February Technical Meeting / Patrons Night
Thursday, February 21, 2019
“Case Studies in Resistance Welding Innovation”
Michael Karagoulis, Ph.D.

Location: Ukranian Cultural Center
26601 Ryan Rd., Warren, MI 48091

Please join us at the Ukranian Cultural Center in Warren for our February technical meeting. This meeting gives you an opportunity to network with your peers, suppliers, customers and other AWS members. We will have a brief introduction and overview by the AWS Detroit Section. A light dinner will be served, and our Patrons will be honored and acknowledged.

Dr. Karagoulis will speak on Case Studies in Resistance Welding Innovation:
#1 – Resistance Seam Welding of Pre-painted Steel
#2 – The Secondary Loop Efficiency “K Factor”
#3 – What Causes Bad Spot Welds?
#4 – Is there one Cap Style that can weld the entire Car Body?
#5 – What is the science behind optimization of weld schedules?
#6 – How does heat flow through the weld electrode?
#7 – Getting control of Tip Dressing

Be sure to bring your technical questions, invite your colleagues, and let’s have some good old “Geeky” fun talking about resistance welding!

As always, you do not have to be a member of the AWS Detroit Section to join us at the technical meetings.

Dr. Karagoulis is a 25 Year AWS Member, has served as Chairman of the AWS Sheet Metal Welding Conferences IX, X, and XI (1999 – 2004), and he was the AWS Detroit Section Chairman 2008-2009.

Notable Accomplishments:
• Invented/Developed/Implemented a new fuel tank seam welding process for GM (1983-1985). This

See Dr. Karagoulis’s Bio on page 2
Mark D. Gugel, P.E., Ph.D.
Chairman’s Message

Welcome to the brisk month of February in South-East Michigan and Ontario.

Every year in February we like to take a moment to remember all of the patrons who generously support the American Welding Society – Detroit Section through their hard-earned money. This year 19 companies and individuals have already donated more than $9,500 toward our section. This money goes a long way to meeting our mission to advance the science, technology and application of welding and allied joining and cutting processes, including brazing, soldering and thermal spraying.

Patrons range from individual gifts of $100 to corporate gifts of $1000. I encourage you to join the Executive Committee and others in becoming a patron of the AWS-Detroit Section.

If you wish to be personally involved with the AWS-Detroit Section, please don’t hesitate to contact me at (810) 602-9735 or mark.gugel@gm.com.

Dr. Karagoulis’s Bio continued from page 1

proprietary process was used from 1984 – 2000 for all pre-painted steel fuel tanks in GM.

- Developed and commercialized a precision tip dressing process, which has been the global standard of GM since 2007.
- Co-Developed and implemented a proprietary GM aluminum spot welding process. Key components developed were Tip Dressing, Weld Control Modifications, Patented Weld Parameters, and a Heat Management methodology.
- Designed/Validated/Commercialized several novel geometries for spot weld tips.
- Developed and commercialized a robust and low-cost standard Tip Dress Verification Gage for automated spot-welding applications.
- General Motors Boss Kettering Award 2013: Aluminum-to-Aluminum Resistance Spot Welding for Body Structures.
- General Motors Boss Kettering Award 2017: Aluminum-to-Steel Resistance Spot Welding for Body Structures.
- Currently involved in developing and implementing new welding methods and standards for lightweight vehicles.
2018/2019 Patrons

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Employment Opportunities
Monroe County Community College is hiring for the following positions:
- **Materials Technology/Welding Instructor** - Full Time. Requires a BS in a technical field related to welding, materials, metallurgy, etc. Position is open with a planned start date of Fall 2019
- **Maker Space Technician** - Part Time (20 hrs/wk). Duties include helping students and community members run equipment and software in the maker space facility and the ASET Division.

Further information and applications are posted on the MCCC website: [monroeccc.edu](http://monroeccc.edu)

Welding and Heavy Metal!
One of our executive committee members, Donald Maatz, Jr., came across the following article in the Detroit Free Press regarding heavy metal band, Metallica, and their organization, All Within My Hands. They are a big supporter of the welding industry and made a considerable donation to a local college and their welding program. You can check out the story and their organization by clicking on either of the two links:
- [www.allwithinmyhands.org/welcome.html](http://www.allwithinmyhands.org/welcome.html)

Looking for Nominees to serve on the Detroit AWS Board
The Detroit Section of the American Welding Society meets on the first Thursday of the months, September through May. The meetings are held to task our main objectives:
- The advancement of the science, technology and application of welding and allied joining and cutting processes, including brazing, soldering and thermal spraying;
- Support for educational opportunities related to welding and allied joining and cutting processes;
- Encouragement of the interaction of the local community of welding professionals, students, and users;
- Advancement of the image of welding
- Promotion of American Welding Society Corporate and Individual memberships.

In furtherance of these objectives the Section will –
- Promote the proper use and application of welding and related processes.
- Increase the quantity and quality of welders and welding professionals.
- Hold meetings for the presentation of appropriate papers and the interchange of ideas.
- Promote welding related inspection trips, educational lectures, training classes, etc.
- Create a rewarding and fulfilling experience for our members.

If you would be interested in attending one of our meetings as a guest or to become a committee member, please contact Mark Gugel at: (810) 602-9735 mark.gugel@gm.com

AWS Library
All AWS items are stored at the Auburn Hills library, and can be utilized any time that the library is open. They are marked “Reference,” so are therefore not available to check out. We do have copy machines available, $.10 per page for black and white, and $.30 for color. Cash is needed to purchase a guest card used for printing or copies, and librarians are more than welcome to help with that. There are copyright laws that limit the number of pages that can be reproduced. Hours are: M-Th 8am-9pm, F 8-5 and S 10-2. Please keep in mind that we do close for breaks. All kinds of information about us (and searching capabilities) are on our website: [https://www.oaklandcc.edu/library/default.aspx](https://www.oaklandcc.edu/library/default.aspx). Engineers can get an idea of what we own.
2019 American Welding Society’s Centennial Year

This will be a very special year for AWS as our 100 year milestone is celebrated. AWS began in response to welding problems from World War I and has continued serving the country and industry ever since. AWS provides leadership in solving many industry problems, providing standardization for equipment, filler metals, Codes and Standards, inspection methods and acceptance criteria, and personnel qualification and certification. The publication of the Welding Handbook, the Welding Journal, and research and development papers support the needs of our metal fabricating and construction industries. AWS is now considered the premier organization for welding and cutting technical information, codes and standards, and education in the world.

FABTECH - Chicago  Nov. 11-13, 2019

Announcements will be forthcoming in the near future regarding plans for celebrating our 100th Anniversary. Many events are planned to celebrate this major milestone. Invite your associates and students to join during our centennial year.

2019 DEADLINES ARE APPROACHING FOR...

Scholarship Applications: Deadline is MARCH 1
This year the application process has changed to an online application system for National, District, and most Section Scholarships. The deadline is March 1 for scholarships to be used the 2019 Fall term. Visit www.aws.org/scholarships to learn more about the application process so you can apply now! Or refer a student to the site and encourage them to apply. Detroit Section scholarship direct link for applications is: www.awsdetroit.org. Contact other Sections or visit www.AWS.org for information and application forms.

District Educator Scholarships: Also, the AWS District Educator Scholarships are available. Applications should be completed no later than April for consideration by the District Committee and awardees selected at the May 20th, 2019 District Conference.

Welder Training Scholarship Applications: With the start of a new year we begin with new opportunities for applicants to apply for these scholarships. These are for individuals who want to learn how to weld, as a stand-alone skill or if they are taking welding classes as part of a technical school program for fabricating, machining, automotive mechanics classes, etc. In 2018 District 11 (Michigan and Northwest Ohio) awarded 20 scholarships of $1,000 each. Students wanting a scholarship may apply at www.aws.org/foundation/page/scholarships. For 2019 our District has 25 scholarships available - students should apply soon. Awards are made to qualified students on a first-come basis until all awarded. Applications are simple and completed on-line.

Leadership Symposium: One individual from our District will be selected to attend plus we can nominate one student from a school to attend. The individual will be selected at the District Conference while the student is selected by the National Membership Committee. Student applications need to be in by February. All interested individuals must apply through the AWS website. Also provide information to me with your recommendations as soon as you have someone in mind. Applications are found at: www.aws.org/events/detail/leadership-symposium.

AWS Welding Instructor Institute: Applications should be submitted early for this and one instructor from our District will be selected to attend with air, hotel, meals, and transportation expenses paid. Apply at: www.aws.org/events/detail/instructors-institute.

Awards: Look around your Section, personnel who are industry leaders and recommend these people for awards. AWS wants to recognize people as outstanding members who serve our industries and the Society. Please forward recommendations and we can work together to get these individuals recognized. Awards are available for local Sections, District, and National Awards Information is available at: www.aws.org/about/awards.

CWI CERTIFICATION
AWS has streamlined the certification exam application and approval process transitioning to online applications for CWI Seminars and/or Exams, Renewals and/or Recertifications through the AWS online certification portal. Paper applications will continue to be accepted but applying through the online certification portal is preferred, ensuring efficient receipt and timely review of applications. Detroit Area 2019 Seminars and Exams are scheduled for:

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DISTRICT CONFERENCE
Mark your calendar for our annual meeting at Lansing Community College West Campus. DIFFERENT DAY Monday May 20, 2019.

DISTRICT DIRECTORS REQUEST
As many of you travel and visit other Sections, make note of events and or meetings that they are having. I wish to attend as many of these as possible but I need to know when they will occur, and the sooner Continued on page 11
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Corporate Announcements

RoMan Manufacturing® Appoints Director of Global Sales
January 7, 2019 GRAND RAPIDS, MICHIGAN— Nelson Sanchez, COO of RoMan Manufacturing, announced the appointment of James Gibson as the company’s Director of Global Sales. With 20 plus years of sales leadership experience with manufacturers in industrial power and automation, Gibson will be responsible for the oversight of RoMan’s global sales functions across all company divisions, including: Automotive, Industrial, Furnace, Glass and Foundry.

“With the continued worldwide growth of RoMan, having a sales professional of Jim’s caliber onboard is the right move for RoMan,” said RoMan’s COO Nelson Sanchez. “Jim’s experience not only brings executive-sales leadership to our diverse sales force and distributors in North and South America, Europe, Asia-Pacific and Africa, but will help the company standardize all sales processes and systems across all of our product lines.”

Prior to joining RoMan, Gibson held sales and marketing leadership positions in various companies including Hammond Power Solutions, Emerson Electric and Weidmuller. He has been active in industry associations including: The National Electrical Manufacturers Representatives Association, the Association for High Technology Distribution and the National Association of Electrical Distributors.

“Becoming part of the sales leadership team of RoMan is an honor and a privilege,” said Gibson. “RoMan is one of the, if not, the strongest global brand in the diverse industries it serves. My job here is two-fold. First, to ensure RoMan continues on a strong sales course, and second, that it does so while providing our customers with a superior buying experience.”

Gibson holds a Bachelor of Science in Business Administration degree from Albright University, and an Electrical Engineering Technology degree from the Pennsylvania State University. He also is a graduate of Emerson Electric, Canada’s Advanced Leadership program.

About RoMan

RoMan Manufacturing was founded in 1980 with a singular corporate commitment to manufacture water-cooled, high-current, low-voltage power sources to the highest quality standards, using the finest materials available. This commitment has made us a worldwide industry-leading manufacturer of AC and DC Power Sources, and related specialty products. Our innovative application-centric engineering, ISO certified and efficient lean manufacturing (Toyota Production System – TPS) processes produce the highest quality products. We provide our clients with a wide array of designs which give us the flexibility to customize products to any configuration, specification or application requirements. We also offer value added services such as training, technical and application support.

Upcoming Events

February 1, 2019
AWS Foundation Welder Workforce Grant
Online registration begins in February
Presented by AWS National

February 21, 2019
Technical Night and Patrons Awards
Ukrainian Cultural Center, Warren, MI
Presented by AWS Detroit

March 2019
Technical Night/Awards Night
Date and Location TBD

April 1, 2019
Scholarship Applications are due!
AWS Scholarships – Detroit Section
On LINE application

April 2019
Technical Night at Centerline Windsor
Windsor, ON
Date TBD

April 6, 2019
AWS Detroit Section Ladies Night
Motor City Casino, Detroit
Presented by AWS Detroit

April 2019
Educational Event
Date and Location TBD
presented by AWS Detroit
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Productivity. Win the Race!
How many times have you heard someone start their answer to a question with, “well in my opinion...?” Have you ever said this? I know I have, and I bet many of you reading this have too. Why do you suppose people use that phrase as they lead into a thought or belief they’re about to convey? Well, in my opinion (yup I just did it ;), it’s mainly because we’re uncertain that we can back up what we’re saying with any substantial and credible support. After all, if someone challenges your statement you can just throw out, “Like I said, it’s just my opinion, and I’m entitled to my opinion.” Sounds like a good answer, right? And, most of the time it may be true, and your opinion is just as important and valid as the next guys. But let’s talk about this from a CWI’s perspective. Is your opinion always valid? The answer is NO, and I’m going to give you several reasons and examples of why and when your opinion has no place. By the way, if you’re not a CWI or you aren’t familiar with welding standards, much of what I say from here forward may not make sense but hang with me.

Let’s start with when. Your opinion doesn’t matter when you, as an AWS CWI are working within the confines of certain clauses or subclauses of a welding standard or code such as AWS D1.1. For example, let’s assume you work for Spark’s & Arc’s Welding Company, LLC (a fictitious company for this example) and you’ve been asked to provide a WPS from the company’s library. The drawing you have for the project requires conformance to AWS D1.1/D1.1M: 2015. As you review the base metal(s) (B/M) to be welded you notice there is an ASTM A108 among the B/M’s on the bill of materials (BOM). It’s your intention to use a prequalified WPS from your library, so you do a quick check of clause 3, Table 3.1. You discover that ASTM A108 is not listed in that table, but you’re not shaken by this discovery. You recall a time on another job when you had your welders weld this very same base metal and it worked out great. You used the same shielding gas, filler metal, welding process and even the same electrical parameters as those on the prequalified WPS that you planned to use on this job. Since the other job went so well and you never had any negative feedback, you decide to issue the pre-qualified WPS for the new job, because in your opinion this metal will weld just fine using your WPS. This is an example of when your opinion doesn’t matter. You may think that you understand the chemistry of all the B/M’s for this job and can anticipate the weldability, but that would be your opinion. Here’s why your opinion isn’t relevant. The very first sentence in clause 3.3 states that ONLY base metals listed in Table 3.1 may be used in prequalified WPSs. You have no authority to render an opinion on weldability and to act on your opinion. Now I’m not saying that you’re out of options for welding that base metal, because there are options. I won’t get into those here, but until you’ve investigated those other options, your opinion and justification for using the prequalified WPS is not supported by the code.

Here’s another example of when your opinion has no place on the job. Let’s say you’ve been called in to inspect a weldment after its completion. This weldment was completed using AWS D1.6/D1.6M:2017. You confirm that all the other criteria pertinent to the job is in order, such as PQR/WPS/WPQ, base metals, consumables, standards/codes used, etc., and

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**CWI Corner continued from page 11**

everything is good. In your review of the welding symbols on the weldment drawing you see that there are 6mm fillet welds called out at several of the T-joint locations. Aside from the specified size for the fillet welds no additional tail note or other welding notes are on the drawing or in the contract documents. You begin your inspection of the weldment and discover that the welds meet the size requirement, but all stop short from the end of the principal weld joint. You measure the amount of “missing” weld and discover the welds have been terminated anywhere from 2mm to 4mm from the end of the joint on each occurrence. All other requirements from table 8.1 have been met, so you begin your report. You make a note on your report that states, “incomplete welds at the ends should be addressed.” Now exactly what you meant by “…should be addressed” only you know. But this could be interpreted as the welds should be continued to the end of the joint, or maybe you would even want the welds boxed. Either way, the statement the welds are “incomplete” is your opinion. Just as in the first example, your opinion has no relevance here and the following is why. A review of AWS D1.6/D1.6M:2017, subclause 4.4.4.1 tells us, “Unless otherwise specified in this code or other contract documents, fillet welds connecting attachments need not start nor terminate less than the weld size from the end of the joint.” Your statement about “incomplete” is only true if you can validate it based on additional information contained in the code regarding these weld joints, or the subclause is superseded by something else you discover in the contract documents.

For the last example I’ll use AWS D1.6/D1.6M:2017 again. And again, you’ve been called in to inspect a weldment with fillet welds specified on T-joints. You’ve reviewed all the contract documents and other documents pertinent to the job and everything is in order. The specified weld sizes for the fillet welds is 6mm and you observe most to be in conformance with table 8.1. All welds are slightly convex, but three have leg lengths that measured 6mm on one side and 8mm on the other leg. You note in your report that “The unequal leg length on fillet weld does not meet project requirements (weld size).” Unless you can verify your statement through contract documents or elsewhere on the drawing, again this is nothing more than your opinion and is without merit. Here’s why. Subclause 7.15.2.1 states, ‘Unequal leg fillet welds produced where welding symbol(s) indicate equal leg fillets are acceptable (provided the minimum specified size is met) unless specifically prohibited or cause interference with mating members.’ Now you may not like the way these welds look, but unless you can prove these welds violate the code or something in the contract documents, they’re in compliance.

So, speaking purely from a CWI standpoint, when does your opinion matter. Well, the short answer is when someone asks for it and you have the authority to give it.

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**Editor’s Notes**

A new month, a new opportunity! February is one of those short months that seems to breeze by. We are far past the holidays, and hoping that the cold, dark days of winter will pass quickly.

Unfortunately, we had to cancel last month’s technical meeting and it was very last minute. I apologize to all of you that were planning on attending.

This month, we acknowledge the patrons of the AWS Detroit Section. We are hoping to see many of our patrons at the technical meeting where they will receive recognition and an award.

We are still looking for companies that would like to host future technical nights. If you or your company would be interested in being a host to one of our technical nights, contact John Pippen, Jr. at jrpippen@milcomfg.com.

I should mention, too, that our annual AWS Detroit Section Ladies’ night is only a couple months away. It will be held at the Motor City Casino again this year on April 6. Those of you who attended last year reported back to us, that this was a great venue, and a great time.

For all our students, don’t forget to go online and start getting those applications for scholarships completed. The AWS Detroit site only accepts the online application. There is no longer a paper one.

Hope to see some of you at the February tech night.

Until next month,

**Keep on Welding!**

Robin

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As a CWI there are very few times when your opinion matters. Your expertise should be in the navigation of the standard/code as written and its application. The standards and codes exist for the very purpose of eliminating opinions and providing definitive ways and means to accomplish a task. Are they perfect? No, but the alternative is worse. AWS also publishes guides, which are not standards or codes, and these do offer opinions on various subjects. But even with those, they don’t offer one person’s opinion, rather a consensus of opinions from multiple industry experts. When dealing with codes, it’s best to keep your opinions to yourself and stay within the written text. If you are unsure and you require an official interpretation of a clause or text in a code, it’s best to follow the procedure outlined in the code you’re working with to accomplish this. The bottom line here is that opinions, whether given or taken, can be costly and even dangerous if they can not be supported by the standard or code you are working in.

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WELDING SCHOLARSHIPS

for

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in

WELDING ENGINEERING, WELDING ENGINEERING TECHNOLOGY

or

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For students pursuing Post-secondary training or an Associate/Bachelor Degree in Welding Engineering or Welding Engineering Technology. These scholarships provide money to be used for the student's tuition, books, or lab fees for one year. To be eligible for these scholarships, you must be enrolled in a certification-based program or two (2) or four (4) year engineering degree program in Welding, Welding Technology, or a related field. The program supports students attending schools in the state of Michigan and the following counties in the province of Ontario; Essex, Chatham-Kent, and Sarnia-Lambton.

An on-line application form (with supplemental instructions) is now available on the AWS Detroit Section website, under the ‘Scholarship’ tab. www.awsdetroit.org

Application deadline for the 2019-20 academic year is April 1, 2019.

Scholarship Committee
AWS Detroit Section
PO Box 530305
37500 Pembroke Ave
Livonia, MI 48152

For 2018/19 the section was able to award 30 scholarships totaling $60,000 to students from 8 different schools.

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If you’re not already an AWS CWI and the idea of becoming a CWI is a career that you would like to pursue, the AWS-Detroit Section is hosting two AWS CWI Seminar/Exams this year:

**CWI Seminar May 05 – May 10, 2019**
Exam May 11, 2019
Location: Detroit Metro Airport Marriott
30559 Flynn Dr, Romulus, MI 48174
(734) 729-7555

AND

**CWI Seminar October 13 – October 18, 2019**
Exam October 19, 2019
Location: Detroit Metro Airport Marriott
30559 Flynn Dr, Romulus, MI 48174
(734) 729-7555

Check the AWS-Detroit e-Bulletin often for other helpful information, at www.awsdetroit.org. For more information on how to become properly trained and certified by the American Welding Society and to register, you can visit www.aws.org/certification.
Golightly CTC and Davis Aerospace Vocational High School
Submitted by Jeffry Hill, AWS Vocational Chair, ARO Welding Technologies

Golightly is unique as it houses three separate schools: Golightly Career Training Center, Davis Aerospace Training Center and Golightly, which is also now a full time High School. All three schools are overseen by one superintendent, Neal Morrison, who was previously employed by the Oakland County School district. Neal has done a great job in keeping the trades in the DPS system and has worked hard on setting up machine shops at Golightly and Randolph High Schools. AWS has been working with Golightly to ensure that the CTC Programs now there stay there and give whatever assistance is needed.

AWS has been working with Golightly for just over five years now and has helped in many ways to keep the welding program at the level that it has been for years. Jeffrey Samuels the current instructor has picked up were Mr. Juan Whiting left off; the welding program at Golightly is the premier welding program in the Detroit School District. They have had students compete in the Skills USA competitions and in the AWS HSWC. Last year Golightly had a student finish in the top 10.

Juan Whiting although retired still assists Mr. Samuels at Golightly with the welding program and has continued to be a great help at the school and a mentor to many a student. AWS has and will continue to help in any way we can, from supplying gas and metal to the welding lab, helping with PPE, participating in the career day events and having special speakers stop by and talk with the students and share their expertise. I have chaired their Weld Advisory Committee five years straight. We have set up and maintained an AWS Student Chapter at Golightly for past five years also.

I hope to continue to work with Golightly as I have made friends there. Neal Morrison, Jeffrey Samuels, and Juan Whiting all deserve a special thank you for being as committed as they are to our young adults and helping ensure a positive future. I would also like to thank Patricia Bell and Michelle Davis (also Golightly staff) for assisting in getting internship and CO-OPS for the students and working with the Weld Advisory Committee to help make these programs a success. From our AWS committee a special thanks to Tom Sparschu who got this all started, Ray Roberts who has been a part of this since the start, and Andre Young as he also has been a great help and has set up field trips to Kuka robotics for Golightly.

In closing I would like to thank the Detroit section for allowing me to continue to work with Golightly, and if any of my fellow committee members would like to get more involved let me know as we can use all the help we can get. Also just one more thing if anyone who reads this wants to contact myself or the District for assistance with welding programs currently in place or are thinking of starting one within our district please feel free to contact AWS as this is what it is all about, helping our young adults prepare for a better future and give them a skill that will last a lifetime.