

Table 330.1.1 Preheat Temperatures

Base Metal P-No. [Note (1)]	Base Metal Group	Greater Material Thickness		Additional Limits [Note (2)]	Required Minimum Temperature	
		mm	in.		°C	°F
1	Carbon steel	≤25	≤1	None	10	50
		>25	>1	%C ≤ 0.30 [Note (3)]	10	50
		>25	>1	%C > 0.30 [Note (3)]	95	200
3	Alloy steel, Cr ≤ 1/2%	≤13	≤1/2	SMTS ≤ 450 MPa (65 ksi)	10	50
		>13	>1/2	SMTS ≤ 450 MPa (65 ksi)	95	200
		All	All	SMTS > 450 MPa (65 ksi)	95	200
4	Alloy steel, 1/2% < Cr ≤ 2%	All	All	None	120	250
5A	Alloy steel	All	All	SMTS ≤ 414 MPa (60 ksi)	150	300
		All	All	SMTS > 414 MPa (60 ksi)	200	400
5B	Alloy steel	All	All	SMTS ≤ 414 MPa (60 ksi)	150	300
		All	All	SMTS > 414 MPa (60 ksi)	200	400
		>13	>1/2	%Cr > 6.0 [Note (3)]	200	400
6	Martensitic stainless steel	All	All	None	200 [Note (4)]	400 [Note (4)]
9A	Nickel alloy steel	All	All	None	120	250
9B	Nickel alloy steel	All	All	None	150	300
10E	17Cr steel	All	All	None	150 [Note (5)]	300 [Note (5)]
15E	9Cr-1Mo-V CSEF steel	All	All	None	200	400
—	All other materials	—	—	None	10	50

NOTES:

(1) P-No. and Group No. from ASME BPVC, Section IX, QW/QB-422.

(2) SMTS = Specified Minimum Tensile Strength.

(3) Composition may be based on ladle or product analysis or in accordance with specification limits.

(4) Maximum interpass temperature 315°C (600°F).

(5) Maintain interpass temperature between 150°C and 230°C (300°F and 450°F).

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Albert A Gayle



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