

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

SHIELDED METAL-ARC WELDING WITH LOW
HYDROGEN ELECTRODES, OR SUBMERGED ARC
WELDING, OR FLUX CORED ARC WELDING

THICKNESS OF THICKEST PART AT POINT OF WELDING - (mm)	ASTM A-36, A-572, AND A-588 M183, M223, AND M222 ASTM A709, GRADE 250 ASTM A709, GRADE 345 ASTM A709, GRADE 345W
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TO 19.1, INCL.	10°C
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OVER 19.1 TO 38.1, INCL.	20°C
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OVER 38.1 TO 63.5, INCL.	65°C
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OVER 63.5	110°C
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THE MAXIMUM PREHEAT TEMPERATURE SHALL NOT EXCEED 232°C.
THE MAXIMUM INTERPASS TEMPERATURE SHALL NOT EXCEED 288°C.

REFER TO THE FOLLOWING CHART FOR EQUIVALENT STEEL TYPES.

ASTM A-36 AND A-709 GRADE 36 AND AASHTO M183
ASTM A-572 AND A-709 GRADE 50 AND AASHTO M223
ASTM A-588 AND A-709 GRADE 50W AND AASHTO M222

CONTACT QUALITY CONTROL FOR PREHEAT REQUIREMENTS ON ANY STEEL
NOT SPECIFICALLY NOTED ABOVE

REVISED:

ORIGINAL ISSUE: 3/4/96

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VTRANS
RECEIVED

OK'D BY Jane OK'D BY

JUN 03 2005

SUBMIT APPROVED

BY DATE 7-6-05

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