

Natural Gas and Propane Tips



Heavy Shell Style 219 - 2 Piece

This precision made two-piece hand or machine cutting tip features excellent preheat flames and a cutting Oxygen stream or "Stinger" which is significantly better than with conventional cutting tips. Sizes 00 through 5 feature a 22° "V" spline design that provides maximum heat transfer and flame stability. Sizes 6, 7 and 8 employ a 36° "V" spline design to provide increased gas flows and extra secondary flame length required on thicker plate.

Part Number	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSIG	SCFH	PSIG	SCFH	PSIG	SCFH	
813 2189-00-1	1/4"	00	72 (.025)	35	65	2-4	18	2	8	20-24
813 2190-00-1	3/8"	0	68 (.031)	40-45	86-115	3-5	25	3	11	19-23
813 2191-00-1	1/2 - 5/8"	1	62 (.038)	45-55	115-137	3-5	28	3	12	19-23
813 2192-00-1	3/4 - 1"	2	56 (.046)	50-55	177	3-5	28	3	12	14-19
813 2193-00-1	1 1/2"	3	54 (.055)	50-55	235	4-7	30	4	14	12-16
813 2194-00-1	2-2 1/2"	4	52 (.064)	50-55	300	4-7	30	4	14	9-13
813 2195-00-1	3-4"	5	49 (.073)	50-55	365-392	5-8	35	5	16	8-11
813 2196-00-1	6"	6	39 (.099)	60	610	5-8	35	5	16	5-8
813 2196-00-1	8"	6	39 (.099)	65	635	5-8	35	5	16	4-6
813 2197-00-1	10"	7	30 (.129)	65	900	5-8	50	6	18	3-5
813 2197-00-1	12"	7	30 (.129)	70	975	5-8	50	6	18	3-5
813 2198-00-1	14"	8	18 (.169)	70	1290	5-8	50	6	18	2-4



Heavy Shell Style 319 - 2 Piece

The 319 is identical to the 219, except the cutting Oxygen bore is diverged to allow higher cutting Oxygen pressure for increased speed in machine cutting operation. For plates over 4" use Style 219.

Part Number	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSIG	SCFH	PSIG	SCFH	PSIG	SCFH	
813 3190-00-1	3/8"	0	68 (.031)	70	62	2-4	25-33	2-3	11-14	20-22
813 3191-00-1	1/2"	1	62 (.038)	80	115	3-5	30-40	3-4	12-16	18-22
813 3191-00-1	5/8"	1	62 (.038)	85	121	3-5	30-40	3-4	12-16	18-21
813 3192-00-1	1"	2	56 (.046)	95	133	3-5	30-40	3-4	12-16	18
813 3193-00-1	1 1/2"	3	54 (.055)	90	186	4-8	35-45	4-5	14-18	16
813 3194-00-1	2 1/2"	4	52 (.063)	90	270	4-8	35-45	4-5	14-18	12
813 3195-00-1	3"	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	11
813 3195-00-1	4"	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	10