

TECHNICAL PRODUCT SPECIFICATION

Code: FTP-702.00.100

Date: 19-7-04

Rev.: 0

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PRODUCT: UNIVERSAL WELDING AND CUTTING HANDLE

REFERENCE: 702.00.100

Construction characteristics:

DESCRIPTION	Equipment for medium and high performances. It contains all the necessary elements for welding and cutting with gases up to 300 mm.		
GAS USED:	OXYGEN-ACETYLENE, OXYGEN-PROPANE, OXYGEN-NATURAL GAS		
APPLICATION STANDARDS:	UNE-EN-ISO-5172	APPROVAL PASSWORD:	CBZ-0182
APPLICATIONS:	Professional boilerwork and bodywork jobs with large thicknesses and where high calorific powers are necessary. Specific equipment for high performances.		
MATERIALS:	ACCORDING TO EN 29.539		
Handle	BRASS CUZN39PB3	Internal parts	BRASS CUZN39PB3
Adjustment wheels	ANODISED ALUMINIUM	Cutter	BRASS CUZN39PB3
Lances	BRASS CUZN39PB3	Nozzles	COPPER

INLET THREADS:	G1/4"RH / G3/8"LH	HOSE Ø	Ø 6,3 - 8 mm.
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HANDLE WEIGHT:	CUTTER TORCH DIMENSIONS:			WELDING TORCH DIMENSIONS:		
360 grams	L=	200 mm.		L=	210 mm.	
CUTTER WEIGHT:	P=	22 mm.		H=	75 mm.	
220 grams	H=	60 mm.		Ø=	25 mm.	

Accessories for acetylene gas

Technical characteristics depending on welding nozzle:

Reference	Description	Thickness	Filler metal Ø	Welding pressures		Consumptions (L/h)	
				P _{acetylene}	P _{oxygen}	Q _{acetylene}	Q _{oxygen}
704.00.000	Welding lance nº 0	0,5-1	1 mm.	<0,2 bar	1-2 bar	55	120
704.00.100	Welding lance nº 1	1-2	2 mm.	<0,2 bar	2-3 bar	95	235
704.00.200	Welding lance nº 2	2-4	3 mm.	<0,2 bar	2,5-4 bar	240	590
704.00.300	Welding lance nº 3	4-6	4 mm.	<0,4 bar	3,5-5 bar	470	1060
704.00.400	Welding lance nº 4	6-9	5 mm.	<0,4 bar	4-7 bar	820	1880
704.00.500	Welding lance nº 5	9-14	6 mm.	<0,4 bar	4,5-8 bar	1020	2350
704.00.600	Welding lance nº 6	14-20	7 mm.	<0,5 bar	5,5-9 bar	1380	3530

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704.00.700	Welding lance nº 7	20-30	8 mm.	<0,5 bar	6-12 bar	1560	3760
724.19.501	Heating nozzle Nº 1			<0,4 bar	4-7 bar	1520	3700
724.19.502	Heating nozzle Nº 2			<0,5 bar	4,5-8 bar	1820	4600

Technical characteristics depending on cutting nozzle (cutter 701.00.000):

Inner nozzle reference	Description	Outer nozzle reference	Description	Cut thickness (mm.)	Welding pressures	
					P _{acetylene}	P _{oxygen}
701.19.201	Inner nozzle nº 1	701.19.101	Outer nozzle nº 1	3-12	<0,3	1-2 bar
701.19.202	Inner nozzle nº 2	701.19.102	Outer nozzle nº 2	15-25	<0,3	2-3 bar
701.19.203	Inner nozzle nº 3	701.19.103	Outer nozzle nº 3	25-30	<0,4	2,5-4 bar
701.19.204	Inner nozzle nº 4	701.19.103	Outer nozzle nº 3	30-50	<0,4	3,5-5 bar
701.19.205	Inner nozzle nº 5	701.19.103	Outer nozzle nº 3	50-100	<0,5	4-7 bar
701.19.206	Inner nozzle nº 6	701.19.104	Outer nozzle nº 4	100-150	<0,5	4,5-8 bar
701.19.207	Inner nozzle nº 7	701.19.104	Outer nozzle nº 4	150-200	<0,5	5,5-9 bar
701.19.208	Inner nozzle nº 8	701.19.104	Outer nozzle nº 4	200-300	<0,6	8-12 bar

Accessories for natural gas and propane gas:

Technical characteristics depending on welding nozzle:

Reference	Description	Thickness	Filler metal Ø	Pressures (bar)			Consumptions (L/h)			
				P _{prop.}	P _{N.G.}	P _{oxyg.}	Q _{prop.}	Q _{oxyg.}	Q _{N.G.}	Q _{oxyg.}
704.00.005	Welding lance nº 0	0,5-1	1 mm.	<0,2	<0,2	1-2	60	295	70	120
704.00.105	Welding lance nº 1	1-2	2 mm.	<0,2	<0,2	2-3	100	590	140	235
704.00.205	Welding lance nº 2	2-4	3 mm.	<0,2	<0,2	2,5-4	150	765	250	590
704.00.305	Welding lance nº 3	4-6	4 mm.	<0,2	<0,2	3,5-5	265	1180	525	1060
704.00.405	Welding lance nº 4	6-9	5 mm.	<0,3	<0,3	4-7	410	2120	845	1880
704.00.505	Welding lance nº 5	9-14	6 mm.	<0,4	<0,4	4,5-8	610	3060	1140	2350
704.00.605	Welding lance nº 6	14-20	7 mm.	<0,6	<0,6	5,5-9	860	4590	1410	3530
704.00.705	Welding lance nº 7	20-30	8 mm.	<0,8	<0,8	6-12	1020	5290	1600	3760
724.19.511	Heating nozzle Nº 1			<0,5	<0,6	2,5	490	1250	1370	3700
724.19.512	Heating nozzle Nº 2			<0,6	<0,7	4	820	3300	2210	4600
755.00.200	Heating nozzle 2NG			<0,5	<0,7	3,5	1100	4700	3650	5600
755.00.300	Heating nozzle 3NG			<0,6	<0,8	5	1550	6500	5470	7760
755.00.400	Heating nozzle 4NG			<0,7	<1	6	1880	8230	7570	11170

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Technical characteristics depending on cutting nozzle (cutter 701.00.030):

Reference	Description	Cut thickness	Welding pressures		Consumptions (L/h)			
			P _{combustible}	P _{oxygen}	Q _{oxygen}	Q _{propane}	Q _{oxygen}	Q _{nat. gas}
756.00.201	Cutting nozzle nº 1	4-9	0,1 bar	2-2,5 bar	915	275	675	205
756.00.202	Cutting nozzle nº 2	9-25	0,15 bar	2,5-3 bar	955	280	730	225
756.00.203	Cutting nozzle nº 3	25-50	0,15 bar	3-3,5 bar	1080	290	830	240
756.00.204	Cutting nozzle nº 4	50-75	0,2 bar	3,5-4 bar	1280	310	900	250
756.00.205	Cutting nozzle nº 5	75-150	0,2 bar	4-4,5 bar	1365	335	1195	320
756.00.206	Cutting nozzle nº 6	150-200	0,25 bar	4,5-5 bar	1500	450	1220	335
756.00.207	Cutting nozzle nº 7	200-300	0,3 bar	5-6 bar	1815	550	1345	340