








Acetylene

The information shown on this page shows Series 1 tip style, fuel gas usage and Victor equipment compatibility.

Series 1 Cutting Tips

Type		Fuel Gas
101		A
101 30°		A
101-L		A
108		A
112		A
118		A
Tip (Round)		
		A
Tip (Sides Cutaway)		

Cutting Torches

Handle	Cutting Attachment	Fuel Gas
315FC	CA 2460-90°	All
H 315FC	CA 2461-75°	All
	CA 2462-180°	All

Straight Torches

ST 2600FC	-	All
ST 1000FC	-	All
ST 900FC	-	All
*HC 1200C	-	All

Machine Torches

MT 200	-	A, LP
MT 300	-	A, LP

*Refer also to straight torch section.

Code For Fuel Gases

A Acetylene

LP Propane/Natural Gas

P Propylene







Tip packaging is color coded with reference to fuel gas usage.

Other special application tips available. Contact technical services.

Propylene

The information shown on this page shows Series 1 tip style, fuel gas usage and Victor equipment compatibility.

Series 1 Cutting Tips

Type		Fuel Gas
GPP		P
HPP		P
MTHP		P
303MP		P
BTMP		P
GTB		P

Cutting Torches

Handle	Cutting Attachment	Fuel Gas
315FC	CA 2460-90°	All
H 315FC	CA 2461-75°	All
	CA 2462-180°	All

Straight Torches

ST 2600FC	-	All
ST 1000FC	-	All
ST 900FC	-	All
*HC 1200C	-	All
*HC 1100C	-	Non-A

Machine Torches

MT 200	-	A, LP
MT 300	-	A, LP

*Refer also to straight torch section.

Code For Fuel Gases

A Acetylene

LP Propane/Natural Gas

P Propylene












Tip packaging is color coded with reference to fuel gas usage.

Other special application tips available. Contact technical services.

LP (Propane/Natural Gas)

The information shown on this page shows Series 1 tip style, fuel gas usage and Victor equipment compatibility.

Series 1 Cutting Tips

Type		Fuel Gas
200		LP
207		LP
218		LP
244		LP
MCN		LP
GPN		LP
MTHN		LP
HPN		LP
BTN		LP
CSN		LP
GTB		LP

Cutting Torches

Handle	Cutting Attachment	Fuel Gas
315FC	CA 2460-90°	All
H 315FC	CA 2461-75°	All
	CA 2462-180°	All

Straight Torches

ST 2600FC	-	All
ST 1000FC	-	All
ST 900FC	-	All
*HC 1200C	-	All
*HC 1100C	-	Non-A

Machine Torches

MT 200	-	A, LP
MT 300	-	A, LP

*Refer also to straight torch section.

Code For Fuel Gases

A Acetylene

LP Propane/Natural Gas

P Propylene

Tip packaging is color coded with reference to fuel gas usage.



Other special application tips available. Contact technical services.

Acetylene	Propylene	LP (Propane/Natural Gas)
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The information shown on this page shows Series 3 tip style, fuel gas usage and Victor equipment compatibility.

Series 3 Cutting Tips

Acetylene

Type		Fuel Gas
101		A
118	 Tip (Round)	A

Propylene

Type		Fuel Gas
GPP		P

LP/Natural Gas

Type		Fuel Gas
GPN		LP

Cutting Torches		
Handle	Cutting Attachment	Fuel Gas
Heavy Duty		
315FC	CA 2460-90°	All
Medium Duty		
100FC	CA 1350-90° CA 1351-75° CA 1352-180°	All
Light Duty		
J-40	CA 1260-90°	All
Straight Torches		
CST 800FC	-	All

Code For Fuel Gases

- A** Acetylene
- LP** Propane/Natural Gas
- P** Propylene

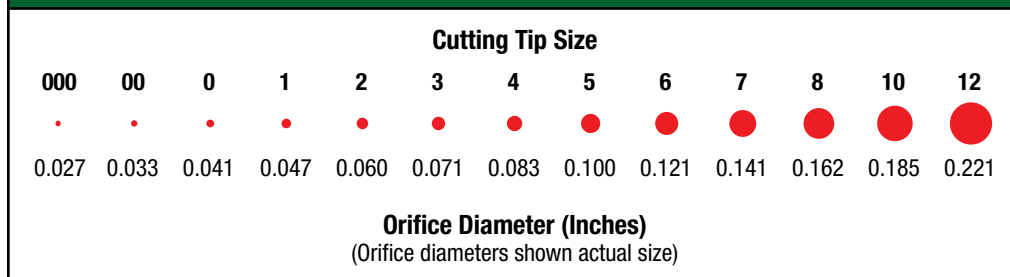
Tip packaging is color coded with reference to fuel gas usage.
Other special application tips available. Contact technical services.

Cutting Tip Preheat Reference Chart

Tip Size	*Cutting Oxygen Orifice Size	Preheat Sizes for Various Tips											
		100	101	1-104	108	110	111	112	129	200	116	117	118
000	71 (0.027")		74(0.023)										
00	67 (0.033")		74(0.023)			65(0.035)		67(0.032)					
0	60 (0.041")	71(0.027)	74(0.023)		75(0.022)	60(0.040)		60(0.040)		67(0.032)			71(0.027)
1	56 (0.047")	67(0.032)	71(0.027)		73(0.024)	56(0.046)	64(0.036)	56(0.047)		64(0.036)			
2	53 (0.060")	60(0.040)	67(0.032)		66(0.033)	54(0.055)		53(0.060)	57 (0.043)	62(0.038)	66(0.033)		63(0.037)
3	50 (0.071")		66(0.034)		63(0.037)	53(0.060)	56(0.046)	52(0.055)		60(0.040)	64(0.036)		
4	45 (0.083")		66(0.034)		60(0.040)			52(0.055)	55(0.052)	56(0.046)	61(0.039)		56(0.048)
5	39 (0.100")		66(0.034)				53(0.060)			55(0.053)			
6	31 (0.121")		63(0.037)							54(0.055)			57(0.044)
7	28 (0.141")		63(0.037)										
8	20 (0.162")		63(0.037)									63(0.037)	57(0.044)
10	13 (0.188")			55(0.052)									57(0.044)
12	2 (0.221")			55(0.052)									56(0.048)

Cutting Orifice Reference Chart

For all standard cutting tips except Series MTH high speed models



Gouging Depth Tip Chart

Approximate Gouge Depth

Depth of gouge will vary due to angle of tip and cutting pressure.

Tip Size	Depth of Gouge	Oz. PSI	C ₂ H ₂ PSI
Tip Size 118			
0	1/8"-1/4"	30-45	5-7
2	1/4"-3/8"	30-45	5-7
8	1/4"-1/2"	30-55	6-8
Tip Size 218			
4	1/4"-3/4"	30-65	8-10
6	3/8"-1"	30-65	10-12

Types: 101, 108, 112 (Oxy-Acetylene)									
Metal Thickness	Tip Size	Cutting Oxygen *** (PSIG)	Cutting Oxygen (SCGH)	Preheat Oxygen * (PSIG)	Preheat Oxygen (SCFH)	Acetylene (PSIG)	Acetylene **** (SCFH)	Speed I.P.M.	Kerf Width
1/8"	000	20/25	20/25	3/5	3/5	3/5	3/5	28/32	0.04
1/4"	00	20/25	30/35	3/5	4/6	4/6	4/6	27/30	0.05
3/8"	0	25/30	55/60	3/5	5/9	5/8	5/8	24/28	0.06
1/2"	0	30/35	60/65	3/6	7/11	6/10	6/10	20/24	0.06
3/4"	1	30/35	80/85	4/7	9/14	8/13	8/13	17/21	0.07
1"	2	35/40	140/150	4/9	11/18	10/16	10/16	15/19	0.09
1.5"	2	40/45	150/160	4/12	13/20	12/18	12/18	13/17	0.09
2"	3	40/45	210/225	5/14	15/24	14/22	14/22	12/15	0.11
2.5"	3	45/50	225/240	5/16	18/29	16/26	16/26	10/13	0.11
3"	4	40/50	270/320	6/17	20/33	18/30	18/30	9/12	0.12
4"	5	45/55	390/425	7/18	24/37	22/34	22/34	8/11	0.15
5"	5	50/55	425/450	7/20	29/41	26/38	26/38	7/9	0.15
6"	**6	45/55	500/600	10/22	33/48	30/44	30/44	6/8	0.18
8"	**6	45/55	500/600	10/25	37/55	34/50	34/50	5/6	0.19
10"	**7	45/55	700/850	15/30	44/62	40/56	40/56	4/5	0.34
12"	**8	45/55	900/1000	20/35	53/68	48/62	48/62	3/5	0.41

Tip Series: LP, P - Torch Series MT 300									
Metal Thickness	Tip Size	Cutting Oxygen *** (PSIG)	Cutting Oxygen (SCGH)	Preheat Oxygen * (PSIG)	Preheat Oxygen (SCFH)	Fuel Gas (PSIG)	Fuel Gas **** (SCFH)	Speed I.P.M.	Kerf Width
1/4"	00	85/95	68/75	30/35	23/140	8 oz. +	12/65	23/30	0.05
3/8"	00	85/95	68/75	30/35	23/140	8 oz. +	12/65	22/29	0.05
1/2"	0	85/95	110/120	30/35	23/140	8 oz. +	12/65	20/28	0.06
3/4"	0	85/95	110/120	30/35	23/140	8 oz. +	12/65	18/26	0.06
1"	1	85/95	145/160	30/35	23/140	8 oz. +	12/65	17/24	0.07
1.25"	1	85/95	145/160	30/35	23/140	8 oz. +	12/65	16/20	0.07
1.5"	1	85/95	145/160	30/35	23/148	8 oz. +	12/65	12/16	0.07
2"	2	85/95	230/250	30/35	23/140	8 oz. +	12/65	11/15	0.09
2.5"	2	85/95	230/250	30/35	23/140	8 oz. +	12/65	10/13	0.09
3"	2	85/95	230/250	30/35	23/140	8 oz. +	12/65	9/11	0.09
4"	3	85/95	285/320	30/35	23/140	8 oz. +	12/65	7/10	0.11
5"	3	85/95	285/320	30/35	23/140	8 oz. +	12/65	6/8	0.11
6"	3	85/95	285/320	30/35	23/140	8 oz. +	12/65	5/7	0.11
7"	4	85/95	390/450	30/35	23/140	8 oz. +	12/65	5/6	0.14
8"	4	85/95	390/450	30/35	23/140	8 oz. +	12/65	4/6	0.14
9"	5	85/95	670/720	30/35	23/140	8 oz. +	12/65	4/5	0.18
10"	5	85/95	670/720	30/35	23/140	8 oz. +	12/65	3/5	0.18

Data compiled using mild steel as test material.

*Applicable for three hose machine torch only. With a two-hose cutting torch, preheat pressure is set by the cutting oxygen.


**For best results use ST2600FC series torches and 3/8" hose when using tip 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 size: 6 and larger.

****Oxygen consumption is 1.1 times the acetylene under neutral flame conditions.

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.

Cutting Tips

Types: 303MP, LP, P, 200, 244									
Metal Thickness	Tip Size	Cutting Oxygen ***(PSIG)	Cutting Oxygen (SCGH)	Preheat Oxygen *(PSIG)	Preheat Oxygen (SCFH)	Fuel Gas ***(PSIG)	Fuel Gas (SCFH)	Speed I.P.M.	Kerf Width
1/8"	000	20/25	12/14	See Below 	23/108	3/5	3/5	24/28	0.04
1/4"	00	20/25	22/26		23/108	3/5	3/5	21/25	0.05
3/8"	0	25/30	45/55		23/108	3/5	3/5	20/24	0.06
1/2"	0	30/35	50/55		23/108	3/5	3/5	18/22	0.06
3/4"	1	30/35	70/80		23/108	4/6	4/6	15/20	0.08
1"	2	35/40	115/125		23/108	4/8	4/8	14/18	0.09
1.5"	2	40/45	125/135		23/108	5/9	5/9	12/16	0.09
2"	3	40/50	150/175		23/108	5/9	5/9	10/14	0.10
2.5"	3	45/50	175/200		23/108	6/10	6/10	9/12	0.10
3"	4	45/50	210/250		23/108	8/12	8/12	8/11	0.12
4"	5	45/55	300/360		23/108	8/12	8/12	7/10	0.14
5"	5	50/55	330/360		23/108	8/12	8/12	6/9	0.14
6"	**6	45/55	400/500		23/153	10/15	10/15	5/7	0.17
8"	**6	55/65	450/500		23/153	10/15	10/15	4/6	0.18


Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200 MT 300	- 30/35 PSIG	8 oz. and UP 8 oz. and UP
ST2600FC	-	1PSIG and UP
ST900FC ST1000FC	-	5PSIG and UP

Data compiled using mild steel as test material.

*Applicable for three hose machine torch only. With a two-hose cutting torch, preheat pressure is set by the cutting oxygen.

**For best results use ST 2600FC series torches and 3/8" hose when using tip 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 size: 6 and larger.

Types: HPM, LP, HDMP, CSN									
Metal Thickness	Tip Size	Cutting Oxygen ***(PSIG)	Cutting Oxygen (SCGH)	Preheat Oxygen *(PSIG)	Preheat Oxygen *(SCFH)	Fuel Gas ***(PSIG)	Fuel Gas (SCFH)	Speed I.P.M.	Kerf Width
3/4"	1	30/35	70/80	See Below 	44/240	3/6	22/110	15/20	0.08
1"	2	35/40	115/125		44/240	3/6	22/110	14/18	0.09
1.5"	2	40/45	125/135		44/240	4/8	22/110	12/16	0.09
2"	3	40/45	150/175		44/240	4/8	22/110	10/14	0.10
2.5"	3	45/50	175/200		44/240	5/9	22/110	9/12	0.10
3"	4	40/50	210/250		44/240	6/9	22/110	8/11	0.12
4"	5	45/55	300/360		44/240	6/9	22/110	7/10	0.14
5"	5	50/55	330/360		44/240	6/10	22/110	6/9	0.14
6"	**6	45/55	400/500		44/240	6/10	22/110	5/7	0.17
8"	**6	55/65	450/500		44/240	8/12	22/110	4/6	0.18

Data compiled using mild steel as test material.

*Applicable for three hose machine torch only. With a two-hose cutting torch, preheat pressure is set by the cutting oxygen.

**For best results use ST2600FC series torches and 3/8" hose when using tip 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 size: 6 and larger.

Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200 MT 300	- 30/35 PSIG	8 oz. and UP 8 oz. and UP
ST 2600FC	-	1 PSIG and UP
ST 900FC ST 1000FC	-	5 PSIG and UP