

Performance table flame cutting
Block nozzles Methane (natural gas)
ZIN452 11/95

CUTTING
WELDING
SINCE 1898



Material thickness mm	Nozzle	Heating nozzle HSD M	Pressures (bar)		Cutting speed mm / min	Consumption ltrs / h	
			Methane	Oxygen		Methane	Oxygen
3 - 10	M 3 - 10	3 - 100	0.2	1.0 - 1.5	700 - 500	800	1350
10 - 30	M 10 - 30		0.5	1.5 - 2.5	520 - 310	900	2275
30 - 60	M 30 - 60		0.5	2.5 - 3.5	340 - 200	900	3750
60 - 100	M 60 - 100		0.5	3.5 - 4.5	230 - 160	1100	6200
100 - 160	100 - 160	A and P and M 100 - 300	0.5	8.5 - 9.5	230 - 180	1600	10050 - 19000
160 - 230	160 - 230			6.5 - 8.5	170 - 140		
230 - 300	200 - 300			6.5 - 8.5	130 - 110		

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.