

**Performance table flame cutting**  
**Ring nozzles Acetylene / Propane**  
**ZIN398 9/82**

CUTTING  
WELDING  
SINCE 1898



**Acetylene**

Material-Thickness mm	Nozzle	Bore size Cutting oxygen Ø in mm	Groove Heating flame in mm 12x	Oxygen Pressure bar	Consumption ltrs / h	
					Acetylene	Oxygen
3 - 10	SA 1	0.9	0.25	2.0 - 2.5	300	2000
10 - 30	SA 2	1.1	0.25	2.5 - 3.5	450	3400
30 - 60	SA 3	1.3	0.40	3.5 - 4.5	750	7100
60 - 100	SA 4	1.6	0.40	4.5 - 5.5	880	10000
100 - 200	SA 5	2.1	0.50	5.5 - 6.5	1140	17500
200 - 300	SA 6	2.5	0.50	7.0 - 8.5	1270	23000

**Propane**

Material-Thickness mm	Nozzle	Bore size Cutting oxygen Ø in mm	Groove Heating flame in mm 12x	Oxygen Pressure bar	Consumption ltrs / h	
					Propane	Oxygen
3 - 10	SP 1	0.9	0.25	1.0 - 1.5	160	1350
10 - 30	SP 2	1.1	0.25	1.5 - 2.5	220	2270
30 - 60	SP 3	1.3	0.30	2.5 - 3.5	280	3750
60 - 100	SP 4	1.6	0.40	3.5 - 4.5	330	6200
100 - 200	SP 5	2.1	0.50	4.5 - 6.0	450	12000
200 - 300	SP 6	2.5	0.50	6.0 - 7.5	550	18850

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.

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.