

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 |



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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 Acetylene | |
|--------------------|-----------|---------------------|-----|-----------------------------|------|
| | | bar | psi | bar | psi |
| 1.2 mm | 3/64" | 1.5 | 20 | 0.14 | 2.0 |
| 2.0 mm | 5/64" | 1.5 | 20 | 0.14 | 2.0 |
| 3.0 mm | 1/8" | 2.5 | 35 | 0.21 | 3.0 |
| 5.0 mm | 3/16" | 2.5 | 35 | 0.21 | 3.0 |
| 8.0 mm | 5/16" | 3.0 | 45 | 0.28 | 4.0 |
| 10.0 mm | 3/8" | 3.0 | 45 | 0.28 | 4.0 |
| 12.0 mm | 13/32" | 3.5 | 50 | 0.42 | 6.0 |
| 14.0 mm | 9/16" | 3.5 | 50 | 0.42 | 6.0 |
| 16.0 mm | 5/8" | 4.0 | 60 | 0.56 | 8.0 |
| 20.0 mm | 13/16" | 4.0 | 60 | 0.70 | 10.0 |
| 25.0 mm | 1" | 4.5 | 65 | 0.70 | 10.0 |