

VICTORPropane, LPG &
Natural Gas
Cutting Tip Chart

Cutting Tip Series GPN, HPN

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)***	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf Width
1/8"	000	20/25	See Below	3/5	24/28	.04
1/4"	00	20/25		3/5	21/25	.05
3/8"	0	20/25		3/5	20/24	.06
1/2"	0	30/35		3/5	18/22	.06
3/4"	1	30/35		3/6	15/20	.08
1"	2	35/40		3/6	14/18	.09
1-1/2"	2	40/45		5/9	12/16	.09
2"	3	40/45		5/9	10/14	.10
2-1/2"	3	40/45		6/10	9/12	.10
3"	4	40/50		8/12	8/11	.12
4"	5	45/55		8/12	7/10	.14
5"	5	50/55		8/12	6/9	.14
6"	6**	45/55		10/15	5/7	.17
8"	6**	55/65		10/15	4/6	.18
12"	8**	60/70		10/15	3/5	.27

NOTICE *The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200N Series	N/A	8oz - Up
MT 300N Series 000-6	20-55	8oz - Up
ST 900C Series	N/A	5 - Up
ST 1600C / ST 1700 Series	N/A	1 - Up
ST 1800C / ST 1900C Series	N/A	1 - Up
STN 2300C Series	N/A	2 - Up

**For best results use ST 1600C / ST 1900C or ST 2600FC series torches and 3/8" hose when using tip size 6 or larger.

*** All pressures are measured at the regulator using 25' x 1/4" hose through tip size 5 and 25' x 3/8 hose for tip size 6 and larger.
 Torches with flashback arrestors require up to 25% more pressure as tip size increases.

VICTORPropane, LPG &
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Cutting Tip ChartCutting Tip Series MTHN
(High Speed Machine Cutting)

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)*	Preheat Oxygen (PSIG)	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf Width
1/4"	00	85/95	See Below	See Below	23/30	.05
3/8"	00	85/95			23/30	.05
1/2"	0	85/95			18/26	.06
3/4"	0	85/95			17/24	.06
1"	1	85/95			15/22	.07
1-1/2"	1	85/95			12/16	.07
2"	2	85/95			11/15	.09
2-1/2"	2	85/95			10/13	.09
3"	2	85/95			9/11	.09
4"	3	85/95			7/10	.11
6"	3	85/95			5/7	.11
8"	4	85/95			4/6	.14
10"	5	85/95			3/5	.18

NOTICE The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200N Series	N/A	8oz - Up
MT 300N Series	10-25	8oz - Up

NOTICE Data compiled using mild steel as test material.

* Pressure is measured at the torch inlet on MTH Series Tips. Torches with flashback arrestors require up to 25% more pressure as tip size increases.