

Victor Oxygen & Acetylene Cutting Pressure & Tip Chart

Note This Chart is 30+ years old

Metal Thickness	Victor Tip #	OXYGEN P.S.I.		Fuel P.S.I.	Consumption C.F. H.			Cutting Speed I.P.M.	Kerf Width	Drill Sizes	
		Cutting Pressure		Acetylene @ Regulator	Cutting Oxygen	Preheat Oxygen	Fuel Acetylene			Cutting	Preheat
		At @ Regulator	At @ Torch								
1/8"	000	20	20	3	18	7	6.5	28	.035	72	75
3/16"	00	20	20	3	24	7	6.5	26	.050	68	75
1/4"	0	30	30	4	40	7.5	7	22	.055	62	73
3/8"	0	35	35	4	50	7.5	7	20	.055	62	73
1/2"	1	35	35	4	75	11	9.5	19	.080	56	71
5/8"	1	40	40	4	85	11	9.5	17	.080	56	71
3/4"	2	35	35	4	105	12	10.5	16	.095	54	70
1"	2	41	40	4	115	12	10.5	14	.095	54	70
1 1/4"	2	51	50	4	135	12	10.5	13	.095	54	70
1 1/2"	3	42	40	5	170	14	12	12	.100	51	68
2"	3	47	45	5	180	14	12	10	.100	51	68
2 1/2"	4	38	35	5	240	15	13	9	.125	45	62
3"	4	44	40	5	265	15	13	8	.125	45	62
4"	4	54	50	5	315	16	14	7	.125	45	62
5"	5	56	50	6	420	29	25	7	.150	41	60
6"	5	67	60	6	485	2	25	6	.150	41	60
8"	5	78	70	6	550	30	26	5.5	.150	41	60
10"	6	83	70	6	750	32	28	5	.203	32	60
12"	6	125	90	6	975	32	28	4.5	.230	32	60
14"	7	100	82	7	1250	34	30	4	.250	28	56