

## Performance table flame cutting

### ZHD-R Mapp / Tetrene - Heavy-duty ring nozzles

#### ZIN450 6/95

CUTTING  
WELDING  
SINCE 1898



Material-thickness mm	Cutting nozzle ZHD-R P and Y	Heating nozzle ZHD-R Y	Pressures (bar)			Cutting speed mm / min	Nozzle distance mm	Kerf mm	Consumption ltrs / h					
			Mapp / Tetrene	Heating oxygen	Cutting oxygen				Mapp / Tetrene	Heating oxygen	Cutting oxygen			
3	3 - 6	3 - 100	0.1	1.0	1.5	760	3 - 5	0.9	300	750	500			
5					2.0	730								
6					2.5	710								
6	6 - 10				4.0	700								
8					4.5	680								
10					5.0	650								
10	10 - 20		0.3	1.5	6.5	660	4 - 8	1.8	350	900	3300			
15					7.5	570								
20					8.5	530								
20	20 - 30				8.0	540								
25					8.5	510								
30					9.0	440								
30	30 - 45	0.4	2.0	8.5	440	5 - 10	2.3	350	900	4200				
35				9.0	420									
40				9.0	400									
45				9.5	380									
45	45 - 60			8.0	380									
50				8.5	360									
55				8.5	350									
60				9.0	330									
60	60 - 80			8.5	330									
70				8.5	320									
80				9.0	300									
80				80 - 100	8.5		290							
90	8.5	270												
100	9.0	260												
100	P a. Y a. M	0.5	3.0		8.5	235	8 - 12	4.0	600	1900	16300			
120				9.0	220									
140				9.0	215									
160				9.5	190									
160	160 - 230			100 - 300	3.5	8.5	190	10 - 15	5.0	600	2650	22000		
180						7.0	180							
200						7.5	165							
230						8.5	150							
230	230 - 300					4.0	4.0						6.5	140
250													7.0	130
280				7.5	120									
300				8.5	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 on the torch entry. In case of higher-powered machines, pressure drops in the hose pipes have to be taken into account.