



May 08, 2018

Co. Code: **IMAGE7**

Mr. Blake Hobson
Image Industries Inc. (Bluearc Stud Welding)
11220 E. Main Street
Huntley, IL, 60142
USA

Dear Mr. Hobson:

RE: EXTENSION OF STUD BASE QUALIFICATION

Please find enclosed document IMAGE7 relating to extension of stud base qualifications for Image Industries Inc. (Bluearc Stud Welding) based on our recent audit at your Huntley, Illinois facility.

Qualification is based on the requirements of CSA Standard W59-2013, and for studs that are not covered under CSA W59-2013, acceptance in accordance with AWS D1.1-2015 has been granted. This applies to the stud bases only and any changes to these studs or the method of their manufacture that may affect the weld quality of the product must be reported to the Bureau and the stud base may be subject to requalification.

Your product will appear in the Bureau's annual listing of certified fabricators and products which are distributed throughout the fabricating market in Canada and abroad.

Thank you for your cooperation.

Yours very truly,
CANADIAN WELDING BUREAU

Ashiqur Khan, M.Eng., P.Eng.
Procedures and Electrodes

Canadian Welding Bureau
8260 Parkhill Drive, Milton, ON L9T 5V7
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**STUD BASE QUALIFICATION
FOR
IMAGE INDUSTRIES INC. (BLUEARC STUD WELDING)**

DOC # IMAGE7

This is to advise Image Industries Inc. (Bluearc Stud Welding) that the studs listed in this document and manufactured at 11220 E. Main Street, Huntley, Illinois have been re-qualified/ accepted in accordance with **Clause H.4, Appendix H of CSA W59-2013 or AWS D1.1- 2015**, as applicable.

The following studs were qualified in accordance with **Clause H.4, Appendix H of CSA W59-2013**:

3/8" (10 mm) Headed Anchor
1/2" (12 mm) Headed Anchor
5/8" (16 mm) Headed Anchor
3/4" (19 mm) Shear Connector
7/8" (22 mm) Shear Connector

Due to the limitations of **CSA W59-2013**, the following studs have been accepted in accordance with the requirements of **AWS D1.1-2015**:

3/8" (10 mm) Deformed Anchor
1/2" (12 mm) Deformed Anchor
5/8" (16 mm) Deformed Anchor
3/4" (19 mm) Deformed Anchor
7/8" (22 mm) Deformed Anchor

The following studs have been accepted by the Canadian Welding Bureau due to similarities in the weld base material, stud base diameters (geometry), material flux, or arc shields:

1/4" Partially Threaded Weld Stud
5/16" Partially Threaded Weld Stud
3/8" Partially Threaded Weld Stud
7/16" Partially Threaded Weld Stud
1/2" Partially Threaded Weld Stud
5/8" Partially Threaded Weld Stud
3/4" Partially Threaded Weld Stud
7/8" Partially Threaded Weld Stud

1/4" Threaded Collar Stud
5/16" Threaded Collar Stud
3/8" Threaded Collar Stud
1/2" Threaded Collar Stud

3/8" Threaded Reduced Base Weld Stud
7/16" Threaded Reduced Base Weld Stud
1/2" Threaded Reduced Base Weld Stud
5/8" Threaded Reduced Base Weld Stud
3/4" Threaded Reduced Base Weld Stud

1/4" Fully Threaded Weld Stud
5/16" Fully Threaded Weld Stud
3/8" Fully Threaded Weld Stud
7/16" Fully Threaded Weld Stud
1/2" Fully Threaded Weld Stud
5/8" Fully Threaded Weld Stud
3/4" Fully Threaded Weld Stud
7/8" Fully Threaded Weld Stud

1/4" Threaded Full Base Weld Stud
5/16" Threaded Full Base Weld Stud
3/8" Threaded Full Base Weld Stud
7/16" Threaded Full Base Weld Stud
1/2" Threaded Full Base Weld Stud
5/8" Threaded Full Base Weld Stud
3/4" Threaded Full Base Weld Stud
7/8" Threaded Full Base Weld Stud



These diameters of studs are suitable for arc welding to steel members where the stud is in direct contact with the steel and welded under the conditions given for stud welding in **Clause 6 of CSA W59-2013**, using automatically timed stud welding equipment.

In accordance with **Clause H.4.11 of Appendix H, CSA W59-2013**, this qualification shall remain valid until the manufacturer makes any change in the stud base geometry, material flux, or arc shield that affects the welding characteristics. In addition, qualification shall be reviewed by the Bureau at a frequency of three years as stipulated in **Clause H.4.12.1 of Appendix H, CSA W59-2013**.

In addition to the above stated conditions of qualification, any changes to the requirements for stud welding in **CSA W59-2013, AWS D1.1-2015 or AWS D1.5-2015** may affect the validity of this qualification.

The above noted qualifications/ acceptance is valid until **January 19, 2021**.

Yours very truly,

CANADIAN WELDING BUREAU

Ashiqur Khan, M.Eng., P.Eng.
Procedures and Electrodes

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