**QG-106.1 Procedure Qualifications.** Each organization is responsible for conducting the tests required by this Section to qualify the procedures that are used in the construction of components under the rules of the Codes, standards, and specifications that reference this Section.

(a) The personnel who produce test joints for procedure qualification shall be under the full supervision and control of the qualifying organization during the production of these test joints. The persons producing test joints for the qualification of procedures shall be either direct employees or shall be personally engaged by contract for material-joining services.

(b) Production of qualification test joints under the supervision and control of another organization is not permitted. However, it is permitted to subcontract any or all of the work necessary for preparing the materials to be joined, the subsequent work for preparing test specimens from the completed test joint, and the performance of nondestructive examination and mechanical tests, provided the organization accepts full responsibility for any such work.

(c) If the effective operational control of procedure qualifications for two or more companies of different names exists under the same corporate ownership, the companies involved shall describe in their Quality Control System or Quality Assurance Program the operational control of procedure qualifications. In this case, separate procedure qualifications are not required, provided all other requirements of this Section are met.

**ADD:**

**QG-106.4 Simultaneous Procedure Qualifications.** When expressly permitted by the referencing code, welding procedures may be simultaneously qualified by more than one organization, provided that each organization accepts full responsibility for any such qualifications and the following requirements are met.

(a) Each participating organization shall be represented by an individual with responsibility for qualification of joining procedures, as detailed in QG-106.

(b) A preliminary joining procedure specification acceptable to the representatives of each participating organization shall be prepared addressing the essential and nonessential variables and, when applicable, the supplementary essential variables and other requirements as may be applicable that are to be observed for each process to be used for joining the test coupon(s). If any variables are revised during the joining of a test coupon, the revised variables shall be agreed upon by the representatives of each participating organization.

(c) Joining of the test coupon(s) shall be conducted under the simultaneous supervision of the representatives of each participating organization.

(d) The PQR shall document that the qualification was conducted under the provisions of QG-106.4.