

Preheat temperatures for flame cutting of TBL steels



Steel grade	Plate thickness t in mm														
	≤ 5	≤ 10	≤ 15	≤ 20	≤ 25	≤ 30	≤ 35	≤ 40	≤ 45	≤ 50	≤ 55	≤ 60	≤ 65	≤ 70	> 70
TBL	without				100 °C				125 °C				150 °C		
TBL PLUS	without														