

## Livelli del Coordinatore di Saldatura secondo EN 1090 per EXC3/4

Per le classi di esecuzione EXC3 ed EXC4 secondo la norma EN 1090, i livelli del coordinatore di saldatura sono definiti nelle seguenti tabelle:

- Tabella 14 per gli acciai al carbonio (EN 1090-2)
- Tabella 15 per gli acciai inossidabili (EN 1090-2)
- Tabella 9 per l'alluminio (EN 1090-3)

**Requisiti minimi di conoscenza tecnica per il coordinatore di saldatura:**

**Tabella 14 – Acciai al carbonio (EN 1090-2)**

Classe di esecuzione (EXC)	Livello minimo richiesto
EXC1	Basic
EXC2	Specific
EXC3	Comprehensive
EXC4	Comprehensive + requisiti aggiuntivi

**Tabella 15 – Acciai inossidabili (EN 1090-2)**

Classe di esecuzione (EXC)	Livello minimo richiesto
EXC1	Basic
EXC2	Specific
EXC3	Comprehensive
EXC4	Comprehensive + requisiti aggiuntivi

**Tabella 9 – Alluminio (EN 1090-3)**

Classe di esecuzione (EXC)	Livello minimo richiesto
EXC1	Basic
EXC2	Specific
EXC3	Comprehensive
EXC4	Comprehensive + requisiti aggiuntivi

### Equivalenza dei percorsi formativi IIW/EFW

Livello EN 1090	Descrizione	Qualifica equivalente IIW/EFW
B – Basic	Conoscenze di base per EXC1/2	IWP / IWS / RWC-B
S – Specific	Conoscenze specifiche per EXC2/3	IWS / IWT / RWC-S
C – Comprehensive	Conoscenze complete per EXC3/4	IWT / IWE

**Table 14 — Technical knowledge of the coordination personnel — Structural carbon steels**

EXC	Steels (steel group)	Reference standards	Thickness (mm)		
			t ≤ 25 <sup>a</sup>	25 < t ≤ 50 <sup>b</sup>	t > 50
EXC2	S235 to S355 (1.1, 1.2, 1.4)	EN 10025-2, EN 10025-3, EN 10025-4, EN 10025-5, EN 10149-2, EN 10149-3, EN 10210-1, EN 10219-1	B	S	C <sup>c</sup>
	S420 to S700 (1.3, 2, 3)	EN 10025-3, EN 10025-4, EN 10025-6, EN 10149-2, EN 10149-3, EN 10210-1, EN 10219-1	S	C <sup>d</sup>	C
EXC3	S235 to S355 (1.1, 1.2, 1.4)	EN 10025-2, EN 10025-3, EN 10025-4, EN 10025-5, EN 10149-2, EN 10149-3, EN 10210-1, EN 10219-1	S	C	C
	S420 to S700 (1.3, 2, 3)	EN 10025-3, EN 10025-4, EN 10025-6, EN 10149-2, EN 10149-3, EN 10210-1, EN 10219-1	C	C	C
EXC4	All	All	C	C	C

<sup>a</sup> Column base plates and endplates ≤ 50 mm  
<sup>b</sup> Column base plates and endplates ≤ 75 mm  
<sup>c</sup> For steels up to and including S275, level S is sufficient  
<sup>d</sup> For steels N, NL, M and ML, level S is sufficient

**Table 15 — Technical knowledge of the coordination personnel — Stainless steels**

EXC	Steels (steel group)	Reference standards	Thickness (mm)		
			t ≤ 25	25 ≤ t ≤ 50	t > 50
EXC2	Austenitic (8) Ferritic (7.1)	EN 10088-4:2009, Table 3 EN 10088-5:2009, Table 4 EN 10296-2:2005, Table 1 EN 10297-2:2005, Table 2	B	S	C
	Austenitic-ferritic (10)	EN 10088-4:2009, Table 4 EN 10088-5:2009, Table 5 EN 10296-2:2005, Table 1 EN 10297-2:2005, Table 3	S	C	C
EXC3	Austenitic (8) Ferritic (7.1)	EN 10088-4:2009, Table 3 EN 10088-5:2009, Table 4 EN 10296-2:2005, Table 1 EN 10297-2:2005, Table 2	S	C	C
	Austenitic-ferritic (10)	EN 10088-4:2009, Table 4 EN 10088-5:2009, Table 5 EN 10296-2:2005, Table 1 EN 10297-2:2005, Table 3	C	C	C
EXC4	All	All	C	C	C

**Table 9 — Required technical knowledge of welding coordination personnel**

Execution class	Parent material	Type of welding consumables			
		Type 3, Type 4		Type 5	
		Nominal thickness of material in mm		Nominal thickness of material in mm	
		t ≤ 12 <sup>a</sup>	t > 12	t ≤ 12 <sup>a</sup>	t > 12
EXC2	3xxx, 5xxx	B	S	B	S
	Other			S	
EXC3	3xxx, 5xxx	S	S	S	C
	Other		C	C	
EXC4	all	C			

B Basic technical knowledge according to EN ISO 14731;  
S Specific technical knowledge according to EN ISO 14731;  
C Comprehensive technical knowledge according to EN ISO 14731.

NOTE This table gives no recommendation about possible combinations of constituent materials (parent materials and filler metal) to be welded. For allowed and recommended combinations, see EN 1999-1-1.

<sup>a</sup> Endplates up to 25 mm.