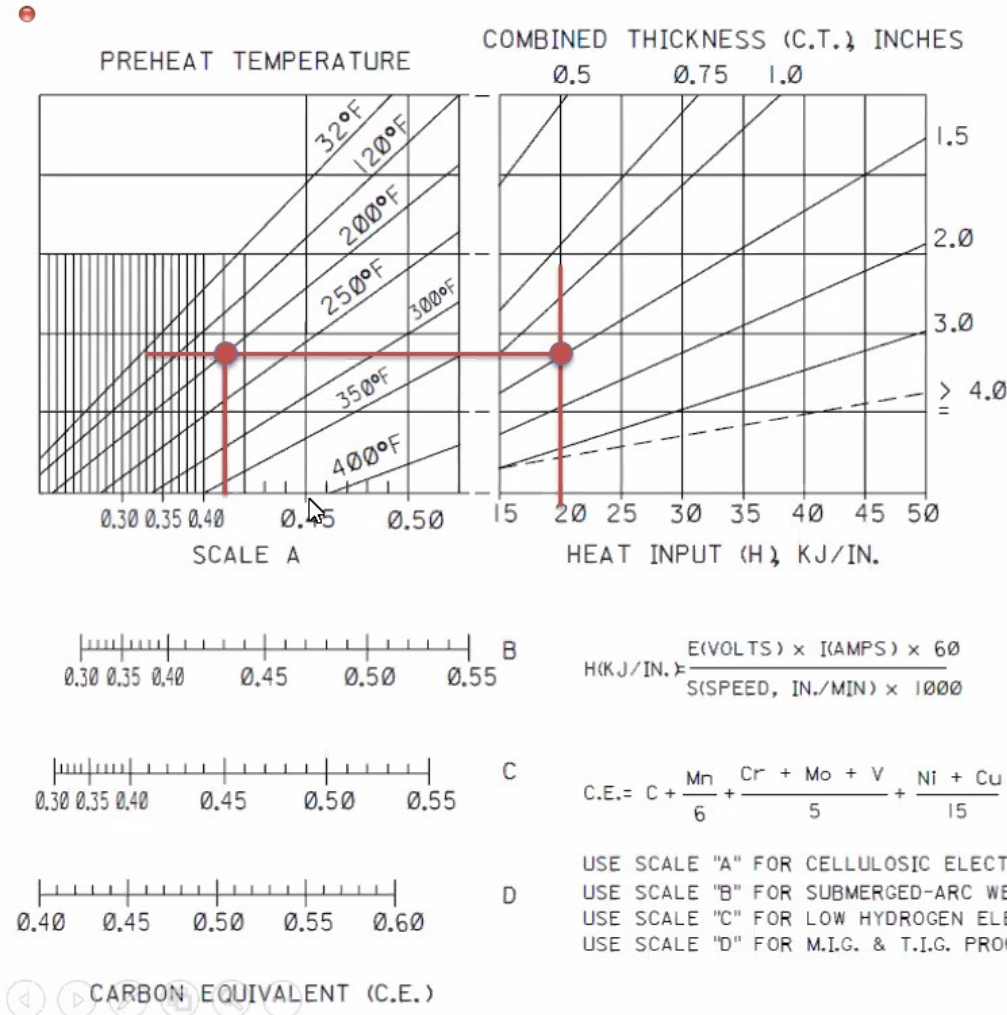




Case study : What is the preheat temperature of 19 mm butt weld thickness having base metal C.E = 0.41?

Step 1 : Welding process : SMAW , E6010

Step 2 : Heat input : 20 KJ/inch

Step 3 : Combined thickness : $T1+T2+T3 = 19+19+0 = 38 \text{ mm (1.5 inch)}$

Step 5 : Draw vertical line in right side graph

Step 6 : Select the scale in left side graph

Step 7 : Draw vertical line left side graph at 0.41

Step 8 : Draw horizontal line and get the preheat temp.