



## Stud Welding Products, Inc.

August 12, 2020

To Whom it may concern

Dear Concerned,

I am responding to your question regarding “piggybacking,” headed weld studs and if this is an approved application per AWS D1.1-2015? Studs applied in the flat (downhand) position are deemed pre-qualified by virtue of the manufacturer’s stud base qualification tests per sub clause 7.9 of AWS D1.1 and no further application testing is required per AWS D1.1-2015 Clause 7 “Stud Welding”.

The “piggyback” application, when performed in the flat (down hand) position, is deemed pre-qualified by virtue of the manufacturers’ stud base qualification tests per sub clause 7.9 of AWS D1.1. Stud welding “piggyback” headed weld studs in the flat (down hand) position requires you to follow the pre-production testing found under sub clause 7.7.1. Sub clause 7.7.1 states you must weld your first two “piggyback” headed weld studs at the beginning of each shift’s production, they shall exhibit a full 360° weld flash and bend 30° at the weld base.

Additionally you will need to cut off the welded stud at the weld base, place the “piggybacked” stud in a vise and bend the stud 30° just above the weld which was “piggybacked” on the first headed stud. If the first two studs past the visual 360° weld flash requirement and the 30° bend test than you may begin production stud welding.

Please let me know if you require additional information and or if you have additional questions.

Best Regards,

Jay E. Koski

Stud Welding Products, Inc.

AWS D1.1-2015 DIQ subcommittee Task Group Member Clause 7 Stud Welding

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