

Acetylene

CUTTING TIP ORDERING INFORMATION

Description	Illustration	Series	Type	Size	Part Number
General Purpose hand & machine torch cutting.		Series 1	101	000	0330-0003
				00	0330-0004
				00	0387-0133CS
				0	0330-0012
				0	0387-0134CS
				1	0330-0005
				1	0387-0135CS
				2	0330-0006
				2	0387-0136CS
				3	0330-0002
4	0330-0007				
5	0330-0008				
6	0330-0009				
7	0330-0013				
8	0330-0014				

CS Clamshell Pkg.

SAMPLE TIP ORDERING INFORMATION

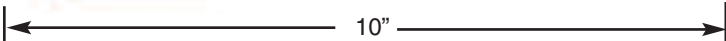
Size	Series	Type
000	1	101

General Purpose hand & machine torch cutting.		Series 3	101	000	0331-0002
				00	0331-0009
				00	0387-0144CS
				0	0331-0013
				0	0387-0145CS
				1	0331-0014
				1	0387-0146CS
				2	0331-0015
				2	0387-0147CS
				3	0331-0016
4	0331-0017				
5	0331-0018				

CS Clamshell Pkg.

General Purpose hand & cutting, machine cutting 30°, with torch perpendicular.		Series 1	101^{30°}	0	0330-0198
				1	0330-0199
				2	0330-0284

General Purpose extra length tips.		Series 1	101L	4	0330-0531
				6	0330-0535



See Section E pages 100-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 87.


Other Special Application Tips available. Contact Technical Services.


Acetylene

CUTTING TIP ORDERING INFORMATION

Description **Size** **Part Number**

Boiler tube removal. Tip is short to insert head & tip inside tube.





Series **1** Type **108**

Size	Part Number
0	0330-0058
1	0330-0059
2	0330-0063
3	0330-0064
4	0330-0065

SAMPLE TIP ORDERING INFORMATION

Size	Series	Type
0	1	108

Cutting close to bulk heads, hand cutting of rivet heads.







Series **1** Type **112**

Size	Part Number
2	0330-0086

Deseaming, scarfing, gouging, weld preparation, removing defective welds, washing rivets.

Tip (Round)







Series **1** Type **118**

Size	Part Number
0	0330-0109
2	0330-0113
4	0330-0114

Tip (Sides Cutaway)







Series **1** Type **118**

Size	Part Number
6	0330-0115
8	0330-0116

Tip (Round)





Series **3** Type **118**

Size	Part Number
2	0331-0035

See Section E pages 100-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 87.

Other Special Application Tips available. Contact Technical Services.

Cutting Tips • One Piece





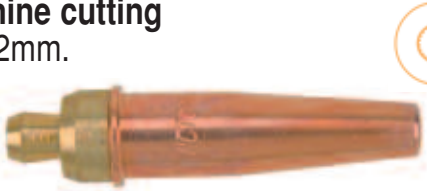

One & Two Piece Cutting Tips
Packaging Color Coded to Fuel Gas.

VICTOR®
Professional

Cutting Tips • One & Two Piece

Propylene

CUTTING TIP ORDERING INFORMATION

Description	Illustration	Series	Type	Size	Part Number		
General Purpose hand & machine torch cutting.		Series 1	GPP	00	0333-0261		
				0	0333-0262		
				0	0387-0154 CS		
				1	0333-0263		
				1	0387-0155 CS		
				2	0333-0264		
				2	0387-0156 CS		
				3	0333-0265		
				4	0333-0266		
				5	0333-0267		
				6	0333-0268		
				Series 3	GPP	000	0333-0260
						00	0333-0389
				0	0333-0390		
				0	0387-0164 CS		
				1	0333-0391		
				2	0333-0392		
				4	0333-0394		
		SAMPLE TIP ORDERING INFORMATION					
		Size	Series	Type			
		0	3	GPP			
Heavy preheat for scrap, bevel and other heavy preheat requirements.		Series 1	HPP	1	0333-0283		
				2	0333-0284		
				3	0333-0285		
				4	0333-0286		
				5	0333-0287		
				6	0333-0288		
				8	0333-0290		
				10	0333-0291		
				12	0333-0292		
		High speed machine cutting thru 10"/252mm.		Series 1	MTHP	00	0333-0352
						0	0333-0353
						1	0333-0354
						2	0333-0355
				3	0333-0356		
				4	0333-0357		
General Purpose hand & machine torch cutting.				Series 1	303MP	00	0330-0187
						0	0330-0188
						1	0330-0189
						2	0330-0193
						3	0330-0194
						4	0330-0195
						SAMPLE TIP ORDERING INFORMATION	
				Size	Series	Type	
				0	1	303MP	

See Section E pages 100-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 88.

Other Special Application Tips available. Contact Technical Services.







One & Two Piece Cutting Tips
 Packaging Color Coded to Fuel Gas.

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 Professional

Propylene

CUTTING TIP ORDERING INFORMATION

Description	Illustration	Series	Type	Size	Part Number
High performance bevel cutting for use with propylene gases.		 Series Series 1	Type BTMP	4	0333-0209
				5	0333-0210
				6	0333-0211
Gouging Tip (Bent) removal of welds		 Series Series 1	Type GTB	3	0330-0414
				4	0330-0415

Cutting Tips • One & Two Piece

See Section E pages 99-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 88.

Other Special Application Tips
 available. Contact Technical Services.

U.S. Customer Care: 800-426-1888 / FAX 800-535-0557
Canada Customer Care: 905-827-9777 / FAX 905-827-9797




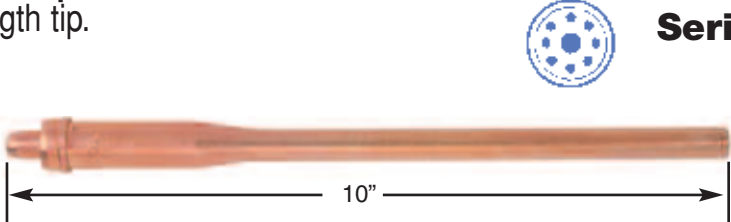

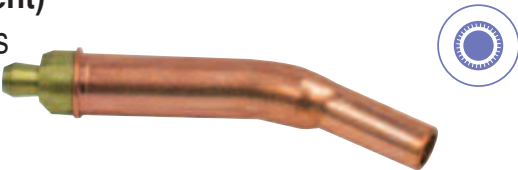

One & Two Piece Cutting Tips
 Packaging Color Coded to Fuel Gas.

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Cutting Tips • One & Two Piece

LP (Propane/Natural Gas)

CUTTING TIP ORDERING INFORMATION

Description	Illustration	Series	Type	Size	Part Number						
General Purpose hand & machine torch cutting.		Series	Type								
		Series 1	200	1	0330-0144						
				2	0330-0145						
SAMPLE TIP ORDERING INFORMATION											
<table border="1"> <thead> <tr> <th>Size</th> <th>Series</th> <th>Type</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>1</td> <td>200</td> </tr> </tbody> </table>						Size	Series	Type	1	1	200
Size	Series	Type									
1	1	200									
General Purpose extra length tip.		Series	Type								
		Series 1	200L	4	0330-0537						
Used for "blowing" rivets. Popular with various railroad applications.		Series	Type								
		Series 1	207	4	0330-0166						
Gouging Tip (Bent) removal of welds		Series	Type	3	0330-0414						
		Series 1	GTB	4	0330-0415						
Deseaming, scarfing, gouging, weld preparation, removing defective welds, washing rivets.		Series	Type	4	0330-0178						
		Series 1	218	6	0330-0179						

See Section E pages 100-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 89.

Other Special Application Tips available. Contact Technical Services.



LP (Propane/Natural Gas)

CUTTING TIP ORDERING INFORMATION


Description	Illustration	Series	Type	Size	Part Number
Cutting close to bulk heads, rivet cutting etc.		Series 1	244	2	0330-0344

SAMPLE TIP ORDERING INFORMATION

Size	Series	Type
2	1	244

Description	Illustration	Series	Type	Size	Part Number
For applications requiring extra heavy pre-heat and wide kerf.		Series 1	MCN	6	0330-0543

Example:
Demolition, ripping & RR car repair. 3/8"/9.75 mm hose required minimum 80 PSIG oxygen and 15 PSIG fuel at torch.

Description	Illustration	Series	Type	Size	Part Number
For extra heavy duty cutting torches, emergency billet cutting, caster cut-off, steelmill scrap cutting, foundry work and riser removal.		Series 1	HDNL	6, 8, 10, 12, 14	0330-0553, 0330-0554, 0330-0547, 0330-0548, 0330-0549

Description	Illustration	Series	Type	Size	Part Number
General Purpose hand & machine torch cutting.		Series 1	GPN	000, 00, 0, 0, 1, 1, 2, 2, 3, 4, 5, 6, 7, 8	0333-0300, 0333-0301, 0333-0302, 0387-0172 CS, 0333-0303, 0387-0173 CS, 0333-0304, 0387-0174 CS, 0333-0305, 0333-0306, 0333-0307, 0333-0308, 0333-0309, 0333-0310

CS Clamshell Pkg.

See Section E pages 100-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 89.

Other Special Application Tips available. Contact Technical Services.

Cutting Tips • One & Two Piece

Two Piece Cutting Tips
Packaging Color Coded to Fuel Gas.

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LP (Propane/Natural Gas)

CUTTING TIP ORDERING INFORMATION

Description	Illustration	Series	Type	Size	Part Number
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General Purpose
hand & machine torch cutting.



Series **3** Type **GPN**

SAMPLE TIP ORDERING INFORMATION

Size	Series	Type
00	3	GPN

- 00 0387-0182 CS
- 0 0333-0399
- 1 0333-0400
- 1 0387-0184 CS
- 2 0333-0401
- 2 0387-0185 CS
- 3 0333-0402
- 4 0333-0403

High speed machine cutting
thru 10"/252mm.



Series **1** Type **MTHN**

- 00 0333-0363
- 0 0333-0364
- 1 0333-0365
- 2 0333-0366
- 3 0333-0367
- 4 0333-0368
- 5 0333-0369
- 6 0333-0370

Heavy preheat for scrap, bevel and
other heavy preheat requirements.



Series **1** Type **HPN**

- 1 0333-0323
- 2 0333-0324
- 3 0333-0325
- 4 0333-0326
- 5 0333-0327
- 6 0333-0328
- 8 0333-0330
- 10 0333-0331
- 12 0333-0332

Heavy performance bevel cutting for
use with mild steel. HSLA, T1 & HV-80



Series **1** Type **BTN**

- 4 0333-0206
- 5 0333-0207
- 6 0333-0208

A coarse splined scrap cutting tip
for use with natural gas.



Series **1** Type **CSN**


- 8 0333-0411

See Section E pages 99-102 for Operational & Performance Data.
Tip/Apparatus Users Guide page 89.

Other Special Application Tips available. Contact Technical Services.

Acetylene

ORDERING INFORMATION

Description	Illustration	Series	Type	Size	Part Number
For pre-heating before welding, descaling and paint burning etc.		Series 1	MFTA	6	0330-0527
				8	0330-0528
				10*	0330-0523
				12*	0330-0524

Required pressures: 12/15 ACET.; 70/80 PSIG Oxy.
NOTE: Size 8 is maximum size for use with cutting attachments.

*Use 3/8"/9.75mm hose
Straight Torch

SAMPLE TIP ORDERING INFORMATION

Size	Series	Type
6	1	MFTA

See Section B, pages 50 for Operational & Performance Data.

LP (Propane/Natural Gas)

Description	Illustration	Series	Type	Size	Part Number
For pre-heating before welding, descaling and paint burning etc.		Series 1	MFTN	10*	0330-0521
				12*	0330-0522

NOTE: Not for use with cutting attachments.
NOTE: Operating pressures refer to page 121 Section J

*Use 3/8"/9.75mm hose

SAMPLE TIP ORDERING INFORMATION

Size	Series	Type
6	1	MFTN

See pages 50, Section B for Operational & Performance Data.

Other Special Application Tips available. Contact Technical Services.

Fire-Stick™
Torch Kit

- Two models available with or without regulator
- Available in a six pack point of purchase (P.O.P.) display pack or individually packaged
- For propane (Hose approved for LP)
- Two year limited warranty

ORDERING INFORMATION

Part Number	Model Number	Description	BTU,s
0384-1251	HS-101	Fire-Stick with R-LP Regulator	350,000 ea.
0384-1261	HT-500	Fire-Stick W/O Regulator (Heavy Duty)	500,000 ea.



Warranty: Refer to pages 138-139.

Tip Type: BTN for use with Natural Gas & Propane.
BTMP for use with Propylene Gases
(For use with MT 200, MT 300 Series
Machine Cutting Torches).

MT 200 Series					
Length of Bevel	Tip Size	Speed IPM	Oxygen Pressure	Fuel Pressure	Cutting Oxygen Pressure
1	4	10/18	60/75	8/10	N/A
1-1/2	4	8/16	60/75	8/10	N/A
2	4	6/14	60/75	8/10	N/A
2-1/2	4	5/12	60/75	8/10	N/A
3	5	6/11	60/75	8/12	N/A
3-1/2	5	5/10	60/75	8/12	N/A
4	5	4/9	60/75	8/12	N/A
4-1/2	5	4/8	60/75	8/12	N/A
5	6	3/8	65/85	8/15	N/A
5-1/2	6	3/7	65/85	8/15	N/A
6	6	3/6	65/85	8/15	N/A

MT300N Series					
Length of Bevel	Tip Size	Speed IPM	Oxygen Pressure	Fuel Pressure	Cutting Oxygen Pressure
1	4	10/18	35/65	10/12	40/60
1-1/2	4	8/16	35/65	10/12	40/60
2	4	6/14	35/65	10/12	40/60
2-1/2	4	5/12	35/65	10/12	40/60
3	5	6/11	35/65	10/12	40/65
3-1/2	5	5/10	35/65	10/12	40/65
4	5	4/9	35/65	10/12	40/65
4-1/2	5	4/8	35/65	10/12	40/65
5	6	3/8	35/65	10/12	45/75
5-1/2	6	3/7	35/65	10/12	45/75
6	6	3/6	35/65	10/12	45/75

Note: Bevels of 30° to 70° are possible on mild steel and most alloy steel without a preheat attachment.



WARNING: High gas withdrawal rates will require manifolding. Consult your gas supplier.

Cutting Tips Operational & Performance Data

VICTOR® Professional

Types: 100, 101, 104, 108, 110, 111, 112, 129 (Oxy- Acetylene)

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)***	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)*	Pre-Heat Oxygen (SCFH)	Acetylene (PSIG)	Acetylene (SCFH)****	Speed I.P.M.	Kerf Width
1/8"	000	20/25	20/25	3/5	3/5	3/5	3/5	28/32	.04
1/4"	00	20/25	30/35	3/5	4/6	3/5	4/6	27/30	.05
3/8"	0	25/30	55/60	3/5	5/9	3/5	5/8	24/28	.06
1/2"	0	30/35	60/65	3/6	7/11	3/5	6/10	20/24	.06
3/4"	1	30/35	80/85	4/7	9/14	3/5	8/13	17/21	.07
1"	2	35/40	140/150	4/9	11/18	3/6	10/16	15/19	.09
1-1/2"	2	40/45	150/160	4/12	13/20	3/7	12/18	13/17	.09
2"	3	40/45	210/225	5/14	15/24	4/9	14/22	12/15	.11
2-1/2"	3	45/50	225/240	5/16	18/29	4/10	16/26	10/13	.11
3"	4	40/50	270/320	6/17	20/33	5/10	18/30	9/12	.12
4"	5	45/55	390/425	7/18	24/37	5/12	22/34	8/11	.15
5"	5	50/55	425/450	7/20	29/41	5/13	26/38	7/9	.15
6"	6**	45/55	500/600	10/22	33/48	7/13	30/44	6/8	.18
8"	6**	45/55	500/600	10/25	37/55	7/14	34/50	5/6	.19
10"	7**	45/55	700/850	15/30	44/62	10/15	40/56	4/5	.34
12"	8**	45/55	900/1000	20/35	53/68	10/15	48/62	3/5	.41

Tip Series: MTHM, N, P - Torch Series MT 300

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)***	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)*	Pre-Heat Oxygen (SCFH)	Fuel Gas (PSIG)	Fuel Gas (SCFH)****	Speed I.P.M.	Kerf Width
1/4"	00	85/95	68/75	30/35	23/140	8 oz +	12/65	23/30	.05
3/8"	00	85/95	68/75	30/35	23/140	8 oz +	12/65	22/29	.05
1/2"	0	85/95	110/120	30/35	23/140	8 oz +	12/65	20/28	.06
3/4"	0	85/95	110/120	30/35	23/140	8 oz +	12/65	18/26	.06
1"	1	85/95	145/160	30/35	23/140	8 oz +	12/65	17/24	.07
1-1/4"	1	85/95	145/160	30/35	23/140	8 oz +	12/65	16/20	.07
1-1/2"	1	85/95	145/160	30/35	23/148	8 oz +	12/65	12/16	.07
2"	2	85/95	230/250	30/35	23/140	8 oz +	12/65	11/15	.09
2-1/2"	2	85/95	230/250	30/35	23/140	8 oz +	12/65	10/13	.09
3"	2	85/95	230/250	30/35	23/140	8 oz +	12/65	9/11	.09
4"	3	85/95	285/320	30/35	23/140	8 oz +	12/65	7/10	.11
5"	3	85/95	285/320	30/35	23/140	8 oz +	12/65	6/8	.11
6"	3	85/95	285/320	30/35	23/140	8 oz +	12/65	5/7	.11
7"	4	85/95	390/450	30/35	23/140	8 oz +	12/65	5/6	.14
8"	4	85/95	390/450	30/35	23/140	8 oz +	12/65	4/6	.14
9"	5	85/95	670/720	30/35	23/140	8 oz +	12/65	4/5	.18
10"	5	85/95	670/720	30/35	23/140	8 oz +	12/65	3/5	.18

Note: Data compiled using mild steel as test material.

* Applicable for three hose machine torch only. With a two-hose cutting torch, pre-heat pressure is set by the cutting oxygen.

** For best results use ST2600FC series torches and 3/8" hose when using tip sizes 6.

*** All pressures are measured at the regulator using 25' x 1/4" hose through tip size 5 and 25' x 3/8" hose for tip size 6 and larger.

**** Oxygen consumption is 1.1 times the acetylene under neutral flame conditions.



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: For larger size 101 tips refer to heavy industry Section J page 121.

Cutting Tips Operational & Performance Data

VICTOR® Professional

Cutting Tips • Operational & Performance Data

Types: 303MP, GPM, N, P, 312, 200, 212, 244

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)***	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)*	Pre-Heat Oxygen (SCFH)*	Fuel Gas (PSIG)***	Fuel Gas (SCFH)	Speed I.P.M.	Kerf Width
1/8"	000	20/25	12/14	See Below 	23/108	3/5	5/6	24/28	.04
1/4"	00	20/25	22/26		23/108	3/5	5/7	21/25	.05
3/8"	0	25/30	45/55		23/108	3/5	8/10	20/24	.06
1/2"	0	30/35	50/55		23/108	3/5	8/10	18/22	.06
3/4"	1	30/35	70/80		23/108	4/6	10/12	15/20	.08
1"	2	35/40	115/125		23/108	4/8	12/15	14/18	.09
1-1/2"	2	40/45	125/135		23/108	5/9	12/15	12/16	.09
2"	3	40/50	150/175		23/108	5/9	14/18	10/14	.10
2-1/2"	3	45/50	175/200		23/108	6/10	14/18	9/12	.10
3"	4	45/50	210/250		23/108	8/12	16/20	8/11	.12
4"	5	45/55	300/360		23/108	8/12	20/30	7/10	.14
5"	5	50/55	330/360		23/108	8/12	20/30	6/9	.14
6"	6**	45/55	400/500		23/153	10/15	25/35	5/7	.17
8"	6**	55/65	450/500		23/153	10/15	25/35	4/6	.18

Torch Series	Pre-heat Oxygen(PSIG)	Pre-heat Fuel (PSIG)
MT 200	N/A	8 oz. and UP
MT 300	30/35 PSIG	8 oz. and UP
ST2600FC	N/A	1PSIG UP
ST900FC	N/A	5PSIG UP
ST1000FC		

Note: Data compiled using mild steel as test material.

* Applicable for three hose machine torch only. With a two-hose Cutting torch, pre-heat pressure is set by the cutting oxygen.

** For best results use ST2600FC series torches and 3/8" hose when using tip sizes 6 or larger.

*** All pressures are measured at the regulator using 25' x 1/4" hose through tip size 5 and 25' x 3/8" hose for tip size 6 and larger.

Types: HPM, N, HDMP, CSN

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)***	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)*	Pre-Heat Oxygen (SCFH)*	Fuel Gas (PSIG)***	Fuel Gas (SCFH)	Speed I.P.M.	Kerf Width
3/4"	1	30/35	70/80	See Below 	44/240	3/6	22/110	15/20	.08
1"	2	35/40	115/125		44/240	3/6	22/110	14/18	.09
1-1/2"	2	40/45	125/135		44/240	4/8	22/110	12/16	.09
2"	3	40/45	150/175		44/240	4/8	22/110	10/14	.10
2-1/2"	3	45/50	175/200		44/240	5/9	22/110	9/12	.10
3"	4	40/50	210/250		44/240	6/9	22/110	8/11	.12
4"	5	45/55	300/360		44/240	6/9	22/110	7/10	.14
5"	5	50/55	330/360		44/240	6/10	22/110	6/9	.14
6"	6**	45/55	400/500		44/240	6/10	22/110	5/7	.17
8"	6**	55/65	450/500		44/240	8/12	22/110	4/6	.18

Note: Data compiled using mild steel as test material.

* Applicable for three hose machine torch only. With a two-hose Cutting torch, pre-heat pressure is set by the cutting oxygen.

** For best results use ST2600FC series torches and 3/8" hose when using tip sizes 6.

*** All pressures are measured at the regulator using 25' x 1/4" hose through tip size 5 and 25' x 3/8" hose for tip size 6 and larger.

Note: For larger size HPN tips refer to Heavy Industry Section J page 121.

Torch Series	Pre-heat Oxygen(PSIG)	Pre-heat Fuel (PSIG)
MT 200	N/A	8 oz. and UP
MT 300	30/35 PSIG	8 oz. and UP
ST2600FC	N/A	1PSIG UP
ST900FC	N/A	5PSIG UP
ST1000FC		

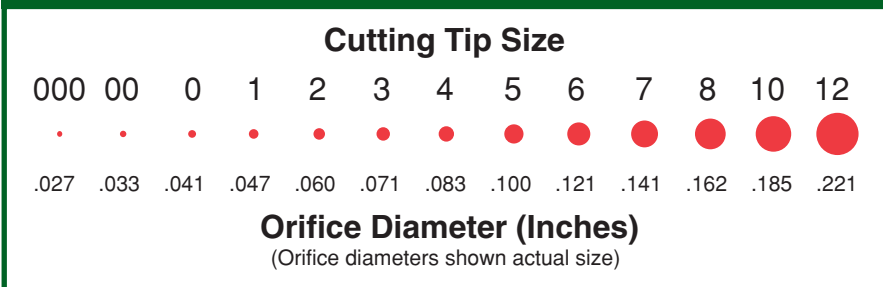


Cutting Tip Preheat Reference Chart

Tip Size	Cutting Oxygen Orifice Size*	Preheat Sizes for Various Tips											
		100	101	1-104	108	110	111	112	129	200	116	117	118
000	71 (.027")		74 (.023)										
00	67 (.033")		74 (.023)			65 (.035)		67 (.032)					
0	60 (.041")	71 (.027)	74 (.023)		75 (.022)	60 (.040)		60 (.040)		67 (.032)			71 (.027)
1	56 (.047")	67 (.032)	71 (.027)		73 (.024)	56 (.046)	64 (.036)	56 (.047)		64 (.036)			
2	53 (.060")	60 (.040)	67 (.032)		66 (.033)	54 (.055)		53 (.060)	57 (.043)	62 (.038)	66 (.033)		63 (.037)
3	50 (.071")		66 (.034)		63 (.037)	53 (.060)	56 (.046)	52 (.055)		60 (.040)	64 (.036)		
4	45 (.083")		66 (.034)		60 (.040)			52 (.055)	55 (.052)	56 (.046)	61 (.039)		56 (.048)
5	39 (.100")		66 (.034)				53 (.060)			55 (.053)			
6	31 (.121")		63 (.037)							54 (.055)			57 (.044)
7	28 (.141")		63 (.037)										
8	20 (.162")		63 (.037)									63 (.037)	57 (.044)
10	13 (.188")			55 (.052)									57 (.044)
12	2 (.221")			55 (.052)									56 (.048)

Cutting Orifice Reference Chart

For all standard cutting tips except Series MTH high speed models



Gouging Depth Tip Chart

Approximate Gouge Depth

Depth of gouge will vary due to angle of tip, and cutting pressure.

Tip Size	Depth of Gouge	Oz. PSI	C ₂ H ₂ PSI
Tip Size 118			
0	1/8" - 1/4"	30-45	5-7
2	1/4" - 3/8"	30-45	5-7
8	1/4" - 1/2"	30-55	6-8
Tip Size 218			
4	1/4" - 3/4"	30-65	8-10
6	3/8" - 1"	30-65	10-12

