipment failures
- machinery, equipment and product mass
- other hazards that might arise.

Problems Routine and non-routine problems must be resolved.

Non-routine problems must be resolved by applying operational knowledge to develop new solutions, either individually or in collaboration with relevant experts, to:

- determine problems needing action
- determine possible fault causes
- develop solutions to problems which do not have a known solution
- follow through items initiated until final resolution has occurred
- report problems outside area of responsibility to designated person.

Non-routine problems are unexpected problems or variations of previous problems and include one or more of:

- variations in quality
- emergency situations
- intermittent faults.

Operational knowledge includes one or more of:

- procedures
- training

- technical information, such as journals and engineering specifications
- remembered experience
- relevant knowledge obtained from appropriate people.

Routine problems are predictable and have known solutions and include one or more of:

- variable PE materials and pipes as supplied
- equipment malfunction or wear and tear
- variable field site conditions.

Unit Mapping Information

Release 1. Supersedes and is equivalent to PMBWELD302B Electrofusion weld polyethylene pipelines

Links

Companion Volume implementation guides are found in VETNet -

<https://vetnet.gov.au/Pages/TrainingDocs.aspx?q=932aacef-7947-4c80-acc6-593719fe4090>

Assessment Requirements for PMBWELD302 Electrofusion weld polyethylene pipelines

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Performance Evidence

Evidence required to demonstrate competence in this unit must be relevant to and satisfy the requirements of the elements and performance criteria and demonstrate the ability to:

- read and interpret designs, plans, patterns, procedures, job specifications, instruments/control panels, material labels and safety data sheets (SDS)
- plan the welding process and sequence tasks
- set up electrofusion welding equipment and materials/components to meet specifications
- prepare electrofusion joint assemblies
- operate the electrofusion control unit to weld the materials/components
- monitor key variables, including:
 - voltage
 - fusion time
 - cooling time
 - alignment
 - product output rate
 - product integrity and general conformance to specification
- maintain and calibrate equipment according to procedures
- identify hazards and apply relevant hazard controls
- apply safety procedures
- apply housekeeping procedures
- apply waste management procedures
- recognise early warning signs of equipment/processes needing attention or with potential problems
- distinguish between causes of problems, including:
 - operational problems
 - instrument failure/malfunction
 - electrical failure/malfunction
 - mechanical failure/malfunction
 - wrong readings
 - materials properties
 - process variables
 - raw material variations/contamination

- procedural errors
- recognise and prioritise problems requiring action
- resolve routine and non-routine problems
- communicate effectively with team/work group and supervisors
- complete workplace records
- do basic arithmetical manipulations, including additions, subtractions, divisions, fractions and percentages.

Knowledge Evidence

Must provide evidence that demonstrates knowledge relevant to their job sufficient to operate independently and to solve routine and non-routine problems, including knowledge of:

- function and operating principles of electrofusion welding equipment, components and ancillary equipment
- impact of variations in welding process variables and raw materials on product quality and production output
- factors which may affect product quality or production output and appropriate remedies
- characteristics of materials and their behaviour in relation to welding process variables and stages of production
- quality requirements at each production stage
- common adjustments in process variables and their impact on product quality and production output
- routine and non-routine problems that may arise, the range of possible causes and appropriate actions
- organisation procedures relevant to the work environment/job role
- hierarchy of control
- hazards that may arise in the job/work environment and:
 - their possible causes
 - potential consequences
 - appropriate risk controls.

Assessment Conditions

- The unit should be assessed holistically and the judgement of competence shall be based on a holistic assessment of the evidence.
- In all plants it may be appropriate to assess this unit concurrently with units such as:
 - teamwork
 - communication.
- The collection of performance evidence:
 - should occur over a range of situations which include typical disruptions to normal, smooth operation of an operating plant

- will typically include a supervisor/third-party report or other evidence, focusing on consistent performance and problem recognition and solving. A supervisor/third-party report must be prepared by someone who has a direct, relevant, current relationship with the person being assessed and who is in a position to form a judgement on workplace performance relevant to the unit of competency
- must include the use of an appropriate industrial item of equipment requiring demonstration of operation, start and stop procedures and responding to problems
- may use industry-based simulation for all or part of the unit particularly where safety, lack of opportunity or significant cost is an issue.
- Assessment should occur in operational workplace situations. Where this is not possible or where personal safety or environmental damage are limiting factors assessment must occur in a sufficiently rigorous simulated environment that reflects realistic operational workplace conditions. This must cover all aspects of workplace performance, including environment, task skills, task management skills, contingency management skills and job role environment skills.
- Assessment in a simulated environment should use evidence collected from demonstration of skills and one or more of:
 - walk-throughs
 - pilot plant operation
 - industry-based case studies/scenarios
 - 'what ifs'.
- Knowledge evidence may be collected concurrently with performance evidence or through an independent process, such as workbooks, written assessments or interviews.
- Assessment processes and techniques must be appropriate to the language, literacy and numeracy requirements of the work being performed and the needs of the candidate.
- Conditions for assessment must include access to all tools, equipment, materials and documentation required, including relevant workplace procedures, product and manufacturing specifications associated with this unit.
- The regulatory framework will be reflected in workplace policies and procedures and is not required to be independently assessed.
- Foundation skills are integral to competent performance of the unit and should not be assessed separately.
- Assessors must satisfy the assessor competency requirements that are in place at the time of the assessment as set by the VET regulator.
- In addition the assessor or anyone acting in subject matter expert role in assessment shall demonstrate both technical competency and currency. If the assessor cannot demonstrate technical competency and currency they shall assess with a subject matter expert who does meet these requirements.
- Technical competence can be demonstrated through one or more of:
 - relevant VET or other qualification/Statement of Attainment
 - appropriate workplace experience undertaking the type of work being assessed under routine and non-routine conditions
 - appropriate workplace experience supervising/evaluating the type of work being assessed under routine and non-routine conditions

- Currency can be demonstrated through one or more of:
 - being currently employed undertaking the type of work being assessed
 - being employed by the organisation undertaking the type of work being assessed and having maintained currency in accordance with that organisation's policies and procedures
 - having consulted/had contact with an organisation undertaking the type of work being assessed within the last twelve months, the consultation/contact being related to assessment
 - conducting on the job training/assessments of the type of work being assessed
 - being an active member of a relevant professional body and participating in activities relevant to the assessment of this type of work.

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