



Fillet Weld Soundness Test (FWST) Results	
AWS D1.5-95	Section 5.10
FWST No: T-TEST-10	Date Welded: 02/23/04

Prepared by: Chris Lausch

T1 Thickness 1 INCH

T2 Thickness 1 INCH

Filler Metal Specification AWS A5.17

Filler Metal Classification F7A2-EM12K (LINCOLN L61)

Shielding Gas N/A

Flux Mfg. Designation LINCOLN 761 AND 960(2ND PASS 3/8")

Voltage 32.5V
(use mean voltage of WPS to be qualified)

Amperage/WFS* 400A/129WFS
(use mean amperage/WFS* of WPS to be qualified)

Polarity DCEN

Position of Welding 2F (HORIZONTAL)

* wire feed may be used in lieu of current when a correlation curve is provided for the same electrode diameter and electrode extension.

TEST RESULTS (per 5.19.3.1)

	Maximum Size Single Pass	Minimum Size Multiple Pass
	Weld Size 5/16"	Weld Size 3/8"
Weld Size Acceptable	Yes	Yes
Cracking	No	No
Thorough Fusion	Yes	Yes
Weld Profile per 3.6	Yes	Yes
Undercut > 1/32 inch	No	No

Note: Fillet weld soundness tests are required in addition to groove weld PQRs to qualify fillet welds. A fillet weld macroetch test shall be made for each WPS and position to be used in construction. Test Plate D shown in Figure 5.8 of AWS D1.5-2002 shall be used.

Preparer's Signature: Chris Lausch

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