

REDUCER REGULATION

REDUCER PRESSURE REGULATION ACCORDING TO TORCHES USED

WELDING HEATING TIPS

ACETYLENE

OX - AD VALUE	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	ACETYLENE	OXYGEN	ACETYLENE
25 lt/h	1,5	0,05	27,5	25
40 lt/h	1,5	0,05	48,4	40
80 lt/h	1,5	0,05	88	80
160 lt/h	2,5	0,05	176	160
225 lt/h	2,5	0,1	248	225
315 lt/h	2,5	0,1	346	315
500 lt/h	2,5	0,1	550	500
800 lt/h	2,5	0,1	880	800
1.250 lt/h	2,5	0,1	1.375	1.250
1.800 lt/h	3	0,2	1.980	1.800
2.500 lt/h	3	0,3	2.750	2.500
3.150 lt/h	3	0,4	3.265	3.150
4.000 lt/h	3	0,4	4.400	4.000
5.000 lt/h	4	0,5	5.500	5.000
6.500 lt/h	-	-	-	-
8.000 lt/h	-	-	-	-
10.000 lt/h	-	-	-	-

PROPANE

OX Prop. VALUE Met.	* PRESSURE (bar)		FLOW RATE (lt/h)		WELD THICKNESS mm
	OXYGEN	PROPANE	OXYGEN	PROPANE	
0PM	2,5	0,2	44	12,5	0,25
1PM	2,5	0,2	70	20	0,40
2PM	2,5	0,2	140	40	0,80
3PM	2,5	0,2	280	80	2,00
-	-	-	-	-	3,00
4PM	2,5	0,1	540	155	4,00
5PM	2,5	0,1	875	250	5,00
6PM	2,5	0,1	1.400	400	8,00
7PM	2,5	0,1	2.100	600	14,00
-	-	-	-	-	18,00
9PM	4,0	0,25	6.000	1.600	-
-	-	-	-	-	-
11PM	4,0	0,65	8.500	2.500	-
12PM	3,0	0,5	11.000	2.800	-
13PM	5,0	1,0	18.000	4.500	-
14PM	6,0	1,3	25.000	6.250	-
15PM	8,0	2,0	36.000	9.000	-

IC CUTTING TIPS

ACETYLENE

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	ACETYLENE	OXYGEN	ACETYLENE
10 mm	2,5	0,25	1.580	350
25 mm	3,0	0,25	3.550	500
50 mm	3,0	0,28	5.800	700
100 mm	3,5	0,30	10.400	800
200 mm	5,0	0,45	21.400	1.250
300 mm	6,0	0,5	31.600	1.400

PROPANE

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	PROPANE	OXYGEN	PROPANE
10 mm	2,5	0,12	2.400	300
25 mm	3,0	0,12	4.600	400
50 mm	3,0	0,15	6.800	450
100 mm	3,5	0,18	11.500	500
200 mm	5,0	0,18	22.400	600
300 mm	6,0	0,2	33.200	800

FLAMAL

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	TETRENE FLAMAL	OXYGEN	TETRENE FLAMAL
10 mm	2,5	0,12	1.350	330
25 mm	3,0	0,12	4.540	440
50 mm	3,0	0,15	6.750	500
100 mm	3,5	0,18	11.400	550
200 mm	5,0	0,18	22.300	660
300 mm	6,0	0,2	33.000	880

METHANE

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	METHANE	OXYGEN	METHANE
10 mm	2,5	0,25	2.470	750
25 mm	3,0	0,25	4.700	1.000
50 mm	3,0	0,28	6.900	1.150
100 mm	3,5	0,30	11.600	1.250
200 mm	5,0	0,45	22.500	1.500
300 mm	6,0	0,50	33.400	2.000

(*) Pressures measured at the torch

Note: Offset pressure drops due to the diameter/length of the hose, connectors and hose accessories by appropriately increasing the reducer outlet pressure.

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H1F CUTTING TIPS

ACETYLENE

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	ACETYLENE	OXYGEN	ACETYLENE
10 mm	2,5	0,35	1.470	250
25 mm	3,0	0,35	3.550	500
50 mm	3,0	0,4	5.720	650
75 mm	3,5	0,4	8.830	750
100 mm	3,5	0,45	11.400	800
150 mm	4,0	0,5	17.100	950

PROPANE

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	PROPANE	OXYGEN	PROPANE
10 mm	2,5	0,2	2.400	280
25 mm	3,0	0,2	4.600	300
50 mm	3,0	0,3	6.800	400
100 mm	3,5	0,3	9.900	470
200 mm	3,5	0,4	12.600	530
300 mm	4,0	0,4	18.400	600

FLAMAL

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	TETRENE FLAMAL	OXYGEN	TETRENE FLAMAL
10 mm	2,5	0,2	2.100	300
25 mm	3,0	0,2	4.150	330
50 mm	3,0	0,3	6.350	450
75 mm	3,5	0,3	9.500	500
100 mm	3,5	0,4	12.200	550
150 mm	4,0	0,4	18.000	650

METHANE

CUTTING THICKNESS	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	METHANE	OXYGEN	METHANE
10 mm	2,5	0,35	2.400	700
25 mm	3,0	0,35	4.300	750
50 mm	3,0	0,4	6.700	1.000
75 mm	3,5	0,4	10.000	1.200
100 mm	3,5	0,45	12.800	1.350
150 mm	4,0	0,5	18.600	1.500

G2 CUTTING TIPS

Thickness	* PRESSURE (bar)		FLOW RATE (lt/h)	
	OXYGEN	PROPANE	OXYGEN	PROPANE
400 - 500	6 ÷ 9	0,9	54.000 ÷ 77.000	2.600
550 - 700	7 ÷ 9	0,9	74.000 ÷ 89.000	3.600
700 - 900	6 ÷ 7,5	0,9	80.000 ÷ 95.000	3.900

(*) Pressures measured at the torch

Note: Offset pressure drops due to the diameter/length of the hose, connectors and hose accessories by appropriately increasing the reducer outlet pressure.