



Welding Tips

Relation of plate thickness, orifice size and gas pressure

Plate Thickness		Orifice Size	Gas Pressure in psi			
			Injector - Type of Torch		Equal Pressure Torch	
Gauge	Inches	Drill No.	Acetylene	Oxygen	Acetylene	Oxygen
32	0.010	74	5	5-7	1	1
28	0.016	70	5	7-8	1	1
28	0.019	70	5	7-10	1	1
22	1/32	65	5	7-18	2	2
16	1/16	56	5	8-20	3	3
13	3/32	56-54	5	15-20	4	4
11	1/8	54-53	5	12-24	4	4
8	3/16	53-50	5	16-25	5	5
-	1/4	50-46	5	20-29	6	6
-	3/8	46-44	5	24-33	7	7
-	1/2	40	5	29-34	8	8
-	5/8	30	5	30-40	9	9
-	3/4	30-29	5	30-40	10	10
-	1	23	5	30-42	12	12

Lens Shade Selection Chart

Operation	Shade Selection
Soldering	2
Torch Brazing	3 or 4
Oxygen Cutting	
up to 1"	3 or 4
1 to 6"	4 or 5
6" and over	5 or 6
Gas Welding	
up to 1/8"	4 or 5
1/8 to 1/2"	5 or 6
1/2 and over	5 or 6
Shielded Metal-Arc Welding	
1/16 thru 5/32" electrodes	10
Gas Tungsten-Arc Welding (Non-Ferrous)	
Gas Metal-Arc Welding (Non-Ferrous)	11
1/16 thru 5/32" electrodes	
Gas Tungsten-Arc Welding (Ferrous)	
Gas Metal-Arc Welding (Ferrous)	12
1/16 thru 5/32" electrodes	
Shielded Metal-Arc Welding	
3/16 thru 1/4" electrodes	12
5/16 thru 3/8" electrodes	14