



## ***TORCH TIP SELECTION***

### ***A RULE OF THUMB FOR SELECTING THE CUTTING TIP FOR CUTTING A PARTICULAR TORCH BEVEL ANGLE IS:***

- 15" BEVEL ANGLE IS 1 TIMES THE PIPE WALL THICKNESS.
- 30 DEGREE BEVEL ANGLE IS 1.2 TIMES THE PIPE WALL THICKNESS.
- 37 1/2 DEGREE BEVEL ANGLE IS 1.3 TIMES THE PIPE WALL THICKNESS.
- 45 DEGREE BEVEL ANGLE IS 1.4 TIMES THE PIPE WALL THICKNESS.

**VICTOR Acetylene Cutting Tip Chart**

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

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