Preheat temperatures for MAG-welding of quenched and tempered structural steels

heat input Q = 1.0 kJ/mm
hydrogen content HD = 2 ml/100 g

Steel grade	Plate thickness t in mm												
	≤ 5	≤ 10	≤ 15	≤ 20	≤ 25	≤ 30	≤ 35	≤ 40	≤ 45	≤ 50	≤ 55	≤ 60	≤ 65	≤ 70	> 70
N-A-XTRA® 550	without				75 °C		100 °C		125 °C						150 °C
N-A-XTRA® 620	without				75 °C		100 °C		125 °C						150 °C
N-A-XTRA® 700	without				75 °C		100 °C		125 °C						150 °C
N-A-XTRA® 800	without				75 °C		100 °C		125 °C						150 °C
XABO® 890	without		75	100	125 °C		150 °C				175 °C		200 °C		
XABO® 960	without		75	100	125 °C		150 °C		175 °C				200 °C		
XABO® 1100	-	75	100	125 °C		150 °C									

Relevant plate thickness t for the determination of the preheat temperature according to the CET-concept