



ACETYLENE CUTTING TIPS

Cutting Tip Series 172C & 173C

For use with **Oxy-Acetylene**

Tip Size	Metal Thickness	Cutting Speed (IN/MIN)	Cutting Oxygen (PSIG)	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)	Pre-Heat Oxygen (SCFH)	Acetylene Gas (PSIG)	Acetylene Gas (SCFH)
000	1/8"	28 / 32	20 / 25	20 / 25	3/5	3 / 5	3 / 5	3 / 5
00	1/4"	27 / 30	20 / 25	30 / 35	3/5	4 / 6	3 / 5	4 / 6
0	3/8"	24 / 28	25 / 30	55 / 60	3/5	5 / 9	3 / 5	5 / 8
0	1/2"	20 / 24	30 / 35	60 / 65	3/6	7 / 11	3 / 5	6 / 10
1	3/4"	17 / 21	30 / 35	80 / 8	4/7	9 / 14	3 / 5	8 / 10
2	1"	15 / 19	35 / 40	140 / 15	4/9	11 / 18	3 / 6	10 / 16
2	1-1/2"	13 / 17	40 / 45	150 / 16	4/12	13 / 20	3 / 7	12 / 18
3	2"	12 / 15	40 / 45	210 / 225	5/14	15 / 24	4 / 9	14 / 22
3	2-1/2"	10 / 13	45 / 50	225 / 240	5/16	18 / 29	4 / 10	16 / 26
4	3"	9 / 12	40 / 50	270 / 320	6/17	20 / 33	5 / 10	18 / 30
5	4"	8 / 11	45 / 55	390 / 425	7/18	24 / 37	5 / 12	22 / 34
5	5"	7 / 9	50 / 55	425 / 450	7/20	29 / 41	5 / 13	26 / 38
6	6"	6 / 8	45 / 55	500 / 600	10/22	33 / 48	7 / 13	30 / 44
6	8"	5 / 6	45 / 55	500 / 600	10/25	37 / 55	7 / 14	34 / 50
7	10"	4 / 5	45 / 55	700 / 850	15/30	44 / 62	10 / 15	40 / 56
8	12"	3 / 5	45 / 55	900 / 1000	20/35	53 / 88	10 / 15	48 / 62

Pre-heat Oxygen Pressure settings are for 3-hose machine cutting torches only. With a 2-hose cutting torches, the preheat pressure is obtained through the cutting oxygen settings.

For best hand cutting torch results, use 163L and 3/8" hose when using tips size 6 or larger.

All pressures are measured at the regulator using 25" x 1/4" hose through tip size 5 and 25'x 3/8" hose for tip sizes 6 and larger. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

WELDING NOZZLE FLOW DATA

171W, 172W, 173W AND 173WRTE

For use with **Oxy-Acetylene**

Tip Size	Metal Thickness	Drill Size	Oxygen Gas (PSIG)	Acetylene Gas (PSIG)	Acetylene Gas (SCFH)
000	Up to 1/32"	75(.022)	3 / 5	3 / 5	1 / 2
00	1/16"-3/64"	70(.028)	3 / 5	3 / 5	1-1 / 2/3
0	1/32"-5/64	65(.035)	3 / 5	3 / 5	2 / 4
1	3/64"-3/32"	60(.040)	3 / 5	3 / 5	3 / 6
2	1/16"-1/8"	56(.046)	3 / 5	3 / 5	5 / 10
3	1/8"-3/16"	53(.060)	4 / 7	3 / 6	8 / 18
4	3/16"-1/4"	49(.073)	5 / 10	4 / 7	10 / 25
5	1/4"-1/2"	43(.089)	6 / 12	5 / 8	15 / 35
6	1/2"-3/4"	36(.106)	7 / 14	6 / 9	25 / 45

NOTE:

Approximately 1470 gross BTU per cubic foot

HEATING NOZZLE

171H/172H/173H

For use with **Oxy-Acetylene**

Tip Size	Oxygen Gas (PSIG)	Acetylene Fuel (PSIG)	Oxygen Gas (SCFH)	Acetylene Fuel (SCFH)
2	4/8	4/8	3/10	3/9
4	8 / 12	6 / 10	7/22	6 / 20
6	10 / 15	8 / 12	15/44	14 / 40
8	20 / 30	10 / 15	33/88	30 / 80
10	30 / 40	12 / 15	44/110	40 / 100
*12	50 / 60	12 / 15	66/165	60 / 150
*15	50 / 60	12 / 15	99/244	90 / 220

* For best results, use model 143 TLH-CV torch and 3/8" hose.

WARNING: At no time should the withdrawal rate of an individual acetylene cylinder exceed 1/7 of the cylinder contents per hour. If additional flow capacity is required, use an acetylene manifold system of sufficient size to supply the necessary volume.