

Performance table flame cutting
Block nozzles Acetylene
ZIN119 3/61



Material thickness mm	Nozzle	Pressures (bar)		Cutting speed mm / min	Consumption ltrs / h	
		Acetylene	Oxygen		Acetylene	Oxygen
3	A 3 - 10	0.2	1.0	710	370	1100
5			1.2	620	395	1150
8			1.4	530	425	1200
10			1.5	490	445	1250
10	A 10 - 30	0.4	1.5	525	445	1620
15			1.8	465	485	1720
20			2.0	410	525	1850
25			2.3	365	560	2000
30			2.5	320	600	2175
30	A 30 - 60	0.4	2.5	370	600	2800
40			2.9	315	650	3100
50			3.2	255	705	3320
60			3.5	220	750	3600
60	A 60 - 100	0.5	3.5	265	750	5125
70			3.8	235	790	5330
80			4.1	210	835	5600
90			4.3	190	865	4800
100			4.5	175	900	6000
100	A 100 - 200	0.5	4.5	220	900	9800
120			4.8	200	955	10200
140			5.1	185	1010	10600
160			5.4	170	1055	11000
180			5.7	160	1095	11350
200			6.0	150	1130	11750
200	A 200 - 300	0.5	6.0	175	1130	16500
220			6.3	170	1160	16900
240			6.6	160	1185	17300
260			6.9	150	1210	17740
280			7.2	145	1230	18150
300			7.5	140	1240	18540

The indicated values are approximate values and refer only to unalloyed steel up to 0.3 % C and if using oxygen with a purity of 99.5 % minimum.

The indicated cutting speeds refer to straight cuts with a rust-free surface. Cutting areas of a quality class I according to DIN 2310 will be obtained.

The indicated cutting speeds have to be reduced for shaping cuts with small radii by approx. 10 %, for angular cuts of 30° by approx. 25 %, for angular cuts of 45° by approx. 45 %.

Nozzle size and the appropriate adjusting values have to correspond to the effective cutting thickness.

The indicated pressures are overpressures in bar, each measured at the torch entry. In case of higher-powered machines pressure drops in the hose pipe have to be taken into account.