



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP
1390, 23A90, 5090 & 8490 WELDING,
BRAZING TIP FLOW CHART
ACETYLENE

WELDING METAL THICKNESS	TIP SIZE	ACETYLENE FLOW CFH**		EQUAL PRESSURE*	RECOM. HOSE I.D.
		WELDING	HEATING		
1/64"	0	1-3	5	1	3/16"
1/32"	1	2-5	7	1	3/16"
3/64"	2	3-8	10	2	3/16"
1/16"	3	5-11	14	3	3/16"
3/32"	4	6-14	18	4	3/16"
1/8"	5	8-18	22	5	3/16"
3/16"	6	10-20	30	6	3/16"
1/4"	7	13-25	35	7	3/16"
5/16"	8	16-32	40	8	3/16"
3/8"	9	20-37	50	9	1/4"
1/2"	10	24-42	60	10	1/4"
3/4"	13	30-50	75	13	3/8"
1"	15	35-65	90	15	3/8"

*Oxygen and Acetylene pressures are set equal.

** Oxygen flow 1.1 times acetylene flow for neutral flame. Low flow set to clear smoke with acetylene only flowing (soft flame). High flow set to hold flame on tip with acetylene only flowing (harsh flame).

Caution: Flow rate should not exceed 1/7 of the acetylene cylinder contents. For higher flow rates, use additional cylinders manifold in parallel. Hose sizes are suitable for hose lengths up to 25ft. Higher pressures should be used for longer lengths. Heat output (BTU/Hr.) = acetylene flow X 1470 (1470 BTU/Cu.Ft.)