

# STANDARD CUTTING TIP SELECTION CHART

(STANDARD TIPS PRODUCE THE CLEANEST CUTS)

STEEL THICKNESS (ENGLISH- IN)	TIP SIZE	POUNDS /INCH <sup>2</sup>		STEEL THICKNESS (METRIC -MM)	TIP SIZE	KPA	
		GASOLINE	OXYGEN			GASOLINE	OXYGEN
0 - 1/4	0	10 - 20	12 - 17	0 - 7	0	70 - 140	80 - 120
1/4 - 1	1	10 - 20	17 - 25	7 - 25	1	70 - 140	120 - 180
1 - 2	2	10 - 20	25 - 35	25 - 50	2	70 - 140	180 - 250
2 - 4	3	10 - 20	35 - 40	50 - 100	3	80 - 140	250 - 280
4 - 6	4	12 - 20	40 - 50	100 - 150	4	80 - 140	280 - 350
6 - 8	5	14 - 20	50 - 60	150 - 200	5	100 - 150	350 - 420
8 - 10	6	16 - 20	70 - 80	200 - 250	6	200 - 250	490 - 560
10 - 12	7	18 - 20	80 - 100	250 - 300	7	250 - 300	560 - 700
12 - 14	8	20	120+	300 - 350	8	300 - 350	800+

## SPECIALTY TIP SELECTION CHART

(SCRAPPING TIPS HAVE A THE LARGER PREHEAT OF A SIZE 8 TIP  
COMBINED WITH THE CUTTING CAPABILITY OF THEIR RESPECTIVE SIZE)

STEEL THICKNESS (ENGLISH- IN)	TIP SIZE	POUNDS /INCH <sup>2</sup>		STEEL THICKNESS (METRIC -MM)	TIP SIZE	KPA	
		GASOLINE	OXYGEN			GASOLINE	OXYGEN
SCRAP 1/4 - 1	81	10 - 20	17 - 25	SCRAP 7 - 25	81	70 - 140	120 - 180
SCRAP 2 - 4	83	10 - 20	35 - 40	SCRAP 50 - 100	83	80 - 140	250 - 280

(HIGH HEAT TIPS ARE USED TO CUT HEAVILY RUSTED, PAINTED, AND/OR DIRTY STEEL)

HIGH HEAT 0 - 1/4	HH0	10 - 20	12 - 17	HIGH HEAT 0 - 7	HH0	70 - 140	80 - 120
HIGH HEAT 1/4 - 1	HH1	10 - 20	17 - 25	HIGH HEAT 7 - 25	HH1	70 - 140	120 - 180
HIGH HEAT 1 - 2	HH2	10 - 20	25 - 35	HIGH HEAT 25 - 50	HH2	70 - 140	180 - 250
HIGH HEAT 2 - 4	HH3	10 - 20	35 - 40	HIGH HEAT 50 - 100	HH3	80 - 140	250 - 280

(LARGE HEATING TIP IS NOT USED FOR CUTTING.  
THIS TIP IS PETROGEN'S VERSION OF THE TRADITIONAL "ROSEBUD" HEATING TIP.)

LARGE HEAT	L	18 - 20	100	LARGE HEAT	L	250 - 300	560 - 700
------------	---	---------	-----	------------	---	-----------	-----------