



## Report on the Initial Inspection / ~~Continuous Surveillance~~ of "Factory Production Control" (FPC) to EN 1090-1

<b>Manufacturer :</b>	J&K Alkon Sp. z o. o.		
<b>Street, No.:</b>	Kuglinów 10		
<b>Post code/Town or City :</b>	72-600 Świnoujście		
<b>Country :</b>	Poland		
<b>Manufacturing plant :</b>	Area Szczeciński Park Przemysłowy Sp. z o.o. Antosiewiczza 1; 71-642 Szczecin		
<b>Phone :</b>	+48 91 321 3003	<b>Fax:</b>	
<b>Internet:</b>	www.juk-alkon.com	<b>E-mail:</b>	info@juk-alkon.com
<b>Date of the inspection / surveillance :</b>	02, 03 December 2015	<b>Inspection No. / Pos.:</b>	DP/2015/10465
<b>Surveillance body auditor :</b>	Mariusz Blezień		
<b>Manufacturer's participant(s)</b>	Adrian Górski, Paweł Rybicki, Sebastian Niedbała, Jerzy Łączny.		

### Type of audit

- Initial inspection of the manufacturing plant and the FPC system  
 Continuous surveillance of the FPC system  
 Unscheduled surveillance due to changes in circumstances

### Scope of FPC certification to EN 1090-1

#### Construction products / Use

- Load-bearing structural steel members in all types of construction works

### Spezielle Prozesse

- Design of construction       Production       Cutting, holing, shaping       Welding  
 Heat treatment       Mechanical jointing       Corrosion protection

### Execution class(es)

- EXC 1 to EXC 4 according EN 1090-2

*Mariusz Blezień*

**Authorised person(s)**

**Responsible person for the "Factory Production Control" (FPC)**

The person(s) named below is / are each individually authorised to sign the respective Declaration of Conformity on behalf of the Manufacturer:

- Responsible: Paweł RYBICKI, 15.05.1974, Welding Engineer IWE , Manager FPC

Their naming by the Executive Management is available:

- Yes     No     Partly, see recommendations / deviations

**Welding coordinator(s)**

The following welding coordinator(s) has(have) been named:

- Responsible welding coordinator: Paweł RYBICKI, 15.05.1974, Welding Engineer IWE No. PL-IWE 00529/2009

The organisation integration of the welding coordinator(s) is ensured

- Yes     No     Partly, see recommendations / deviations

The tasks and areas of responsibility to EN ISO 14731 are defined

- Yes     No     Partly, see recommendations / deviations

Demonstration of the required technical knowledge has been verified by a technical interview

- Yes     No     Partly, see recommendations / deviations

An extended technical interview was held due to lack of proof of qualifications

- Yes     No     Partly, see recommendations / deviations

If yes, qualification according to:  Level B,  Level S,  Level C

**Welder / welding operator qualification**

Valid tests to EN 287 / EN ISO 9606 / EN ISO 14732 exist for the following welding processes, for application according EN 1090-2:

- 135t
- 111
- 141
- 121
- 136
- 138
- 783

for application according EN 1090-3:

- 141
- 131
- 

As part of the initial inspection / monitoring a sample of your work / welding examination was welded and evaluated under the guidance and supervision of the responsible welding supervisor

- Yes     No     Partly, see recommendations / deviations

The responsible welding coordinator is authorised to test welders to EN 287 / EN ISO 9606 / EN ISO 14732 for their area of qualification



Yes       No       Partly, see recommendations / deviations

**Methods of testing / testers**

Qualifications according to EN 473 / EN ISO 9712 exist for the following methods of testing:

- PT, penetration test
- MT, magnetic powder test
- UT, ultrasonic testing
- RT, radiographic testing
- VT, visual inspection

Visual inspections of welds are carried out by the Manufacturer's own personnel.  Yes  No

These have been trained and instructed accordingly:  Yes  No

If necessary, appropriately qualified external personnel of accredited test laboratories are deployed:

Yes  No

**Procedure qualification(s)**

Procedure qualifications are available for the following materials according ISO/TR 15608 (if applying EN 1090-2):

General mild steels:

- Material group 1.1
- Material group 1.2
- Material group 1.3
- Material group 3.1

Stainless steels:

- Material group 8
- Material group 10

Procedure qualifications / welding processes are available for the following materials / procedures (if applying EN 1090-3):

- Material group 21
- Material group 22
- Material group 23

The existing qualification of the welding procedure was examined.

Welding procedure test	EN ISO 15614-1 bis -10	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No
Pre-production welding test	EN ISO 15613	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
Standard welding procedure	EN ISO 15612	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
Existing welding experience	EN ISO 15611	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
Use of tested welding consumables	EN ISO 15610	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No

Demonstrations of conformity for the construction products used:

- are available
- are not available or are not complete

## Operating facilities

Based on the documents submitted and the visit to the company it was found that sufficient production space and suitable production facilities are available for the preparation, process execution, testing and transport, in order to achieve product conformity.

Yes  No

The facilities are kept in proper condition through regular inspection and maintenance. Proofs are available.

Yes  No

The calibration and validation of the measuring, monitoring and test equipment is defined and controlled.

Yes  No

## Recommendations / Notes

### Recommendations for improvement

- Acknowledge with the requirements of EN 1090 standard
- More focus on traceability, material certificates
- Updated EN standards, the lack of the next review period.
- Validate the oven for electrodes, temperature operating range.
- Report of mechanical connectors, a lack of fulfillment the requirements of En 1090-2 Annex H.9

## Documents to be submitted later

Date: None

## Result of the initial inspection/surveillance

The requirements for certification of the Factory Production Control were fulfilled on the basis of EN 1090-1. Issue/continued validity of the certificate is recommended.

The Manufacturer must initiate suitable corrective actions for the significant deviations named in the report and send the surveillance body the required documents. Only then is certification possible.

The requested documents were examined on: \_\_\_\_\_ Signature: \_\_\_\_\_

The deviations found were removed by the documents submitted later. A renewed audit inspection/surveillance is not required. Based on the findings named above we recommend issue/continued validity of the certificate.

Due to significant deviations it is necessary to perform a renewed audit inspection/surveillance to check the corrective actions.

## General information

- Should changes occur in the organisation or quality-influencing changes to the production facilities and test equipment and a change in responsible supervisory personnel, the Certification Body shall be notified in writing and this requires confirmation.
- The Certification Body reserves the right, in special cases, and depending on the scope and significance of the changes, to require partial or complete repetition of the audit inspection /surveillance at the cost of the Manufacturer.
- Regardless of the audit inspection/surveillance performed, the Manufacturer is responsible for ensuring compliance with the respective latest issue of the relevant technical regulations/specifications valid for the respective production area. We refer to the random character of the audit inspection/surveillance.



- **Agreed date for the next surveillance: 12.2016**  
If the next date deviates by more than one year from the current audit inspection / surveillance, after one calendar year the Manufacturer shall submit a declaration to the Certification Body in accordance with Chapter B.4.1 in EN 1090-1.
- The Manufacturer and the Certification Body each receive a copy of this report.

**Appendices**

- Checklist for certification with comments and attachments

The auditor has not advised the company during the past two years.

**Report written:**

Szczecin 03.12.2015

Place, Date

Mariusz Blezień

Name/Signature of the auditor



Drawing up of the certificate in  German /  English /  Polish

**Confirmation of the report contents by the Manufacturer:**

Szczecin 03.12.2015

Place, Date

Paweł Rybicki

Name/signature of the Head of the FPC

**Checking and release by the Certification Body:**

- Drawing up of the certificate
- Certificate not drawn up because: (To be returned to the auditor)

Cologne, 1.2.2016

Place, Date

Name/Signature of the Certification Body



