

Performance table flame cutting
ZHD-R Propane - Heavy-duty ring nozzles
ZIN449 6/95

CUTTING
WELDING
SINCE 1898



Material- thickness mm	Cutting nozzle ZHD-R P and Y	Heating nozzle ZHD-R A and P	Pressures (bar)			Cutting speed mm / min	Nozzle distance mm	Kerf mm	Consumption ltrs / h								
			Propane	Heating oxygen	Cutting oxygen				Propane	Heating oxygen	Cutting oxygen						
3	3 - 6	3 - 100	0.1	1.0	1.0	730	3 - 5	0.9	300	870	500						
5					1.5	700											
6					2.5	680											
6	6 - 10				5.0	670											
8					6.0	650											
10					7.0	610											
10	10 - 20		0.2	2.0	7.0	600	4 - 8	1.8	350	1300	3200						
15					7.5	530											
20					8.5	470											
20	20 - 30				7.5	490											
25					8.5	460											
30					9.0	410											
30	30 - 45	0.2	2.0	8.0	420	5 - 10	2.3	350	1300	4900							
35				8.5	400												
40				8.5	380												
45	9.0			360													
45	45 - 60			8.0	360												
50				8.5	340												
55				8.5	330												
60	60 - 80			9.0	310												
60				8.0	310												
70				8.5	300												
80	80 - 100			9.0	280												
80				8.0	280												
90		8.5	260														
100	P a. Y a. M	A a. P a. M 100 - 300	0.5	3.0	8.5	230	8 - 12	4.0	600	2250	14000						
120					9.0	210											
140					9.0	190											
160					9.5	180											
160	160 - 230		0.5	3.5	6.5	170	10 - 15	5.0	600	2250	19000						
180					7.0	160											
200					7.5	150											
230					8.5	140											
230	230 - 300				0.5	4.0						6.5	130	6.0	600	2250	27000
250												7.0	120				
280												7.5	110				
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.