

Performance table flame cutting ZHD Propane - Heavy-duty nozzles ZIN440 5/92

CUTTING
WELDING
SINCE 1898



Material- thickness mm	Cutting nozzle ZHD P and Y	Heating nozzle ZHD 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	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	7.5				490	5 - 10						2.3	350	1300	4900			
25	8.5	460																
30	9.0	410																
30	8.0	420																
35	30 - 45	0.2	2.0	8.5	400	5 - 10	2.4	350	1300	5300								
40				8.5	380													
45				9.0	360													
45				8.0	360													
50	8.5			340														
55	8.5			330														
60	45 - 60	0.2	2.0	9.0	310	5 - 10	2.5	400	1500	6250								
60				8.0	310													
70				8.5	300													
80				9.0	280													
80	8.0			280	10 - 15						2.7	400	1500	10000				
90	8.5			260														
100	9.0	240																
100	8.5	230																
120	P a. Y a. M 100 - 160	A a. P a. M 100 - 300	0.5	3.0	9.0	210	8 - 12	4.0	600	2250	14000							
140					9.0	190												
160					9.5	180												
160					6.5	170												
180	160 - 230		0.5	3.5	7.0	160	10 - 15	5.0	600	2250	19000							
200					7.5	150												
230					8.5	140												
230					6.5	130												
250	230 - 300				0.5	4.0						7.0	120	10 - 15	6.0	600	2250	27000
280												7.5	110					
300		8.5	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.