



3040G



Acetylene

TIP NO.	Cutting Oxygen Hole Diameter MM	Thickness of Cutting MM	Cutting Speed MM/MIN	Acetylene Pressure MPA	Cutting Oxygen Pressure MPA	Cutting Oxygen Consumption (m ² /h)
1	0.60	5-10	700-500	>0.03	0.7-0.8	1.25
2	0.80	10-20	600-380	>0.03	0.7-0.8	2.23
3	1.25	20-40	500-350	>0.03	0.7-0.8	3.48
4	1.00	40-60	420-300	>0.03	0.7-0.8	5.44
5	1.50	60-100	320-200	>0.03	0.7-0.8	7.84
6	1.75	100-150	260-140	>0.04	0.7-0.8	10.68
7	2.00	150-180	180-130	>0.04	0.7-0.8	13.9



3051



Propane

TIP NO.	Cutting Oxygen Hole Diameter MM	Thickness of Cutting MM	Cutting Speed MM/MIN	Propane Pressure MPA	Cutting Oxygen Pressure MPA	Cutting Oxygen Consumption (m ² /h)
1	0.60	5-10	700-450	>0.03	0.5-0.6	0.99
2	0.80	10-20	550-340	>0.03	0.5-0.6	1.76
3	1.00	20-40	450-300	>0.03	0.5-0.6	2.75
4	1.25	40-60	380-250	>0.03	0.5-0.6	4.3
5	1.50	60-100	300-180	>0.03	0.5-0.6	6.19
6	1.75	100-150	200-130	>0.04	0.5-0.6	9.5

Cutting Conditions

Oxygen purity is above 99.5%
Carbon Rate of Steel Material <.45%
Cutting way: Vertical Cutting
Oxygen Pressure refers to cutting pressure before arriving at the cutting torch

TIP NO.	Cutting Oxygen Hole Diameter MM	Thickness of Cutting MM	Cutting Speed MM/MIN	GAS PRESSURE MPA		Cutting Oxygen Consumption (m ² /h)
				Oxygen	Propane	
00	0.8	5-10	600-450	0.2-0.3	>0.03	0.9-1.3
0	1	10-20	480-380	0.2-0.3	>0.03	1.3-1.8
1	1.20	20-30	400-320	0.25-0.35	>0.03	2.5-3
2	1.40	30-50	350-280	0.25-0.35	>0.03	3.0-4
3	1.60	50-70	300-240	0.3-0.4	>0.04	4.5-6
4	1.80	70-90	260-200	0.3-0.4	>0.04	5.5-7
5	2.00	90-120	210-170	0.4-0.6	>0.04	8.5-10.5
6	2.40	120-160	180-140	0.5-0.8	>0.05	12-15
7	2.80	160-200	150-110	0.6-0.9	>0.05	21-24.5
8	3.20	200-270	120-90	0.6-1.0	>0.05	26.5-32
9	3.60	270-350	90-60	0.7-1.1	>0.05	40-46
10	4.00	350-400	70-50	0.7-1.2	>0.05	49-58