

Performance table flame cutting
Gas-mixing nozzles „Hi Speed“ Propane / Oxygen
ZIN419 3/88

CUTTING
WELDING
SINCE 1898



Material- thickness mm	Nozzle		Pressures (bar)		Cutting speed mm / min	Kerf mm	Consumption ltrs / h	
	mm	No.	Propane	Oxygen			Propane	Oxygen
3	3 - 6	0	0.5	7.5	600	1.3	290	2100
6					550			
6	6 - 12	1	0.5	5.8	570	1.6	290	2550
9					540			
12					520			
12	12 - 25	2	0,5	7.2	500	1.9	290	3570
20					450			
25					420			
25	25 - 38	3	0.5	7.4	430	2.2	430	5350
30					400			
38					380			
38	38 - 65	4	0.5	7.5	380	2.7	430	7050
50					340			
65					320			
65	65 - 100	6	0.5	6.4	270	3.4	430	9550
80					240			
100					210			
100	100 - 150	8	0.5	8.0	210	3.4	430	12850
125					200			
150					180			
150	150 - 200	10	0.4	7.2	150	4.3	630	18900
175					120			
200					100			

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.