

CUTTING TIPS TIP MIX - A STYLE

FITS UNIWELD "A" STYLE & AIRCO / CONCOA

* For complete part number place a dash and the tip size at the end of the Tip Style number; e.g., (Tip Style 124, Tip Size 00, Complete Part Number) 124-00

ACETYLENE AIRCO® STYLE SEAT ONE PIECE TIPS

* Tip Style Part No.	Price & Tip Sizes	Use with UNIWELD Torch Series	Application	Preheat / illustration
124	00 - 3 \$18.22 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	Cutting clean plate, hand and machine	 LIGHT
138	00 - 4 \$21.93 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	Cutting clean plate - close circle preheat pattern	 LIGHT
144	00 - 8 9 & 10 \$17.93 EA \$21.75 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	General purpose hand and machine cutting	 MEDIUM
164	00 - 8 9 & 10 \$21.22 EA \$24.29 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	General use Hand and machine cutting for rusted and painted surfaces	 MEDIUM
183	6, 8, 10, 12 \$63.36 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCH N/A	Grooving, flame machining, gouging and removing weld metal Tip bent 20°	 MEDIUM
185	6 & 8 10 \$57.15 EA \$63.36 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCH N/A	Gouging, removing weld metal, rivet washing, weld preparation	 MEDIUM

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

* Tip Style Part No.	Price & Tip Sizes**	Use with UNIWELD Torch Series	Application	Preheat / illustration
AFS	72, 68, 65, 60, 56, 54, 52, 49, 44, 38, 31 \$24.43 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	General purpose machine cutting - Fast even preheat pattern	 HEAVY
AFH	68, 65, 60, 56, 54, 52, 49, 44, 38 \$24.29 EA	CUTTING ATTACHMENTS N/A HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	High-speed machine cutting - special cutting oxygen orifice	 HEAVY

**TIP SIZE EQUIVALENCY TABLE

ASPI/AFS/AFH	72	68	65	60	56	54	52	49	44	38	31
STD. SIZE	-	00	-	0	1	2	3	4	5	6	8

LIQUID AIRS FUEL GAS / MAPP® / PROPYLENE AIRCO® STYLE SEAT ONE PIECE TIPS

* Tip Style Part No.	Price & Tip Sizes**	Use with UNIWELD Torch Series	Application	Preheat / illustration
ASP	72, 68, 65, 60, 56, 54, 52, 49, 44, 38, 31 \$22.29 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	General purpose hand cutting & preheat	 HEAVY

TIPS FOR UNIWELD CUTTING TORCHES AND ATTACHMENTS CAN ALSO BE USED FOR AIRCO/CONCOA EQUIPMENT.

UNIWELD #	TIP STYLE FOR *CAN BE USED ON*	AIRCO / CONCOA #
CA-98 (A)		5800 Series
370, 371		5700 Series
30 Series		9000 Series
50, 54 Series		9700 Series

ACETYLENE AIRCO® STYLE SEAT ONE PIECE TIPS

* Tip Style Part No.	Price & Tip Sizes	Use with UNIWELD Torch Series	Application	Preheat / illustration
195	1, 2, 3 \$65.08 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	Hand cutting rivet heads or machine cutting 45° bevels, Tip bent 45°, one flat side	 MEDIUM
45	0 - 4 \$32.08 EA	CUTTING ATTACHMENTS N/A HAND CUTTING TORCHES N/A MACHINE CUTTING TORCHES 64	One piece tip, Divergent bore, High speed for machine torches	 MEDIUM

NATURAL GAS / PROPANE AIRCO® STYLE SEAT TWO PIECE TIPS

* Tip Style Part No.	Price & Tip Sizes	Use with UNIWELD Torch Series	Application	Preheat / illustration
229	0 - 10 \$23.79 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	General purpose hand and machine cutting, scrap cutting	 HEAVY
263	00 - 3, 5, 7, 8, 10 \$23.43 EA	CUTTING ATTACHMENTS CA98, CA730, CA370, CA330 HAND CUTTING TORCHES 30, 50, 54 MACHINE CUTTING TORCHES 64	Fast starting tip used for general hand and machine cutting	 MEDIUM

CUTTING TIPS PERFORMANCE DATA

STYLE 124

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)	Acetylene (PSIG)	Cutting Oxygen SCFH	Speed IPM
1/8"	00	25-30	3	32	18-20
1/4"	0	25-30	3	51	17-18
3/8"	1	25-30	3	73	16-17
1/2"	1	35-40	3	89	13-15
3/4"	2	35-40	3	113	11-13
1"	2	45-50	3	141	10-12
1-1/2"	3	45-50	3	180	9-11

STYLE 138

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)	Acetylene (PSIG)	Cutting Oxygen SCFH	Speed IPM
1/4"	0	25-30	3	54	8-22
3/8"	1	25-30	3	75	8-21
1/2"	1	35-40	3	90	18-19
3/4"	2	35-40	3	130	14-16
1"	2	45-50	3	150	13-15
1-1/2"	3	45-50	3	180	11-14
2"	3	45-50	3	200	9-11
2-1/2"	4	45-50	3	260	8-10

STYLE 144

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)	Acetylene (PSIG)	Cutting Oxygen SCFH	Speed IPM
1/8"	00	25-30	2	30	21-24
1/4"	0	25-30	2	60	20-23
3/8"	1	25-30	3	85	18-21
1/2"	1	35-40	3	100	16-19
3/4"	2	35-40	3	130	14-17
1"	2	45-50	3	155	13-16
1-1/2"	3	45-50	3	190	1-14
2"	3	55-60	3	200	9-12
3"	5	55-60	4	310	7-10
4"	5	55-60	4	390	6-8
5"	5	55-60	5	460	5-7
6"	6	55-60	5	490	5-6
7"	6	60-65	5	550	4-5

STYLE 45

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)	Acetylene (PSIG)	Cutting Oxygen SCFH	Speed IPM
1/4"	0	115-120	3	70	24-28
3/8"	1	80-85	3	85	23-26
1/2"	1	95-100	3	100	18-22
3/4"	2	95-100	3	120	17-21
1"	2	105-110	3	130	16-20
1-1/2"	3	105-110	4	150	14-17
2"	4	105-100	4	230	11-15

NOTES:

All data 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. added. Torch oxygen consumption is 1.1 times acetylene with neutral 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. PSIG, pounds per square inch gauge; SCFH, std. cu. ft. per hr.

MAPP® / PROPYLENE

STYLE AFH, AFS	Metal Thickness	Tip Size	Cutting Oxygen (PSIG)	Fuel Gas (PSIG)	Cutting Oxygen SCFH	Speed IPM
	1/4"	68	70-75	2-4	66	20-25
	3/8"	68	75-80	2-4	70	20-22
	1/2"	62	75-80	3-5	115	22-24
	5/8"	62	80-85	3-5	120	19-22
	3/4"	56	80-85	3-5	160	19-22
	1"	56	80-85	3-5	170	17-20
	1-1/2"	54	80-85	4-7	230	16-19
	2"	52	80-85	4-7	340	15-16
	3"	49	85-90	5-9	480	13-15
	4"	49	90-95	5-9	500	12-14