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VICTOR STYLE ECONOMY 5 & 3 SERIES CUTTING TIPS

More Victor Style Tips

TIPS TO FIT "V" STYLE TORCHES SUCH AS: ACCU-FLAME, FIREPOWER, GENERIC, GENERICO, HI-LIGHT, PROWELD, UNIWELD, VICTOR, WESTERN & WELDIT

5 SERIES (old style J) Light Duty

Fits: UNIWELD CA-550 & VICTOR CA-1250

UNIT PRICE	Tip Style Part #	Available Tip Sizes	Application	Preheat / Illustration
ALL SIZES \$16.95 EA	*5-101	00 - 2	Acetylene - Oxygen General purpose cutting	 MEDIUM
ALL SIZES \$19.95 EA	*5-200	0, 1, 2	Propane - Oxygen General purpose cutting	 MEDIUM

* For complete part number place a dash and the tip size at the end of the Tip Style number; e.g., (Tip Style 5-101, Tip Size 00, Complete Part Number) 5-101 -00

3 SERIES Medium Duty

Fits:
ACCU-FLAME (WESTERN) CB-531
GENERIC (GENERICO, HI-LIGHT, PROWELD) 141C, 142C, 842C FIREPOWER CA-250
UNIWELD CA-250, 350, 3-780 & EC72740
VICTOR CA-1260, 1350, 2060 & CST-800, 1400

ACETYLENE VICTOR® STYLE SEAT ONE PIECE TIPS

UNIT PRICE	Tip Style Part #	Available Tip Sizes	Application	Preheat / Illustration
SIZES 000 - 4 \$15.95 EA 5 & 6 \$16.95 EA	*3-101	000 - 6	General purpose cutting	 MEDIUM
\$33.79 EA	*3-108	2	Short tip for removing boiler tubes and work in confined places	 MEDIUM
ALL SIZES \$34.57 EA	*3-110	0 - 2	Drag type for hand cutting and trimming clean plate	 LIGHT
ALL SIZES \$34.93 EA	*3-112	1 - 3	Two preheat holes for cutting close to bulkheads, rivet heads	 MEDIUM
\$29.00 EA	*3-118	2	Gouging, removing Welds, rivet washing, weld preparation	 MEDIUM

LIQUID AIR® FUEL GAS / MAPP®/PROPYLENE VICTOR® STYLE SEAT TWO PIECE TIPS

UNIT PRICE	Tip Style Part #	Available Tip Sizes	Application	Preheat / Illustration
ALL SIZES \$19.95 EA	*3-GPM	00 - 4	General Purpose Cutting	 MEDIUM

CUTTING TIPS – PERFORMANCE DATA

OXY / ACETYLENE

STYLE 100, 101, 108, 110, 111, 112, 116, 118, 129

Metal Thickness	Tip Size	Cut Oxy Drill Size	Cutting Oxygen		Acetylene		Speed I.P.M	KERF Width
			PSIG	SCFH	PSIG	SCFH		
1/8"	000	71	20/25	20/25	5	5	28/32	.04
1/4"	00	67	20/25	30/35	5	6	27/30	.05
3/8"	0	60	25/30	55/60	5	8	24/28	.06
1/2"	0	60	30/35	60/65	5	10	20/24	.06
3/4"	1	56	30/35	80/85	5	13	17/21	.07
1"	2	53	35/40	140/150	6	16	15/19	.09
1-1/2"	2	53	40/45	150/160	7	18	13/17	.09
2"	3	50	40/45	210/225	9	22	12/15	.11
2-1/2"	3	50	45/50	225/240	10	26	10/13	.11
3"	4	45	40/50	270/320	10	30	9/12	.12
4"	5	39	45/55	390/425	12	34	8/11	.15
5"	5	39	50/55	425/450	13	38	7/9	.15
6"	6	31	45/55	500/600	13	44	6/8	.18
8"	6	31	50/80	500/600	14	50	5/6	.19
10"	7	28	50/80	700/850	15	56	4/5	.34

LIQUID AIR® FUEL GAS/MAPP®/PROPYLENE/PROPANE/NATURAL GAS

STYLE GPP, GPN, GPM, MP, 200, 207, 212, 218, 234, 244, 312

Metal Thickness	Tip Size	Cut Oxy Drill Size	Cutting Oxygen		Fuel Gas		Speed I.P.M	KERF Width
			PSIG	SCFH	PSIG	SCFH		
1/8"	000	71	20/25	12/15	5	5/6	24/28	.04
1/4"	00	67	20/25	22/26	5	5/7	21/25	.05
3/8"	0	60	25/30	45/55	5	8/10	20/24	.06
1/2"	0	60	30/35	50/55	5	8/10	18/22	.06
3/4"	1	56	30/35	70/80	6	10/12	15/20	.08
1"	2	53	35/40	115/125	8	12/15	14/18	.09
1-1/2"	2	53	40/45	125/135	9	12/15	12/16	.09
2"	3	50	40/45	150/175	9	14/18	10/14	.10
2-1/2"	3	50	45/50	175/200	10	14/18	9/12	.11
3"	4	45	45/50	210/250	12	16/20	8/11	.12
4"	5	39	45/55	300/360	12	20/30	7/10	.15
5"	5	39	50/55	300/360	12	20/30	6/9	.15
6"	6	31	45/55	400/500	15	25/35	5/7	.17
8"	6	31	55/65	450/500	15	25/35	4/6	.18

Notes:

- All is approximate for estimating purposes only – it will vary due to materials, working conditions and operator's skill and experience.
- Pressures are for hose lengths to 25 ft., add 3 psig per 25 ft. of additional hose length.
- Torch oxygen consumption is 1.1 times acetylene with natural flame, about 2 times for natural gas and MAPP® and about 4 times for propane and propylene. Use oxy-acetylene for welding steel.
- Acetylene cylinder gas withdrawal should not exceed 1/7 of cylinder contents per hour. Do not allow gas cylinders (especially oxygen) to empty in use – this can cause unbalanced pressures and reverse flow of gases. An adequate cylinder or manifold system should be provided for large gas usage operations with 3/8" hose for large size tips.
- Approximate heat output in B.T.U./HR. Per cubic foot, acetylene 1470, propane 2498, MAPP® 2406, propylene 2371, natural gas 1000.

NATURAL GAS / PROPANE VICTOR® STYLE SEAT TWO PIECE TIPS

UNIT PRICE	Tip Style Part #	Available Tip Sizes	Application	Preheat / Illustration
ALL SIZES \$19.95 EA	*3-GPN	00 - 5	General Purpose Cutting	 MEDIUM

PROPYLENE VICTOR® STYLE SEAT TWO PIECE TIPS

UNIT PRICE	Tip Style Part #	Available Tip Sizes	Application	Preheat / Illustration
ALL SIZES \$19.95 EA	*3-GPP	000 - 4	General Purpose Cutting	 MEDIUM

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