

# “C” FLAME HEATING TIPS

This multiflame heating tip is designed for heating applications using the W-200 welding torch. It is like a standard single flame welding head or rosebud heating head without a cutting oxygen bore.



These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for air-fuel gas equipment, we urge you to read our booklet “Precautions and Safe Practices for Gas Welding, Cutting & Heating,” Form 2035. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information.

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

## OPERATING INSTRUCTIONS

1. Read torch instruction and operating form F-9773 before operating tips.
2. Attach tip securely to torch, and snug with a wrench.
3. Set regulator pressures at the torch with flow as follows:

P/N	Model	Oxygen (psig)	Acetylene (psig)
22557	C-2	7	5
22558	C-4	8	8
22559	C-6	10	8
22560	C-8	11	10

4. **CAUTION:** Be sure to wear fire resistant gloves and eye protection at all times when operating the torch. Failure to do so will or can cause minor personal injury.
5. Open the acetylene torch valve 1/8 turn and ignite with a spark lighter only.
6. Continue opening the acetylene torch valve, increasing the flame size until the black smoke just barely disappears from the outer flames.
7. Adjust the oxygen by opening the torch valve, reducing the long acetylene feathers so that 1/8" to 1/4" is still visible beyond the brighter inner cone thereby producing a slightly carburizing flame.
8. **CAUTION:** If the tip flames begin popping or self extinguishing during operation, quickly extinguish the torch. Reignite and readjust the torch flame. If the problem persists, make sure the tip is not starving due to incorrect gas pressures. Excessive gas pressures or flame adjustment may cause the tip to overheat and backfire. Backfiring may lead to a flashback which will or can cause minor personal injury or property damage.

**Be sure this information reaches the operator.  
You can get extra copies through your supplier.**



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