



Multi-Use

425

3. Decide thickness of metal and ... 4. Oxy-fuel cutting pressure

Standard Pressure- - Propane, Natural Gas - LG / Propyle

Metal Thickness Inches/mm	No	Cutting Oxygen Orifice	Cutting Oxygen PSI / Bar	Fuel Gas PSI / Bar	Cut Speed Inches-min. / mm-min.	Kerf Width Inches/mm
3/16 / 5	00	68	30-40 / 2.1-2.8	3-5 / 0.2-0.34	17-24 / 430-610	.05 / 1.3
5/8 / 16	0	60	35-45 / 2.4-3.1	3-6 / 0.2-0.4	16-22 / 405-560	.06 / 1.5
1 / 25	1	56	30-50 / 2.1-3.5	3-6 / 0.2-0.4	14-18 / 355-460	.08 / 2.0
2 / 51	2	53	40-50 / 2.8-3.5	4-8 / 0.3-0.55	12-16 / 305-405	.09 / 2.3
3 / 76	3	51	40-50 / 2.8-3.5	4-8 / 0.3-0.55	10-14 / 255-355	.10 / 2.5
4 / 102	4	45	45-65 / 3.1-4.5	5-10 / 0.34-0.7	8-12 / 230-305	.12 / 3.0
7 / 178	5	39	60-75 / 4.2-5.2	8-12 / 0.55-0.8	5-8 / 130-230	.15 / 3.8
10 / 254	6	31	60-90 / 4.2-6.3	9-15 / 0.6-1.0	3-5 / 80-127	.21 / 5.3
12 / 305	7	25	60-90 / 4.2-6.3	9-15 / 0.6-1.0	3-4 / 80-100	.24 / 6.1
14 / 356	8	20	60-90 / 4.2-6.3	9-15 / 0.6-1.0	2-3 / 50-80	.26 / 6.6

High Pressure - Propane, Natural Gas - LGHS / Propylene - LGPHS / MAPP Gas - LGMHS

Metal Thickness Inches/mm	No	Cutting Oxygen Orifice	Cutting Oxygen PSI / Bar	Fuel Gas PSI / Bar	Cut Speed Inches-min. / mm-min.	Kerf Width Inches/mm
3/16 / 5	00	72	50-100 / 3.5-7.0	2-5 / 0.1-0.34	23-29 / 580-735	.04 / 1.0
1/4 / 6	0	68	70-100 / 4.9-7.0	2-5 / 0.1-0.34	21-28 / 530-710	.05 / 1.3
3/8 / 10	1	65	80-100 / 5.6-7.0	3-5 / 0.2-0.34	19-26 / 480-660	.05 / 1.3
1/2 / 13	2	60	80-115 / 5.6-8.0	3-5 / 0.2-0.34	18-26 / 460-660	.05 / 1.3
3/4 / 19	3	56	80-115 / 5.6-8.0	3-6 / 0.2-0.4	16-24 / 410-610	.06 / 1.5
1 / 25	4	55	80-115 / 5.6-8.0	3-6 / 0.2-0.4	15-20 / 380-510	.06 / 1.5
2 / 51	5	54	80-115 / 5.6-8.0	3-6 / 0.2-0.4	12-16 / 305-405	.06 / 1.5
3 / 76	6	53	80-115 / 5.6-8.0	4-8 / 0.3-0.55	10-15 / 254-380	.07 / 1.8
4 / 102	7	52	80-115 / 5.6-8.0	4-8 / 0.3-0.55	9-12 / 230-305	.08 / 2.0
5 / 127	8	49	80-115 / 5.6-8.0	5-9 / 0.34-0.6	8-11 / 200-280	.09 / 2.3
7 / 178	10	44	80-115 / 5.6-8.0	6-10 / 0.4-0.7	8-10 / 200-255	.10 / 2.5
10 / 254	12	39	80-115 / 5.6-8.0	9-15 / 0.6-1.0	4-6 / 100-150	.17 / 4.3

High Speed Cutting W/Stainless Steel Inserts - Propane, Natural Gas - HSD7 / Propylene - PHSD7 / MAPP - MHSD7 / Acetylene - AHSD7

Metal Thickness Inches/mm	No	Cutting Oxygen Orifice	Cutting Oxygen PSI / Bar	Fuel Gas PSI / Bar	Cut Speed Inches-min. / mm-min.	Kerf Width Inches/mm
1/8 / 3	00	78	100 / 7.0	2-5 / 0.1-.034	31.5 / 800	.03 / 0.8
1/4 / 6	0	74	100 / 7.0	2-5 / 0.1-.034	29 / 735	.04 / 1.0
3/8 / 10	0	74	100 / 7.0	2-5 / 0.1-.034	27 / 685	.05 / 1.3
1/2 / 13	1	65	100 / 7.0	2-8 / 0.1-0.55	25 / 635	.05 / 1.3
3/4 / 19	2	57	100 / 7.0	3-5 / 0.2-0.34	22 / 560	.06 / 1.5
1 / 25	2	57	100 / 7.0	3-5 / 0.2-.034	20 / 510	.07 / 1.8
1-1/2 / 38	3	55	100 / 7.0	3-6 / 0.2-0.4	18 / 460	.08 / 2.0
2 / 51	4	53	100 / 7.0	3-6 / 0.2-0.4	16 / 405	.10 / 2.5
2-1/2 / 64	5	50	100 / 7.0	3-6 / 0.2-0.4	14 / 355	.11 / 2.8
3 / 76	5	50	100 / 7.0	3-6 / 0.2-0.4	12.5 / 320	.11 / 2.8
4 / 102	6	45	100 / 7.0	4-8 / 0.3-0.55	10 / 255	.13 / 3.3
5 / 127	6	45	100 / 7.0	4-8 / 0.3-0.55	9 / 230	.14 / 3.6
6 / 152	7	38	100 / 7.0	4-8 / 0.3-0.55	7 / 180	.14 / 3.6
8 / 230	7	38	100 / 7.0	4-8 / 0.3-0.55	5.5 / 140	.18 / 4.6
10 / 254	8	30	100 / 7.0	5-9 / 0.34-0.6	4 / 110	.20 / 5.1

LGPHSD7 = Propylene Style Shell
 LGMHSD7 = Mapp Style Shell
 LGHSD7 = Propane/Natural Gas Shell

**Pressures are approximate. You may have to vary pressure with feeds and speeds for optimum results.

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