

1-101 & 3-101 Styles

1-101 = Heavy Duty WH-315 Handle
3-101 = Medium Duty WH-100 Handle



metal thickness	tip size	cutting oxygen (PSIG)	preheat oxygen (PSIG)	acetylene (PSIG)	speed I.P.M.	kerf width
1/8"	000	20/25	3/5	3/5	28/32	.04
1/4"	00	20/25	3/5	3/5	27/30	.05
3/8"	0	20/30	3/5	3/5	24/28	.06
1/2"	0	30/35	3/6	3/5	20/24	.06
3/4"	1	30/35	4/7	3/5	17/21	.07
1"	2	35/40	4/9	3/6	15/19	.09
1-1/2"	2	40/45	4/12	3/7	13/17	.09
2"	3	40/45	5/14	4/9	12/15	.11
2-1/2"	3	45/50	5/16	4/10	10/13	.11
3"	4	40/50	6/17	5/10	9/12	.12
4"	5	45/55	7/18	5/12	8/11	.15
5"	5	50/55	7/20	5/13	7/9	.15
6"	6	45/55	10/22	7/13	6/8	.18
8"	6	45/55	10/25	7/14	5/6	.19
10"	7	45/55	15/30	10/15	4/5	.34
12"	8	45/55	20/35	10/15	3/5	.41

W & W-1 Styles

W = Heavy Duty WH-315 Handle
W-1 = Medium Duty WH-100 Handle



CAUTION

At no time should the withdrawal rate of an individual acetylene cylinder exceed 1/7 of the cylinder contents. If additional flow capacity is required, use an acetylene manifold system of sufficient size to supply the necessary volume.

MFA & MFA-1 Styles

MFA = Heavy Duty WH-315 Handle
MFA-1 = Medium Duty WH-100 Handle



Welding Nozzle Flow Data

metal thickness	tip size	drill size	oxygen pressure		acetylene pressure		acetylene usage	
			min.	max.	min.	max.	min.	max.
up to 1/32"	000	75 (.022)	3	5	3	5	1	2
1/16"-3/64"	00	70 (.028)	3	5	3	5	1 1/2	3
1/32"-5/64"	0	65 (.035)	3	5	3	5	2	4
3/64"-3/32"	1	60 (.040)	3	5	3	5	3	6
1/16"-1/8"	2	56 (.046)	3	5	3	5	5	10
1/8"-3/16"	3	53 (.060)	4	7	3	6	8	18
3/16"-1/4"	4	49 (.073)	5	10	4	7	10	25
1/4"-1/2"	5	43 (.089)	6	12	5	8	15	35
1/2"-3/4"	6	36 (.106)	7	14	6	9	25	45
3/4"-1 1/4"	7	30 (.128)	8	16	8	10	30	60
1 1/4"-2"	8	29 (.136)	10	19	9	12	35	75
2 1/2"-3"	10	27 (.144)	12	24	12	15	50	100
3 1/2"-4"	12*	25 (.149)	18	28	12	15	80	160

MFA Heating Nozzles

tip size	acetylene pressure range (PSIG)	oxygen pressure range (PSIG)	acetylene cubic feet per hour		oxygen cubic feet per hour		BTU per hour
			min.	max.	min.	max.	
4	6-10	8-12	6	20	7	22	**
6	8-12	10-15	14	40	15	44	**
10	12-15	30-40	40	100	44	110	See below**
12*	12-15	50-60	60	150	66	165	**
15*	12-15	50-60	90	200	99	244	**

*Use model HD310C torch and 3/8 hose.

**Approximately 1470 gross BTU per cubic foot.