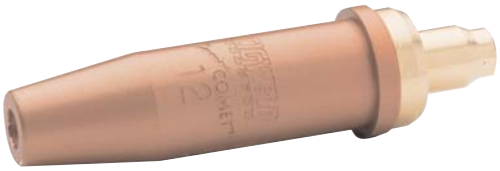
COMET Type 44 Cutting Nozzles



Oxy/LP gas or Natural gas specifications

Standard speed cutting nozzles

CIGWELD Type 44	Part No.	Size	Plate thickness	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa
Standard	306025	6	3-6	2.0	17(200)
	306026	8	6-12	3.5	30(200)
	306028	12	12-20	4.5	58(250)
	306029	15	25-75	5.5	99(400)
	306030	20	100-125	6.5	171(400)
	306031	24	150-200	9.0	256(500)
	306032	32±	225-300	14.0	456(600)

Hi-speed speed cutting nozzles

CIGWELD Type 44	Part No.	Size	Plate thickness	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa	Cutting speed mm/min†
Hi-speed for use on cutting machines	306018	6HS	6-8	5.0	45(650)	550
	306019	8HS	8-20	5.0	64(650)	550-500
	306021	12HS	25-75	6.5	122(650)	500-300
	306022	15HS	75-150	7.0	173(650)	300-200
	306023	20HS	150-250	9.0	267(650)	200-100
	306024	24HS	250-300	12.0	350(650)	90

NOTE: Pre-heat oxygen pressure for all hi-speed nozzles = 200kPa

Gouging nozzles

CIGWELD Type 44	Part No.	Size	Plate thickness	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa
Gouging	306033	32GS		12.0	94(500)
	306054	32GB		12.0	94(500)
	306055	48GB±		13.0	120(600)
	306056	64GB±		15.0	150(650)

DG= Deep Gouging
GB= Gouging - Bent
GS= Gouging - Straight
SM= Sheet Metal
RC= Rivet Cutting
FW= Flame Washing
HS= High Speed
± For use with COMET Multi-Purpose only
† Cutting speeds are average values for drop cuts on clean plate with nozzles in good condition - variations could be expected due to actual working conditions.
NB. Cutting nozzles can operate over a range of gas flows (hence plate thicknesses).
The values indicated are typical operating conditions and can be increased or decreased to suit particular applications.