



Fillet Weld Soundness Test (FWST) Results
AWS D1.5-95 Section 5.10
FWST No: J-TEST-10 Date Welded: 09/23/04

Prepared by: Chris Lausch
T1 Thickness 1 INCH
T2 Thickness 1 INCH
Filler Metal Specification AWS A5.17
Filler Metal Classification E70A2-EM12K (LINCOLN L61)
Shielding Gas NA
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 Weld Size <u>5/16"</u>	Minimum Size Multiple Pass Weld Size <u>3/8"</u>
Weld Size Acceptable	<u>Yes</u>	<u>Yes</u>
Cracking	<u>No</u>	<u>No</u>
Thorough Fusion	<u>Yes</u>	<u>Yes</u>
Weld Profile per 3.6	<u>Yes</u>	<u>Yes</u>
Undercut > 1/32 inch	<u>No</u>	<u>No</u>

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.

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