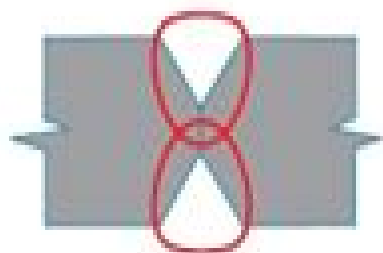


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Wind Tower  
Joint Preparation

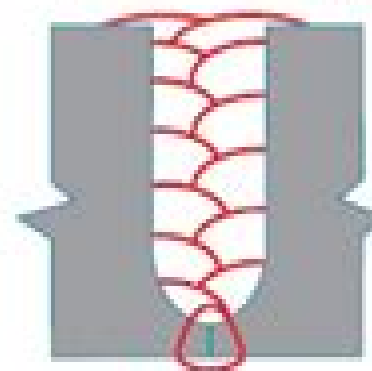
Two-Run



Multi-Pass



Narrow Gap



CVN  
Temp  
Flux / Electrode  
Combination

-32° C (0° F)	-29° C (-20° F)	-40° C (-40° F)	-29° C (-20° F)	-40° C (-40° F)	-46° C (-50° F)	-40° C (-40° F)	-46° C (-50° F)
WTX™ / L-61							
960 / L-61	WTX™ / L-70	996N / LA-81	P223 / L-61	P223 / L-S3	888™ / L-S3	888™ / L-S3	888™ / LA-85
761 / L-61	761 / L-70						

NOTE: Base material dilution is typically 60 - 70% in Two-Run applications, so the Charpy V-Notch (CVN) values will vary significantly with changes in the base metal chemical composition.

# Lincoln Welding Rod Guide

**K Morrison**



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