

Victor Acetylene

Torch Tip Selection

A rule of thumb for selecting the cutting tip for cutting a particular bevel angle is:

- 15° bevel angle is 1 times the pipe wall thickness
- 30° bevel angle is 1.2 times the pipe wall thickness
- 37.5° bevel angle is 1.3 times the pipe wall thickness
- 45° angle is 1.4 times the pipe wall thickness

Metal Thickness	Tip Size	Cutting Oxygen		Pre-Heat Oxygen* PSIG	Acetylene		Speed IPM	Kerf Width
		Pressure*** PSIG	Flow*** SCFH		Pressure PSIG	Flow SCFH		
1/8"	000	20-25	20-25	3-5	3-5	6-11	20-30	.04
1/4"	00	20-25	30-35	3-5	3-5	6-11	20-28	.05
3/8"	0	25-30	55-60	3-5	3-5	6-11	18-26	.06
1/2"	0	30-35	60-65	3-6	3-5	9-16	16-22	.06
3/4"	1	30-35	80-85	4-7	3-5	8-13	15-20	.07
1"	2	35-40	140-160	4-8	3-6	10-18	13-18	.09
2"	3	40-45	210-240	5-10	4-8	14-24	10-12	.11
3"	4	40-50	280-320	5-10	5-11	18-28	10-12	.12
4"	5	45-55	390-450	6-12	6-13	22-30	6-9	.15
6"	6**	45-55	500-600	6-15	8-14	25-35	4-7	.15
10"	7**	45-55	700-850	6-20	10-15	25-35	3-5	.34
12"	8**	45-55	900-1050	7-25	10-15	25-35	3-4	.41



SAWYER MFG COMPANY

7799 S Regency Drive • Tulsa, OK 74131
P (918) 834-2550 • F (918) 834-0318