



Cutting & Welding				
Pre-heat and Interpass Temperature				
	Temperatures in Fahrenheit			
Description & Size	Oxy-Fuel Cutting	Plasma Cutting	Welding Min °F	Interpass Max °F
AR36 & A572				
< 1 ½"	60 - 72°F	60 - 72°F	Ambient	400
1 ½" – 2 ½"	60 - 72°F	60 - 72°F	150	400
>2 ½"	60 - 72°F	60 - 72°F	250	400
AR 514 & A517				
< ¾"	60 - 72°F	60 - 72°F	Ambient	400
¾" – 1 ½"	60 - 72°F	60 - 72°F	150	400
>1 ½"	60 - 72°F	60 - 72°F	200	400
AR 400				
3/8"	60 - 72°F	60 - 72°F	Ambient	400
5/8"	60 - 72°F	60 - 72°F	Ambient	400
3/4"	60 - 72°F	60 - 72°F	150	400
AR 450				
3/8"	60 - 72°F	60 - 72°F	Ambient	400
5/8"	60 - 72°F	60 - 72°F	Ambient	400
¾"	60 - 72°F	60 - 72°F	150	400
1" or greater	200	60 - 72°F	200	400
AR 500				
3/8"	60 - 72°F	60 - 72°F	Ambient	400
5/8"	60 - 72°F	60 - 72°F	Ambient	400
3/4"	60 - 72°F	60 - 72°F	200	400
1" or greater	200	60 - 72°F	200	400
QT-Plus				
¾"	250	250	250	400
1" or greater	250	250	250	400