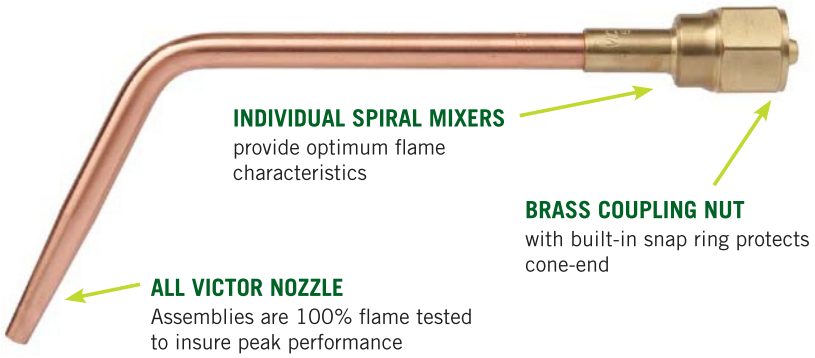
Welding & Heating Nozzles/Tips

GENERAL INFORMATION



INDIVIDUAL SPIRAL MIXERS
provide optimum flame characteristics

BRASS COUPLING NUT
with built-in snap ring protects cone-end

ALL VICTOR NOZZLE
Assemblies are 100% flame tested to insure peak performance

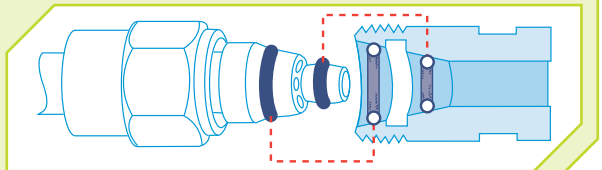
Exclusive "OPTIMIZED" nozzles with a large choice of types and sizes, plus uniformity of tip orifice and size for all series

VICTOR OFFERS A COMPLETE RANGE OF NOZZLES,
tips and elbows with a size for every application including: welding, brazing, heating, descaling, hard facing, flame priming, etc.

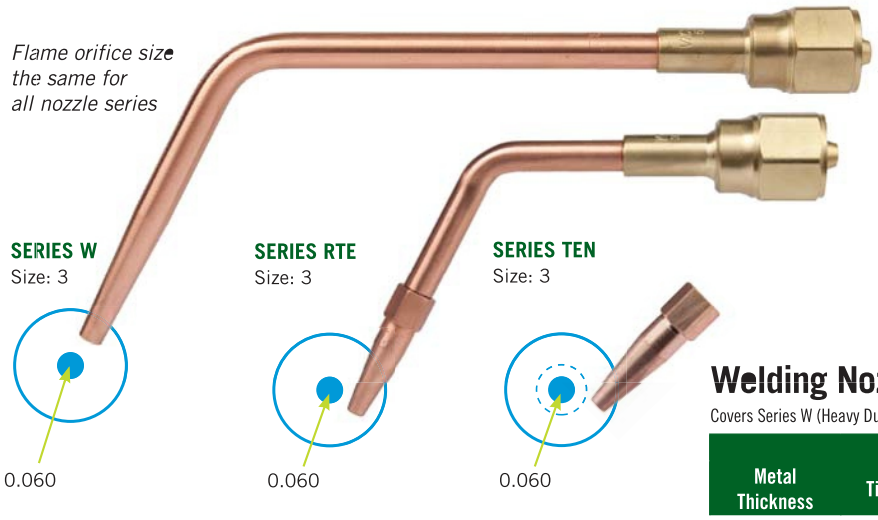
NOZZLES DESIGNED FOR "OPTIMUM" PERFORMANCE
Each complete nozzle has its own built-in spiral mixer, individually designed for each tip size and flame characteristic. Each nozzle is individually swaged to insure proper alignment for uniform flame, sizing and free-flow contour.

ORIFICE SIZES ARE COMMON FOR ALL SERIES
Regardless of nozzle series (W, W-1, W-J), flame characteristic or fuel gas used. The uniformity of orifice sizes simplifies nozzle selection, eliminates chances of ordering and wrong size when changing from one type of nozzle to another.

DOUBLE O-RING SEAL
Provides gas-tight connectionwithout wrench



Flame orifice size the same for all nozzle series



Heating Tip
Fuel Gas

A

Type

MFTA

Welding Nozzle Operational Data/Acetylene

Covers Series W (Heavy Duty), W-1 (Medium Duty) And W-J (Light Duty) Series

Operational & Performance Data					
Metal Thickness	Tip Size	Drill Size	Oxygen (psig)	Acetylene (psig)	Acetylene (Scfh)
1/32" (0.8 mm)	000	75 (0.022)	3/5	3/5	1/2
3/64" (1.2 mm)	00	70 (0.028)	3/5	3/5	1.5/3
5/64" (1.9 mm)	0	65 (0.035)	3/5	3/5	2/4
3/32" (2.4 mm)	1	60 (0.040)	3/5	3/5	3/6
1/8" (3.2 mm)	2	56 (0.046)	3/5	3/5	5/10
3/16" (4.8 mm)	3	53 (0.060)	4/7	3/6	8/18
1/4" (6.4 mm)	4	49 (0.073)	5/10	4/7	10/25
1/2" (12.7 mm)	5	43 (0.089)	6/12	5/8	15/35
3/4" (19.0 mm)	6	36 (0.106)	7/14	6/9	25/45
1 1/4" (32.0 mm)	7	30 (0.128)	8/16	8/10	30/60
2" (51.0 mm)	8	29 (0.136)	10/19	9/12	35/75
3" (76.2 mm)	10	27 (0.144)	12/24	12/15	50/100

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.

Oxygen consumption (SCFH) is 1.1 times the acetylene under neutral flame conditions.

Oxy-Acetylene & Oxy-Hydrogen				
Application	Torch Series	Nozzle Type	Available Sizes	Illustration
General purpose welding & heating. Uses replaceable tip ends. Flame characteristic – Long cone	315FC H 315FC	RTE	000-6, 8,10	65° Sizes: 000-6, 8 (Length 4.5") Size: 10 (Length 14")
General purpose welding and preheating. Swaged one-piece copper elbow. Flame characteristic – Long cone	315FC 100FC	W W-1	000-8, 10 000-7	65° Sizes: 000-8 (Length 4.5") Size: 10 (Length 14")
	J-28 J-40	W-J	000-4	

NOZZLES