

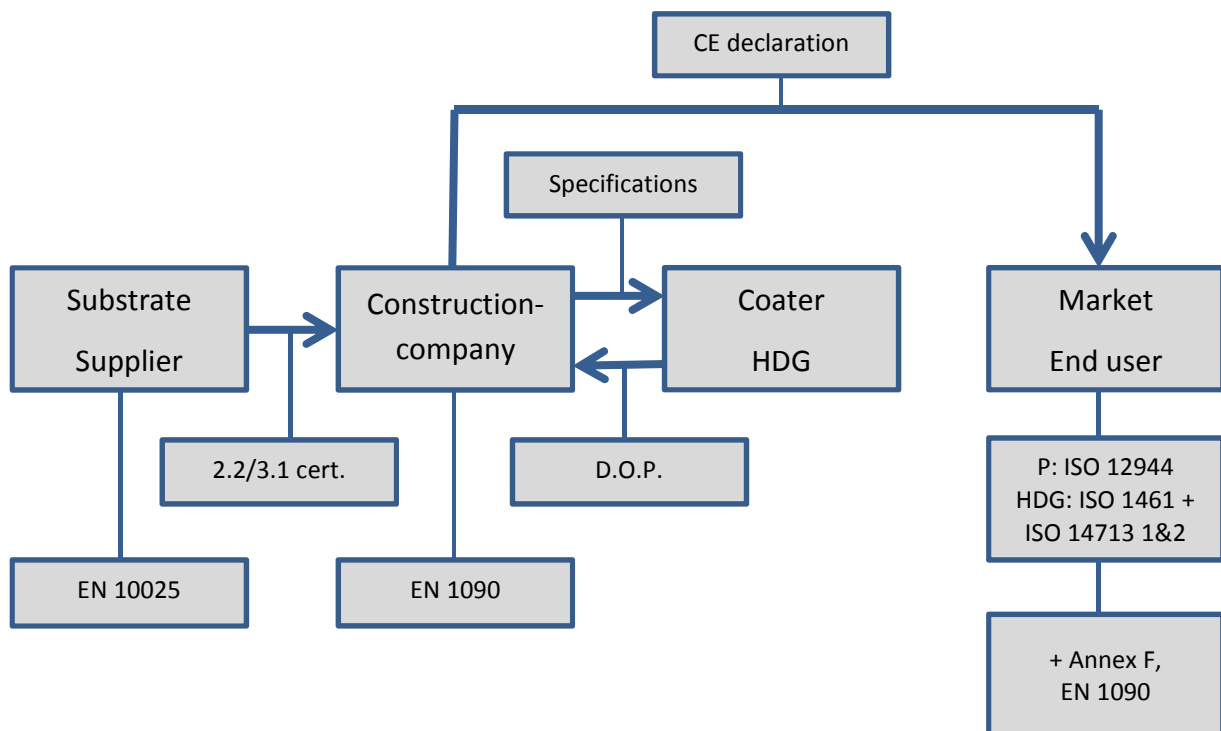
Annex 2: Voluntarily requirements to comply with EN 1090.

Voluntary part of the Qualisteelcoat specifications, to meet the EN1090 requirements.

In fact, for a coater there is not an obligation to give a Declaration of Conformity (DoC). This obligation is for the party that brings the product to the market, and a coater mostly works on order of a construction company or product company.

Due to the fact that EN 1090 addresses the party that brings the product on the market, A coater can do the declaration by himself that his in-house Control and production process fulfils the requirements of EN 1090. However, if a problem occurs, and the coater declared the performance by himself, and the procedures are not right, the customer (construction company) is in deep problems, and will have a significant penalty. If a customer wants to avoid that, either he have to do the audit by himself, or he have to do an audit by an external party. It is obvious, a declaration by a notified body is must stronger than a do it yourself audit, and that is much stronger than a self-declaration of performance by your supplier.

So, for an above mentioned company, it is rather convenient to work with a coater or HDG that do have a guaranteed working process in line with the EN 1090. So it is an advantage to audit the coater in line with the EN 1090 as an extra option on the Qualisteelcoat specifications.



ISO 9001.

The EN 1090 is covered by the Qualisteelcoat specifications with the exception of:

1. Personnel chart with educated tests.
2. The description of the order to the coater with the written coating specifications.
3. An incoming goods procedure.
4. A procedure for customers with complains.

In most cases, an ISO 9001 can cover these aspects, however, one should verify this.

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Items of the EN1090 not (completely) covered by the Qualisteelcoat specification if this voluntary part is not executed.

EN 1090-1 Section 6.3.2 Personnel

Responsibilities, authorities and cooperation of all employees in managerial, executive or supervising functions, which have an impact on the conformity of the product, must be determined.

>>The company needs to have an organisation chart, descriptions of functions and responsibilities and a record of qualification of personnel.

As an example, one can use the following table.

Name employee	Date of birth	Education level	Test to do	Date instruction	Instruction valid to	Instructor

EN 1090-1 Section 6.3.6, EN 1090-2 attachment F, Coating specification

The coating system is defined by:

The expected lifetime (ISO 12944-1) and corrosivity class (ISO 12944-2), to be specified by the customer. The coater has to define a coating system which meets these requirements.

Or;

The coating system is specified by the customer. If applicable special working procedures regarding pre-treatment and/or special coating application are specified.

The coating system to be applied must be indicated in the order specification.

The coater must implement a written supervising and verifying schedule for the verification and recording of the components coated in compliance with the order specification.

>> The coater has to have a procedure for defining a proper coating system according ISO 12944 in case the customer specifies an expected lifetime and corrosivity class. If the customer does not specify an expected lifetime and corrosivity class, the coater needs a procedure to assure the right system for the right use and/or circumstances. The coater has to check if the preparation grade is specified and executed according EN 1090-2, 10.2 (EN-ISO 8501-3).

All necessary information to execute the corrosion protection according the EN 1090 (preparation, corrosivity class and lifetime or coating system, testing requirements, special instructions regarding masking holes or edges) has to be provided by the customer and all this information must be clearly stated on the order guidance form or fabrication form:

- P-grade
- Pre-treatment
- Paintsystem
- Layer thickness

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- Special requirements

EN 1090-2 Section 10.2, 12.6 and Annex F, Incoming goods (products to be coated)

All surfaces to which paints and related products are to be applied shall be prepared to meet the criteria of EN ISO 8501. The preparation grade according to EN ISO 8501-3 shall be specified.

If the expected life of the corrosion protection and corrosivity category are specified, the preparation grade shall be in accordance with Table 22. Integratie EN1090 en Quali-labels 150626 Thermally cut surfaces, edges and welds shall be suitably smooth and able to achieve the specified roughness after subsequent surface preparation (see Annex F).

NOTE Thermally cut surfaces are sometimes too hard for the abrasive material to achieve the suitable surface roughness. The procedure test specified in 6.4.4 may be used to establish surface hardness and determine whether grinding is necessary.

If the structure is to be protected against corrosion, inspection of the structure prior to corrosion protection shall be carried out against the requirements of Clause 10. All surfaces, welds and edges shall be visually inspected. The acceptance criteria shall meet requirements of EN ISO 8501.

>> The company has to have a procedure for visual inspection of all surfaces, welding joints and edges (preparation grade ISO8501-3, EN13438) to check the coatability of incoming goods. Also the action if the coatability is not sufficient must be described.

EN 1090-1, 6.3.8 and annex F, Checking and non-conforming products

Inspection and checking shall be undertaken in accordance with the quality plan. The execution specification shall specify any requirements for additional inspection and testing. Inspection and checking, including routine checking shall be recorded.

The manufacturer shall have written procedures that specify how to deal with non-conforming products. Such events shall be recorded as they occur and these records shall be kept for the period defined in the manufacturer's written procedures.

>> The coater must have procedures how to determine and treat non-conforming products. All cases of non-conformity must be recorded. Non-conforming products must be clearly and visibly marked.