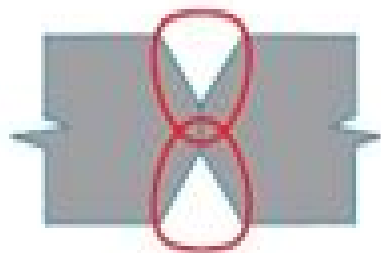


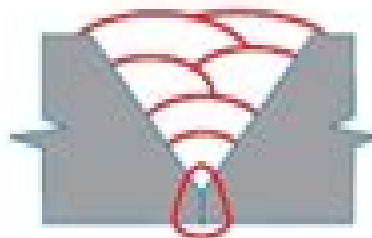
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Wind Tower
Joint Preparation

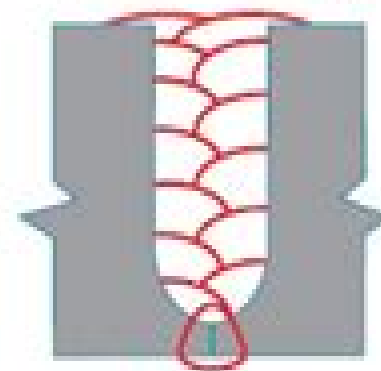
Two-Run



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

906N / 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

DJ Losen



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