

Welding Tips

TIPS

- Tips are manufactured from copper tubes which have swaged interior
 - Gas passages are mirror smooth with internal angles rounded, non-turbulent
 - More efficient gas flow.
- Wide range of Tips of different sizes
 - Optimum consumption of gas with use of correct size of tips.

Saffire 2 HP (swaged)

TIP SIZE (mm)	PLATE THICKNESS (mm)
1	0.9
2	1.2
3	2.0
6	3.0
7	3.2
10	4.0
13	5.0
20	8.0
30	8.5
35	10.0
45	13.0
55	16.0
70	20.0
90	25.0



Welding Tips



TIPS

Light weight - LWHP (swaged)

TIP SIZE (mm)	PLATE THICKNESS (mm)
2	1.9
3	2.0
6	3.0
10	4.0
18	5.0
25	6.5
13	8.2



Model 'O' Tips

TIP SIZE (mm)	PLATE THICKNESS (mm)
1	2-3
2	4.5
3	6-8
4	10-20
5	18-30



Operating Data for Mild Steel welding with ESAB Welding Blowpipe (High pressure & Low pressure type) comply with ISI & ISO Standards

Material Thickness		Tips size	Gas pressure Oxygen		Gas Pressure Fuel Acetyline	
mm	inch		bar	psi	bar	psi
1.2	3/64"	2.0	1.5	20	0.14	2.0
2.0	5/64"	3.0	1.5	20	0.14	2.0
3.0	1/8"	6.0	2.5	35	0.21	3.0
5.0	3/16"	13.0	2.5	35	0.21	3.0
8.0	5/16"	20.0	3.0	45	0.28	4.0
10.0	3/8"	30.0	3.0	45	0.28	4.0
12.0	13/32"	35.0	3.5	50	0.42	6.0
14.0	9/16"	45.0	3.5	50	0.42	6.0
16.0	5/8"	55.0	4.0	60	0.56	8.0
20.0	13/16"	70.0	4.0	60	0.70	10.0
25.0	1"	90.0	4.5	65	0.70	10.0