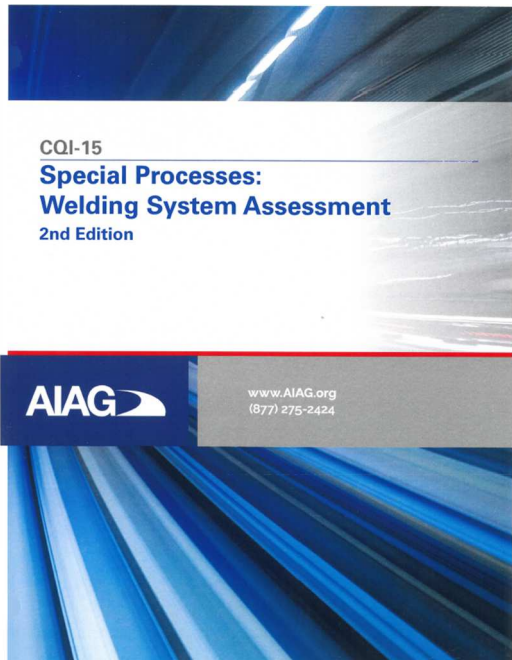


The new AIAG CQI-15 Welding System Assessment 2nd Version Oct. 2019 & 2nd Printing Jan. 2020

The new AIAG CQI-15 2nd Edition was officially announced in October 2019. As a long-time AIAG member and official training license partner, TopQM-Systems is always "up to date" and provides the automotive market with the latest AIAG information. We offer training for all AIAG CQI special processes and are always up to date. Benefit from this exclusivity and sign up for our newsletter at www.topqm.de and thus always find the latest AIAG topics.

Below are the most important changes to the 2nd Edition. This change information was compiled by TopQM-Systems because no official AIAG changes are listed in the new CQI-15 standard.



- Cover sheet - The cover sheet has been completely redesigned; the rating system has been automated in "degrees of fulfilment" (R-Y-G) status
- Cover sheet - A new evaluation and systematic of the "Special Characteristics" (CTQ) was added
- Cover page - product-specific information was added, such as detailed welding process information, article number, in which vehicle the component is assembled, to which customer the component is delivered
- Cover sheet - The welding processes have been reorganized
- Main audit questionnaire - 5 sub-elements were re-divided into:
 - » 1. Weld System Process Assessment
 - » 2. Documentation
 - » 3. Preplanning / Quality Documentation
 - » 4. Production Monitoring / Documentation
 - » 5. Rework
- Main WSA audit questionnaire - the number of audit questions has been increased from approximately 74 to 85
- The process tables and the job audits were merged into a common audit checklist and renamed "Job Audit Process Tables"
- The audit question lists of the individual welding processes "Job Audit Process Tables" were re-divided into the following sub-question elements: 1. Part Print 2. Control Plan 3. Destructive / Non-Destructive testing Data 4. Weld Quality Inspection & Reports 5. Rework Procedures & Reports 6. Parameter Documentation 7. Maintenance Records 8. Sustainability 9. Equipment & Robotic Processing Requirements
- Ultrasonic welding is no longer required in the new CQI-15 2nd Edition, US welding is typically for plastic welding
- A new "Welding Health Chart" has been introduced for the continuous monitoring of welding quality

Where can I buy the official CQI-15 as a license version?

This can be purchased at www.aiag.org

Below is a list of the new CQI-15 "Job Audit Process Tables 1-8"

1. Job Audit Process Table	GMAW Gas Metal Arc Welding
2. Job Audit Process Table	LBW Laser Welding
3. Job Audit Process Table	Drawn Arc Welding
4. Job Audit Process Table	Resistance Welding
5. Job Audit Process Table	Friction Welding
6. Job Audit Process Table	Induction/High Frequency Tube Welding
7. Job Audit Process Table	Fastener Projection Welding
8. Job Audit Process Table	MIAB Magnetically Impelled Arc Butt Welding

Further information and registrations for our diverse AIAG CQI seminar program can be found at www.topqm.de in our current "seminar and audit program"

CHANGES MADE TO CQI-15 2nd Edition, 2nd PRINTING

The following corrections were made to the CQI-15 2nd edition, 2nd printing:

1. Job Audit Process Table Section 2 Control Plan

- Weld Lot Containment – All weld validation testing shall be performed prior to shipping (Batch & Hold)

Changed to –

- Weld Lot Containment – All weld validation testing shall be performed prior to shipping Components with critical (CC) welds (Batch & Hold).

2. Drawn Arc Job Audit tab, item 4.6

- Control Limits – Control limits shall be utilized for controlling minimum load requirements

Changed to –

- Warning Limits – Warning limits shall be utilized for controlling the weld attributes. Warning limits to establish an alert prior to failure to meet specifications

3. Resistance Welding Job Audit, items 7.3 and 7.5 are duplicates and will be combined into 7.3

- 7.3 Part touching details, locating pins, fixture locators and tooling mating surfaces – All details checked for looseness, all non-pinned details torque checked and match marked.
- 7.5 Part touching details, locating pins, fixture locators and tooling mating surfaces – All mating surfaces shall be free of expulsion and debris.

Changed to –

- 7.3 Part touching details, locating pins, fixture locators and tooling mating surfaces – All details checked for looseness, all non-pinned details torque checked and match marked. All mating surfaces shall be free of expulsion and debris.
- Item 7.5 will be deleted

Note: For auditing / assessing purpose the CQI-15 2nd edition and the CQI-15 2nd edition, 2nd printing are considered equivalent.

