



**2 Seat Oxweld Type : Nozzle , Speed and Gas Data for Gas Cutting**

Plate Thickness mm	Nozzle size	Gas Pressure ( kg/cm <sup>2</sup> )		Gas Consumption ( m <sup>3</sup> /hr )			Speed (mm/min)	Kerf mm
		Oxygen	Acetylene	Acetylene	Preheat Oxygen	Cutting Oxygen		
5	1/32	2	0.2	0.4	0.5	0.9	660-550	1.5
5-10	3/64	2.0	0.2	0.4	0.5	1.9	550-490	2
10-20	1/16	2.5	0.2	0.4	0.5	4	490-450	2.5
20-50	1/16	3.0	0.2	0.5	0.6	4.3	450-360	3
50-75	1/16	3.5	0.2	0.5	0.6	4.9	360-280	4
75-100	5/64	4	0.25	0.6	0.7	7.2	280-200	4.2
100-150	5/64	4.5	0.3	0.6	0.7	10	200-150	4.5
150-200	7/64	4.5	0.35	0.7	0.9	20	150-100	5
200-250	1/8	5.0	0.4	0.9	1.1	25	100-80	6
250-300	5/32	5	0.4	0.9	1.1	30	80-60	7

1. The above table is only for guidance. Actual parameters may vary depending on number of factors such as plate's carbon contents, purity of oxygen, gas regulators, flash back arrestors orifice and spring pressures, type of fuel, welders experience etc.
2. The pressures are to be measured in dynamic conditions.