Welding Nozzles
Additional Information & Flow Data

WELDING NOZZLE FLOW DATA

Metal Thickness IN	Metal Thickness MM	Tip Size	Drill Size	Oxygen (PSIG)	Acetylene (PSIG)	Acetylene (SCFH)
1/32"	.8	000	75 (.022)	3 / 5	3 / 5	1 / 2
3/64"	1.2	00	70 (.028)	3 / 5	3 / 5	1-1/2 / 3
5/64"	1.9	0	65 (.035)	3 / 5	3 / 5	2 / 4
3/32"	2.4	1	60 (.040)	3 / 5	3 / 5	3 / 6
1/8"	3.2	2	56 (.046)	3 / 5	3 / 5	5 / 10
3/16"	4.8	3	53 (.060)	4 / 7	3 / 6	8 / 18
1/4"	6.4	4	49 (.073)	5 / 10	4 / 7	10 / 25
1/2"	12.7	5	43 (.089)	6 / 12	5 / 8	15 / 35
3/4"	19.0	6	36 (.106)	7 / 14	6 / 9	25 / 45
1 1/4"	32.0	7	30 (.128)	8 / 16	8 / 10	30 / 60
2"	51.0	8	29 (.136)	10 / 19	9 / 12	35 / 75
3"	76.2	10	27 (.144)	12 / 24	12 / 15	50 / 100
4"	102.0	12*	25 (.149)	18 / 28	12 / 15	80 / 160

* Use HD 310 torch handle and 3/8" hose.

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.

Note: Oxygen consumption (SCFH) is 1.1 times the acetylene under neutral flame conditions.