

**Performance table flame cutting**  
**Gas-mixing nozzles „Hi Speed“ Acetylene / Oxygen**  
**ZIN417 1/87**

CUTTING  
WELDING  
SINCE 1898



Material-thickness mm	Nozzle		Pressures (bar)		Cutting speed mm / min	Kerf mm	Consumption ltrs / h	
	mm	No.	Acetylene	Oxygen			Acetylene	Oxygen
3	3 - 6	0	0.2	8.4	650	1.3	400	1980
6					600			
6	6 - 12	1	0.2	7.0	600	1.6	510	2800
9					575			
12					550			
12	12 - 25	2	0.2	7.7	500	1.9	510	3700
20					475			
25					450			
25	25 - 38	3	0.3	7.0	430	2.2	700	4850
30					415			
38					400			
38	38 - 65	4	0.3	7.7	370	2.7	700	6900
50					345			
65					320			
65	65 - 100	6	0.3	6.0	240	3.4	970	9300
80					210			
100					180			
100	100 - 150	8	0.3	8.8	240	3.4	970	12250
125					210			
150					180			
150	150 - 200	10	0.3	7.0	150	4.3	1050	16400
175					138			
200					125			

The indicated values are approximate values and only refer 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 and scales-free surface. Cutting areas of 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 %, angular cuts of 30°: by approx. 25 %, 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 on the torch entry. In case of higher-powered machines, pressure drops in the hose pipes have to be taken into account.