

Application Guide

Alloy Steels	Preheat (Minimum)	Postheat (Maximum)
Water Hardening W1, W2	250°F	450°F*
Hot Work S1, S5, S7	300°F	500°F
Oil Hardening O1, L6	300°F	400°F
Air Hardening A2, A4	300°F	500°F
Air Hardening D2	700°F	900°F*
Hot Work H11, H12, H13	700°F	1,000°F*
High Speed M1, M2, M10	950°F	1,050°F*
AISI SAE 4130, 4140, 3140	400°F	450°F
P20 Mold Steel	450°F	550°F
AISI SAE 6150, 6145	550°F	650°F
AISI SAE 4340, L6, L7	850°F	900°F*
CR, Ni, Mo, Cast Steel 1% C	700°F	800°F*
400 Series Stainless Steel	400°F	500°F*
Preheat for Pure Copper	800°F	1,000°F*
Cast Iron Preheat and Postheat for Best Machinability	350°F	600°F*
CryoSpray™ Powder Applications	200°F	500°F*
Maximum Interpass Temperature for:		
12% Manganese Steel	-	600°F
Austenitic Stainless Steel	-	350°F
Cold Welding Cast Iron	-	200°F

**Indicates most popular temperature limits.*