Performance table flame cutting
Block nozzles Propane
ZIN163 12/69

CUTTING WELDING SINCE 1898 ZINSER

Material thickness mm	Nozzle	Heating nozzle HSD / ZHD A and P	Pressures (bar)		Cutting speed mm / min	Consumption ltrs / h	
			Propane	Oxygen		Propane	Oxygen
3 - 10	P 3 - 10	3 - 100	0.1	1.0 - 1.5	700 - 500	130 - 160	1200 - 1350
10 - 30	P 10 - 30		0.2	1.5 - 2.5	520 - 310	180 - 220	1750 - 2275
30 - 60	P 30 - 60		0.2	2.5 - 3.5	340 - 200	240 - 280	2950 - 3750
60 - 100	P 60 - 100		0.2	3.5 - 4.5	230 - 160	290 - 330	5325 - 6200
100 - 160	P 100 - 160	A and P and M 100 - 300	0.5	8.5 - 9.5	230 - 180	400 - 600	10050 - 19000
160 - 230	P 160 - 230			6.5 - 8.5	170 - 140		
230 - 300	P 230 - 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.