

thermal units (Btu) or joules. This is called the *heat of combustion*. The heat of combustion helps to keep the metal in the cutting area at the ignition temperature, so that cutting can progress smoothly.

14.2 Oxyfuel Gas Cutting Process

A special torch and tip is used in the oxyfuel gas cutting process. See Figure 14-1. Cutting tips have one or more preheating orifices (holes) to provide the flames used to heat the metal being cut to its ignition temperature. Cutting oxygen exits from a central orifice when the welder presses the cutting oxygen lever. See Figure 14-2. The ignition temperature of steel occurs when its color is cherry red and its temperature is about 1300°F to 1400°F (704°C to 760°C).

The oxyfuel gas preheating flames are adjusted and used in the same manner as the flames used for welding. The preheating flames are used to heat a spot on the base metal to its ignition temperature. When the ignition temperature is reached, the operator



Figure 14-1. Oxyacetylene cutting outfit.

depresses the oxygen lever, and a stream of pressurized oxygen burns the metal and blows it away from the base metal. As the torch is moved along a predetermined line, the metal is cut, forming the cut or *kerf*. The preheating flames are kept burning throughout the entire cutting process. These flames are required to ensure that the base metal never drops below its ignition temperature during cutting.

14.3 Cutting Outfit

An outfit used for manual oxyfuel gas cutting is similar to an oxyacetylene welding outfit. The outfits differ only in the torch and possibly the oxygen regulator used. The term *cutting outfit* is used to include all equipment required to perform a cut. A cutting station would include the outfit, lighting, ventilation, a cutting table, and possibly a booth.

Since the cutting torch must provide an oxygen cutting jet, it is quite different from a welding torch. Because the oxygen pressures for cutting are usually higher than the pressures employed when welding, an oxygen regulator with a higher working pressure should be used. Also, the inside diameter of the oxygen hose should be larger to provide a higher rate of flow.

Carefully review Chapters 11 and 13 before connecting and operating the oxyfuel gas cutting outfit. Information in those chapters concerning cylinders, manifolds, regulators, hoses, torches, and tips also apply to oxyfuel gas cutting outfits.

14.4 Cutting Torch

A cutting torch is similar to a welding torch, however, a cutting torch has a separate passageway for the oxygen jet. As in welding, the cutting torch is

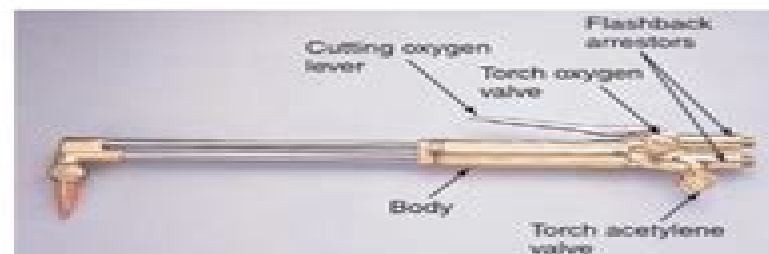


Figure 14-2. A cutting torch with flashback arrestors built into the torch body. (Victor, a division of Thermadyne Industries, Inc.)

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