

# Oxygen & Acetylene Gas Pressures

## WELDING

METAL THICKNESS	ROD DIAMETER	TIP (Drill Size)	PRESSURES (PSI)	
			OXYGEN	ACETYLENE
1/16"	1/16-3/32"	56	8 - 20	5
1/8"	3/32-1/8"	53	11 - 25	5
1/4"	5/32-3/16"	48	12 - 23	5

## CUTTING

METAL THICKNESS	ORIFICE (Drill Size)		PRESSURE (PSI)	
	PREHEAT	CUTTING	OXYGEN	ACETYLENE
1/8 - 3/8"	70	67	20 - 30	3
3/8 - 3/4"	62	58	30 - 40	5
3/4 - 1"	57	54	40 - 45	5
1 1/2 - 2"	54	51	45 - 50	5

### NOTES:

Tables show approximate gas pressures for welding or cutting.

Tip size numbers vary among manufacturers, so orifice sizes are shown in "number drill" sizes.

## EYE PROTECTION

APPLICATION	BASE METAL THICKNESS	LENS SHADE
Oxygen/Acetylene Welding	Up to 1/8"	3-4
Oxygen/Acetylene Welding	1/8" to 1/2"	4-5
Oxygen/Acetylene Welding	1/2" and over	5-6
Oxygen/Acetylene Cutting	Up to 1"	4-5
Oxygen/Acetylene Cutting	1" to 6"	5-6
Oxygen/Acetylene Cutting	6" and over	6-8