

1-101 & 3-101 STYLES

1-101 = Heavy Duty WH-315 Handle
3-101 = Medium Duty WH-100 Handle

| Metal Thickness | Tip Size | Cutting Oxygen (PSIG) | Preheat Oxygen (PSIG) | Acetylene (PSIG) | Speed I.P.M. | Kerf Width |
|-----------------|----------|-----------------------|-----------------------|------------------|--------------|------------|
| 1/8" | 000 | 20/25 | 3/5 | 3/5 | 28/32 | .04 |
| 1/4" | 00 | 20/25 | 3/5 | 3/5 | 27/30 | .05 |
| 3/8" | 0 | 20/30 | 3/5 | 3/5 | 24/28 | .06 |
| 1/2" | 0 | 30/35 | 3/6 | 3/5 | 20/24 | .06 |
| 3/4" | 1 | 30/35 | 4/7 | 3/5 | 17/21 | .07 |
| 1" | 2 | 35/40 | 4/9 | 3/6 | 15/19 | .09 |
| 1-1/2" | 2 | 40/45 | 4/12 | 3/7 | 13/17 | .09 |
| 2" | 3 | 40/45 | 5/14 | 4/9 | 12/15 | .11 |
| 2-1/2" | 3 | 45/50 | 5/16 | 4/10 | 10/13 | .11 |
| 3" | 4 | 40/50 | 6/17 | 5/10 | 9/12 | .12 |
| 4" | 5 | 45/55 | 7/18 | 5/12 | 8/11 | .15 |
| 5" | 5 | 50/55 | 7/20 | 5/13 | 7/9 | .15 |
| 6" | 6 | 45/55 | 10/22 | 7/13 | 6/8 | .18 |
| 8" | 6 | 45/55 | 10/25 | 7/14 | 5/6 | .19 |
| 10" | 7 | 45/55 | 15/30 | 10/15 | 4/5 | .34 |
| 12" | 8 | 45/55 | 20/35 | 10/15 | 3/5 | .41 |



CAUTION: At no time should the withdrawal rate of an individual acetylene cylinder exceed 1/7 of the cylinder contents. If additional flow capacity is required, use an acetylene manifold system of sufficient size to supply the necessary volume.

W & W-1 STYLES

W = Heavy Duty WH-315 Handle
W-1 = Medium Duty WH-100 Handle

CAUTION: At no time should the withdrawal rate of an individual acetylene cylinder exceed 1/7 of the cylinder contents. If additional flow capacity is required, use an acetylene manifold system of sufficient size to supply the necessary volume.

Welding Nozzle Flow Data

| Metal Thickness | Tip Size | Drill Size | Oxygen Pressure | | Acetylene Pressure | | Acetylene Usage | |
|-----------------|----------|------------|-----------------|-----|--------------------|-----|-----------------|-----|
| | | | min | max | min | max | min | max |
| up to 1/32" | 000 | 75 (.022) | 3 | 5 | 3 | 5 | 1 | 2 |
| 1/16"-3/64" | 00 | 70 (.028) | 3 | 5 | 3 | 5 | 1 1/2 | 3 |
| 1/32"-5/64" | 0 | 65 (.035) | 3 | 5 | 3 | 5 | 2 | 4 |
| 3/64"-3/32" | 1 | 60 (.040) | 3 | 5 | 3 | 5 | 3 | 6 |
| 1/16"-1/8" | 2 | 56 (.046) | 3 | 5 | 3 | 5 | 5 | 10 |
| 1/8"-3/16" | 3 | 53 (.060) | 4 | 7 | 3 | 6 | 8 | 18 |
| 3/16"-1/4" | 4 | 49 (.073) | 5 | 10 | 4 | 7 | 10 | 25 |
| 1/4"-1/2" | 5 | 43 (.089) | 6 | 12 | 5 | 8 | 15 | 35 |
| 1/2"-3/4" | 6 | 36 (.106) | 7 | 14 | 6 | 9 | 25 | 45 |
| 3/4"-1 1/4" | 7 | 30 (.128) | 8 | 16 | 8 | 10 | 30 | 60 |
| 1 1/4"-2" | 8 | 29 (.136) | 10 | 19 | 9 | 12 | 35 | 75 |
| 2 1/2"-3" | 10 | 27 (.144) | 12 | 24 | 12 | 15 | 50 | 100 |
| 3 1/2"-4" | 12* | 25 (.149) | 18 | 28 | 12 | 15 | 80 | 160 |



MFA & MFA-1 STYLES

MFA = Heavy Duty WH-315 Handle
MFA-1 = Medium Duty WH-100 Handle

MFA Heating Nozzles

| Tip Size | Acetylene Pressure Range (PSIG) | Oxygen Pressure Range (PSIG) | Acetylene Cubic Feet Per Hour | | Oxygen Cubic Feet Per Hour | | BTU Per Hour |
|----------|---------------------------------|------------------------------|-------------------------------|-----|----------------------------|-----|--------------|
| | | | min | max | min | max | |
| 4 | 6-10 | 8-12 | 6 | 20 | 7 | 22 | ** |
| 6 | 8-12 | 10-15 | 14 | 40 | 15 | 44 | ** |
| 10 | 12-15 | 30-40 | 40 | 100 | 44 | 110 | See below** |
| 12* | 12-15 | 50-60 | 60 | 150 | 66 | 165 | ** |
| 15* | 12-15 | 50-60 | 90 | 200 | 99 | 244 | ** |



*Use model HD310C torch and 3/8 hose. **Approximately 1470 gross BTU per cubic foot.