

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 ≤ ½%	≤13	≤½	SMTS ≤ 450 MPa (65 ksi)	10	50
		>13	>½	SMTS ≤ 450 MPa (65 ksi)	95	200
		All	All	SMTS > 450 MPa (65 ksi)	95	200
4	Alloy steel, ½% < 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	>½	%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	27Cr 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-Nos. and Group Nos. 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).

# Preheating Guide For Welding

**Albert A Gayle**



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## **Table of Contents Preheating Guide For Welding**

1. Understanding the eBook Preheating Guide For Welding
  - The Rise of Digital Reading Preheating Guide For Welding
  - Advantages of eBooks Over Traditional Books
2. Identifying Preheating Guide For Welding
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Preheating Guide For Welding
  - User-Friendly Interface
4. Exploring eBook Recommendations from Preheating Guide For Welding
  - Personalized Recommendations
  - Preheating Guide For Welding User Reviews and Ratings
  - Preheating Guide For Welding and Bestseller Lists
5. Accessing Preheating Guide For Welding Free and Paid eBooks
  - Preheating Guide For Welding Public Domain eBooks
  - Preheating Guide For Welding eBook Subscription Services
  - Preheating Guide For Welding Budget-Friendly Options

6. Navigating Preheating Guide For Welding eBook Formats
  - ePub, PDF, MOBI, and More
  - Preheating Guide For Welding Compatibility with Devices
  - Preheating Guide For Welding Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Preheating Guide For Welding
  - Highlighting and Note-Taking Preheating Guide For Welding
  - Interactive Elements Preheating Guide For Welding
8. Staying Engaged with Preheating Guide For Welding
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Preheating Guide For Welding
9. Balancing eBooks and Physical Books Preheating Guide For Welding
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Preheating Guide For Welding
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Preheating Guide For Welding
  - Setting Reading Goals Preheating Guide For Welding
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Preheating Guide For Welding
  - Fact-Checking eBook Content of Preheating Guide For Welding
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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