

Heating & Welding/Brazing Assemblies

OXYACETYLENE HEATING NOZZLES

STYLE	SIZE	COMPLETE NOZZLE
MFA For use with Flame Tech® VTHH-21 heavy duty torch handle or Victor® HD handle.	4	4-MFA
	6	6-MFA
	8	8-MFA
	10	10-MFA
	12	12-MFA
	15	15-MFA
MFA-1 For use with Flame Tech® VTHM-22 medium duty torch handle or Victor® MD handle.	2	2-MFA-1
	4	4-MFA-1
	6	6-MFA-1
	8	8-MFA-1
MFA-J For use with J-Torch.	2	2-MFA-J
	4	4-MFA-J
	6	6-MFA-J

STYLE	SIZE	COMPLETE NOZZLE
MFN For use with Flame Tech® VTHH-21 heavy duty torch handle or Victor® HD torch handle. *3/8" hose is required	8	8-MFN
	10	10-MFN
	12*	12-MFN
	15*	15-MFN
MFN-1 For use with Flame Tech® VTHM-22 medium duty torch handle or Victor® MD torch handle.	6	6-MFN-1
	8	8-MFN-1

WARNING: MFN & MFN-1 heating nozzles are for alternative fuel gases only; they are not for use with acetylene.



TIP SIZE	OXYGEN PRESSURE (PSI)	ALT. FUEL GAS PRESSURE (PSI)	ACETYLENE PRESSURE (PSI)	OXYGEN CONSUMPTION (SCFH)	ALT. FUEL GAS CONSUMPTION (SCFH)	ACETYLENE CONSUMPTION (SCFH)
2	4-8	—	4-8	3-10	—	3-9
4	8-12	—	6-10	7-22	—	6-20
6	10-15	2-10	8-12	15-44	5.5-20	15-50
8	20-30	10-15	10-15	33-88	10-35	30-80
10	30-40	12-20	12-15	44-110	20-80	40-100
12	50-60	13-25	12-15	66-165	30-160	60-150
15	50-60	13-25	12-15	99-244	50-200	90-220

NOTE: Oxygen consumption (SCFH) is 1.1 times that of acetylene, under neutral flame conditions.
 Oxygen consumption (SCFH) is about 2.0 times that of alt. fuel gases, under neutral flame conditions.

OXYACETYLENE WELDING NOZZLES

STYLE	SIZE	COMPLETE NOZZLE
W For use with Flame Tech® VTHH-21 heavy duty torch handle or Victor® HD handle.	000	000-W
	00	00-W
	0	0-W
	1	1-W
	2	2-W
	3	3-W
	4	4-W
W-1 For use with Flame Tech® VTHM-22 medium duty torch handle or Victor® MD handle.	000	000-W-1
	00	00-W-1
	0	0-W-1
	1	1-W-1
	2	2-W-1
	3	3-W-1
	4	4-W-1
W-J For use with J-Torch.	000	000-W-J
	00	00-W-J
	0	0-W-J
	1	1-W-J
	2	2-W-J
	3	3-W-J
	4	4-W-J
	5	5-W-J
	6	6-W-J



METAL THICKNESS	TIP SIZE	DRILL SIZE	OXYGEN (PSI)	ACETYLENE (PSI)	ACETYLENE (SCFH)
Up to 1/32"	000	75 (.022)	3-5	3-5	1-2
1/16" to 3/64"	00	70 (.028)	3-5	3-5	1.5-3
1/32" to 5/64"	0	65 (.035)	3-5	3-5	2-4
3/64" to 3/32"	1	60 (.040)	3-5	3-5	3-6
1/6" to 1/8"	2	56 (.056)	3-5	3-5	5-10
1/8" to 3/16"	3	53 (.060)	4-7	3-5	8-18
3/16" to 1/4"	4	49 (.073)	5-10	4-7	10-25
1/4" to 1/2"	5	43 (.089)	6-12	5-8	15-35
1/2" to 3/4"	6	36 (.106)	7-14	6-9	25-45