

Preheat temperature for MAG-welding of TBL steels

heat input $Q = 1.0 \text{ kJ/mm}$
hydrogen content $HD = 2 \text{ ml/100 g}$



Steel grade	Plate thickness t in mm										
	≤ 5	≤ 10	≤ 15	≤ 20	≤ 25	≤ 30	≤ 35	≤ 40	≤ 45	≤ 50	> 50
TBL	-	75 °C	100 °C		125 °C		150 °C			175 °C	
TBL PLUS	100 °C	125 °C	150 °C								