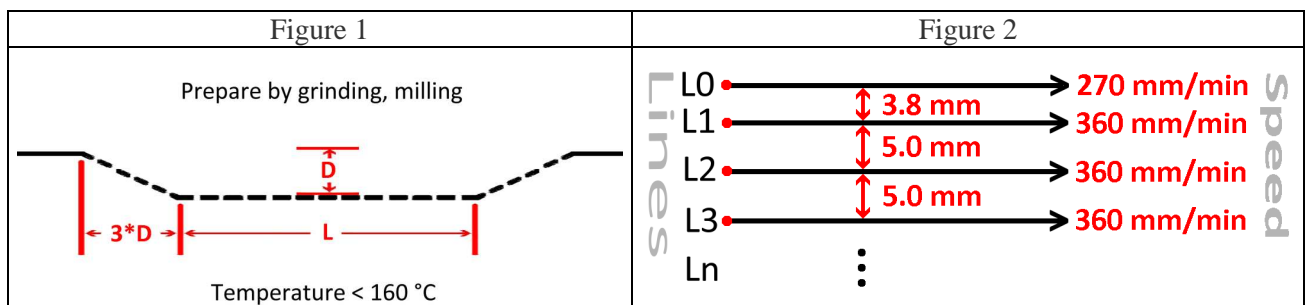


Welding Procedure Specification

LASTIFIL LF 8071G

Chemical Composition according to manufacturer data	C	Mn	Si	Cr	Ni	work hardened
	0.4	16.0	0,45	14.3	1-2	250-500 HB

OPS Reference	Operating Procedure Specification No.: OPS-0001
Welder's Name	
Welding Equipment	Power Source Lasmig + smartRobot®
Base Metal	13% Mn Steel
Method of Preparation	View Figure 1, Grinding / Brushing
Welding Process / Position	View Figure 2, FCAW / 1G
Wire / Diameter / Class	LF 8071G / 1.6 mm / EN 14700: TFe 9
Stick Out	30 mm
Current / Voltage / Polarity	170 A / 28 V / DC+
Preheat / Interpass Temp	100 °C / 160 °C
Travel Speed	27 - 36 cm/min



Operating Procedure OPS-0001: Multi-Area, Multi-Line, Fast-Line-Mode-Oscillation: 0.4 mm

