

# Cutting Nozzles

## NOZZLE

- Hard drawn Tellurium copper used in one piece nozzles
  - withstands heat & wear
  - out lasts any copper nozzles
- One piece nozzle has swaged interior
  - Gas passages are mirror smooth with internal angles rounded
  - Non-turbulent more efficient gas flow.
  - Clean smooth cuts with minimal kerf loss
- Preheat ports are closely spaced around cutting orifice
  - For greater concentration of preheat flames.
- Long parallel preheat passages
  - Permit redressing of nozzle without affecting performance

### ANM (Acetylene) Nozzle for NM 250 / NM 400

NOZZLE (inch)	PLATE THICKNESS (mm)
1/32	6
3/64	12
1/16	25,50,75
5/64	100
3/32	150
1/8	200,250,300



### AGNM (Gouging) Nozzle for NM 400



NOZZLE width (mm)	Maximum Groove Width (mm)
13	8
19	11
25	12

### PNM (LPG) Nozzle for NM 250 / NM 400

NOZZLE (inch)	PLATE THICKNESS (mm)
1/32	6
3/64	12
1/16	25,50,75
5/64	100
3/32	150
1/8	250



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### A-Type (Acetylene) Nozzle for Cutogen 5

NOZZLE SIZE	PLATE THICKNESS (mm)
A8 (1/32")	6
A12 (3/64z")	12
A16 (1/16")	50,75,100
A20 (5/64")	150
A24 (3/32")	200
A28 (7/64")	250
A32 (1/8")	300



### P-Type (LPG) Nozzle for Cutogen 5



NOZZLE SIZE	PLATE THICKNESS (mm)
P8 (1/32")	6
P12 (3/64")	12
P16 (1/16")	25,50,75
P20 (5/64")	100
P24 (3/32")	150
P28 (7/64")	200
P32 (1/8")	250

### Operating Data for Mild Steel cutting with ESAB Cutting Blowpipe (Injector & Nozzle Mix type) comply with ISI & ISO Standards

Material Thickness		Nozzle size		Gas pressure Oxygen		Gas Pressure Fuel			
mm	inch			bar	psi	Acetyline		Propane	
						bar	psi	bar	psi
6.0	1/4"	1/32"	(3-6)	1.5	20	0.15	2.0	0.20	3.0
12.0	1/2"	3/64"	(5-12)	2.0	30	0.15	2.0	0.20	3.0
25.0	1"	1/16"	(10-75)	2.5	35	0.15	2.0	0.30	4.0
50.0	2"	1/16"	(10-75)	3.0	45	0.15	2.0	0.30	4.0
75.0	3"	1/16"	(10-75)	3.5	50	0.15	2.0	0.30	4.0
100.0	4"	5/64"	(70-100)	4.0	60	0.20	3.0	0.35	5.0
150.0	6"	3/32"	(90-150)	4.0	60	0.20	3.0	0.40	6.0
200.0	8"	7/64"	(140-200)	4.0	60	0.20	3.0	0.40	6.0
250.0	10"	1/8"	(190-250)	4.0	60	0.20	3.0	0.45	6.5
300.0	12"	1/8"	(250-300)	4.5	65	0.20	3.0	0.50	7.0