

NO. 55 O-A Heating Nozzle
P/N 20238
for use with C-32 or C-77 Oxy-Acetylene Cutting Torch

This multiflame heating nozzle is designed for heating applications using a C-32 or C-77 cutting torch. It is like a standard cutting nozzle without a cutting oxygen bore and it connects to the torch head in the same manner as a cutting nozzle.

Use only acetylene. Do not use with any other fuel gas.

PRECAUTIONS

To prevent overheating and flashbacks, read and understand the following precautions:

1. Do NOT use this heating nozzle on cutting attachments. Use only hand cutting torches capable of cutting at least 12-in. thick steel.
2. Be sure to use the oxygen and acetylene pressures as given below using 3/8-in. I.D. hoses with 1/4-in. I.D. hose fittings.
3. If using hose lengths greater than 25-ft., use an oxygen (P/N 07X17) and acetylene (P/N 262510) test gauge adaptors to make sure that the recommended operating pressures are available at the torch inlets.
4. Withdrawal of acetylene from a cylinder should not exceed 1/7 of the cylinder capacity. Therefore, if using a cylinder smaller than a WTL (390 cf), 2 or more cylinders should be manifolded.
5. With proper operating pressure, flame inner cone height should be approximately 1/2-in. long. Do not operate with flames too short.
6. Do not operate the heating nozzle too close to the work. The tip of the flame inner cones should be 1/8 to 1/4-in. from the work.
7. If you hear frequent popping noises at the nozzle, a cross leak has developed. Retighten the nozzle. If popping continues, send the torch and nozzle to your ESAB distributor for repair.

OPERATING DATA - NO. 55 O-A Heating Nozzle, P/N 20238

Torch	Oper. Pressure, psig		Consumption, cfh		Flame Inner Core Height	No. of Flames	Tip Cleaning Drill Size
	Oxygen	Acetylene	Oxygen	Acetylene			
C-32	7-11	5-8	70-86	50-62	1/2"	9	61
C-77	10-13	12 -15	70-77	50-55	1/2"	9	(0.039" dia.)



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