

Structural steel fabricators

From mill certificate to erected frame

Heats traced to their EN 10204 certificates, welds checked against the procedure and the welder on the day, NDT by joint type, bar nesting, and coating checked against the dew point.

EN 10204

Mill certificates and heat release

WPS + welder continuity

Checked at every weld

NDT by joint type

Extent and method from the joint

Every piece mark – traced to its heat

A heat sits in quarantine until its certificate passes; a weld is refused if the procedure or the welder doesn't cover it; and a mark cannot leave until its testing and coating are done.



Traceability you can show

Every piece mark is tied to the heat it was cut from, and every heat to its own mill certificate.



Welds inside the rules

The WPS must cover the joint's thickness, position and type, and the welder must be qualified on the day of the weld.



Testing the code asks for

The NDT extent and method follow the joint type, and the system shows the testing still owed, job by job.



Cost per tonne

A labour standard in man-hours per tonne, a burdened work-centre rate and overhead – set against the order value and margin.

5

joint types with NDT rules

3 °C

minimum above dew point

4

gates before a mark ships

21

man-hours/t, portal frame

Material and welds — checked before they count

Heats are released only on their mill certificate, and every weld is checked against the procedure and the welder's qualification on the day it was made.



Heats & mill certificates

- A received heat lands in **quarantine** until it is released.
- Release is refused if the certificate type is below your minimum EN 10204 grade.
- Tested yield, tensile, elongation and Charpy impact are checked against the steel grade.
- The IIW carbon equivalent is worked out from the certificate chemistry and checked against the grade ceiling.



Welders & procedures

- Each WPS holds its process, position, joints, thickness range, consumable, preheat, interpass and PQR.
- A weld is refused if its WPS does not cover the thickness, position or joint type.
- The welder must be qualified **on the day the weld was made**.
- Continuity runs from the last weld, so recording a weld restarts it; expiring and lapsed welders are shown.



A heat held on its carbon equivalent

In testing, one of **10** casts was held: its carbon equivalent, worked out from the certificate chemistry, came to **0.4732** against the grade's ceiling of **0.450**. On the same job, the one UT rejection fell on the joint that was welded cold.

Quarantine to release

Heats released, in quarantine and with problems, and steel on hand, on one screen.

Welder register

Stamp, qualifications, welds, next expiry and continuity for every welder.

Grades & sections

Yield, tensile, elongation, impact, CE maximum and weld group for each grade.

Tested as the code asks — cleared before it ships

The NDT extent and method come from the joint type, coating is checked for thickness and dew point, and dispatch is the last gate.



NDT & rejections

- The required extent and method are set by the joint type – see the table below.
- Tests by method with length tested, rejects and reject rate, and the recent rejections listed.
- The testing still owed is shown job by job.



Coating & dispatch

- Dry film thickness is checked against the specification.
- Steel must be **3 °C above the dew point** – paint on damp steel fails whatever the gauge says.
- A mark is held back if it has no heat, unmet testing, an open rejection or unaccepted coating.

NDT extent by joint type

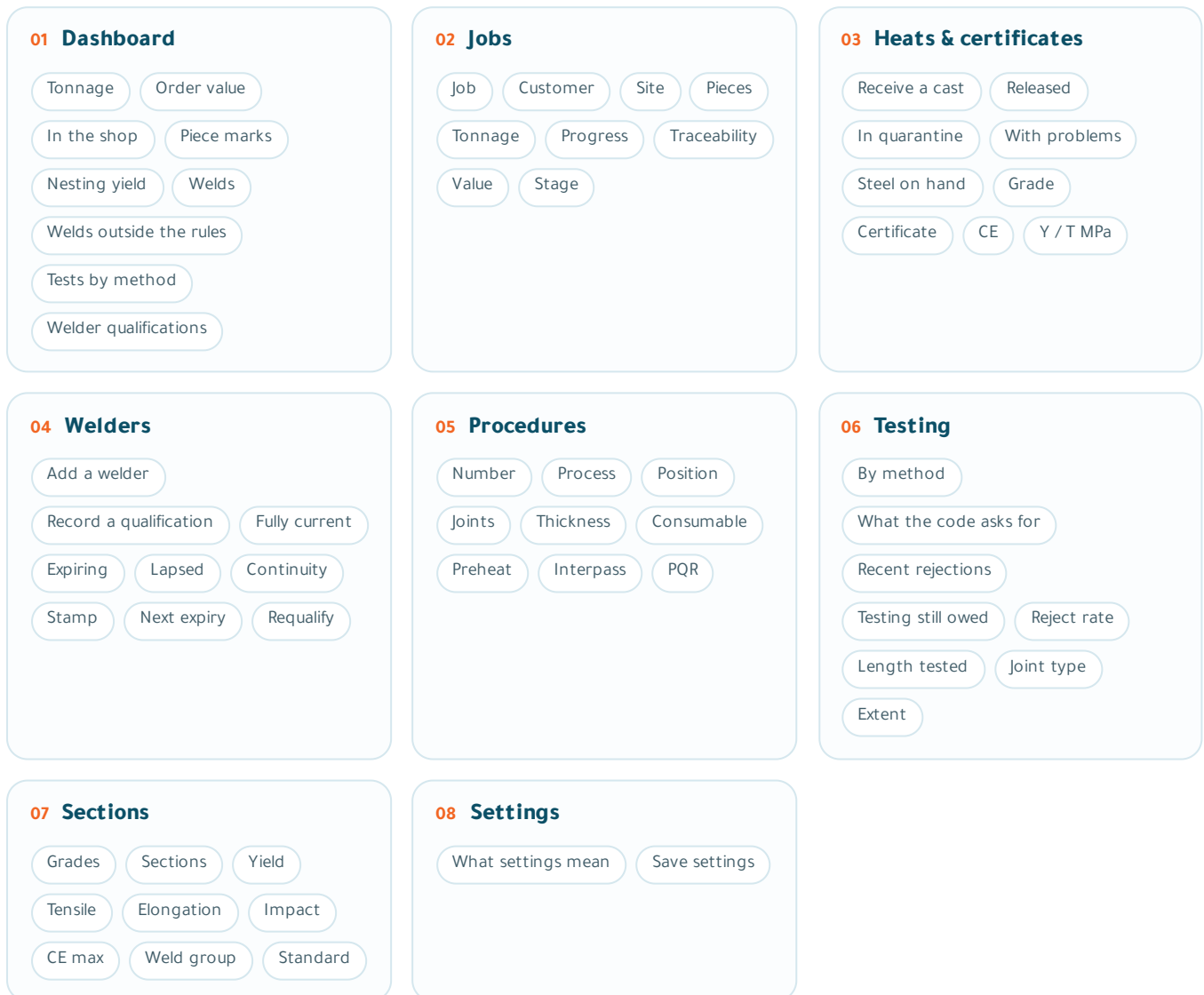
Joint type	Required testing	Extent
CJP, in tension	Ultrasonic testing (UT)	100%
CJP, in compression	Ultrasonic testing (UT)	25%
PJP	Magnetic particle testing (MT)	10%
Fillet, primary	Magnetic particle testing (MT)	10%
Fillet, secondary	Visual testing (VT)	5%

CJP = complete joint penetration, PJP = partial joint penetration. Section nesting uses the same bar optimiser as the aluminium add-on.

Every screen in the module – and what is on it

Read off the running application – the panels, columns and figures that are actually there.

8 **64**
screens functions



Not a separate program – a complete business system

The trade module sits on top of a complete ERP: everything it does lands directly in the accounts, the stores and the reports – no double entry.



Accounting

Editable chart of accounts, automatic entries from every transaction, VAT and financial statements.



Financial dimensions

Cost centres, departments, business lines and sites – with statements per factory.



Inventory

Warehouses and bins, batches and serials, moving average, FIFO or standard cost.



Purchasing & sales

RFQs, purchase orders and receipts, quotations, invoices and ageing.



Maintenance & assets

Equipment register, preventive maintenance, work orders and depreciation.



Access & language

Roles and rights per module, audit trail, full Arabic and English interface.

Standards and regulations supported

EN 10204

Inspection documents – mill certificates

IIW CE

Carbon equivalent (IIW formula)

WPS / PQR

Welding procedure and its qualification

Certificate grade, carbon-equivalent ceiling, welder continuity and NDT extents are enforced in the workflow – not left to a checklist.

Run one of your jobs **with us**

Book a session and we will load one of your jobs – heats, welders and procedures – and take it with you from mill certificate to dispatch.

Request a demo

Website

www.vluerp.com

Demo request

www.vluerp.com/#demo

Email

hello@vluerp.com

- 1 Heat release:** a cast held on its carbon equivalent, with the reason shown.
- 2 Weld check:** try a weld outside the procedure, or by a lapsed welder, and see it refused.
- 3 Testing owed:** the NDT each joint type requires, job by job, with the rejections.
- 4 Dispatch gate:** why a mark is held back – and the job's cost per tonne.

Switched on from Add-ons with a free seven-day trial, and it runs on the same general ledger.