

Series 3 – Cutting Tips

Series 3 tip style, fuel gas usage and Victor equipment compatibility shown below.

Cutting Torches

Handle	Cutting Attachment	Fuel Gas
HEAVY DUTY		
315FC	CA 2460-90°	All
MEDIUM DUTY		
100FC	CA 1350-90°, CA 1351-75°, CA 1352-180°	All
LIGHT DUTY		
J-40	CA 1260-90°	All
STRAIGHT TORCHES		
CST 800FC	–	All

Material Thickness – Tip Size

Material Thickness		Tip Size
Inches	mm	
1/8"	3.2 mm	000
1/4"	6.4 mm	00
3/8" – 1/2"	9.5 - 12.7 mm	0
3/4"	19.1 mm	1
1" – 1 1/2"	25.4 - 38.1 mm	2
2" – 2 1/2"	50.8 - 63.5 mm	3
3"	76.2 mm	4
4" – 5"	102 - 127 mm	5

Series 3 – Acetylene Cutting Tips

Victor Series 3 Type 101



- General purpose
- Hand and machine torch cutting

Metal Thickness (Inches)	Size	Part No.	Cutting Oxygen *** (psig)	Cutting Oxygen (SCFH)	Preheat Oxygen *(psig)	Preheat Oxygen (SCFH)	Acetylene (psig)	Acetylene **** (SCFH)	Speed ipm	Kerf Width
1/8"	000	0331-0002	20 / 25	20 / 25	3 / 5	3 / 5	3 / 5	3 / 5	28 / 32	.04
1/4"	00	0331-0009	20 / 25	30 / 35	3 / 5	4 / 6	3 / 5	4 / 6	27 / 30	.05
1/4"	00	0387-0144#	20 / 25	30 / 35	3 / 5	4 / 6	3 / 5	4 / 6	27 / 30	.05
3/8"	0	0331-0013	25 / 30	55 / 60	3 / 5	5 / 9	3 / 5	5 / 8	24 / 28	.06
3/8"	0	0387-0145#	25 / 30	55 / 60	3 / 5	5 / 9	3 / 5	5 / 8	24 / 28	.06
1/2"	0	0331-0013	30 / 35	60 / 65	3 / 6	7 / 11	3 / 5	6 / 10	20 / 24	.06
1/2"	0	0387-0145#	30 / 35	60 / 65	3 / 6	7 / 11	3 / 5	6 / 10	20 / 24	.06
3/4"	1	0331-0014	30 / 35	80 / 85	4 / 7	9 / 14	3 / 5	8 / 13	17 / 21	.07
3/4"	1	0387-0146#	30 / 35	80 / 85	4 / 7	9 / 14	3 / 5	8 / 13	17 / 21	.07
1"	2	0331-0015	35 / 40	140 / 150	4 / 9	11 / 18	3 / 6	10 / 16	15 / 19	.09
1"	2	0387-0147#	35 / 40	140 / 150	4 / 9	11 / 18	3 / 6	10 / 16	15 / 19	.09
1 1/2"	2	0331-0015	40 / 45	150 / 160	4 / 12	13 / 20	3 / 7	12 / 18	13 / 17	.09
1 1/2"	2	0387-0147#	40 / 45	150 / 160	4 / 12	13 / 20	3 / 7	12 / 18	13 / 17	.09
2"	3	0331-0016	40 / 45	210 / 225	5 / 14	15 / 24	4 / 9	14 / 22	12 / 15	.11
2 1/2"	3	0331-0016	45 / 50	225 / 240	5 / 16	18 / 29	4 / 10	16 / 26	10 / 13	.11
3"	4	0331-0017	40 / 50	270 / 320	6 / 17	20 / 33	5 / 10	18 / 30	9 / 12	.12
4"	5	0331-0018	45 / 55	390 / 425	7 / 18	24 / 37	5 / 12	22 / 34	8 / 11	.15
5"	5	0331-0018	50 / 55	425 / 450	7 / 20	29 / 41	5 / 13	26 / 38	7 / 9	.15

G-Series Series 3 Type 101

Metal Thickness (Inches)	Size	Part No.	Model No.	Cutting Oxygen *** (psig)	Cutting Oxygen (SCFH)	Preheat Oxygen *(psig)	Preheat Oxygen (SCFH)	Acetylene (psig)	Acetylene **** (SCFH)	Speed ipm	Kerf Width
1/8"	000	6700C2438	CS3101000	20 / 25	20 / 25	3 / 5	3 / 5	3 / 5	3 / 5	28 / 32	.04
1/4"	00	6700C2439	CS310100	20 / 25	30 / 35	3 / 5	4 / 6	3 / 5	4 / 6	27 / 30	.05
3/8"	0	6700C2440	CS31010	25 / 30	55 / 60	3 / 5	5 / 9	3 / 5	5 / 8	24 / 28	.06
1/2"	0	6700C2440	CS31010	30 / 35	60 / 65	3 / 6	7 / 11	3 / 5	6 / 10	20 / 24	.06
3/4"	1	6700C2441	CS31011	30 / 35	80 / 85	4 / 7	9 / 14	3 / 5	8 / 13	17 / 21	.07
1"	2	6700C2442	CS31012	35 / 40	140 / 150	4 / 9	11 / 18	3 / 6	10 / 16	15 / 19	.09
1 1/2"	2	6700C2442	CS31012	40 / 45	150 / 160	4 / 12	13 / 20	3 / 7	12 / 18	13 / 17	.09
2"	3	6700C2443	CS31013	40 / 45	210 / 225	5 / 14	15 / 24	4 / 9	14 / 22	12 / 15	.11
2 1/2"	3	6700C2443	CS31013	45 / 50	225 / 240	5 / 16	18 / 29	4 / 10	16 / 26	10 / 13	.11
3"	4	6700C2444	CS31014	40 / 50	270 / 320	6 / 17	20 / 33	5 / 10	18 / 30	9 / 12	.12
4"	5	6700C2445	CS31015	45 / 55	390 / 425	7 / 18	24 / 37	5 / 12	22 / 34	8 / 11	.15
5"	5	6700C2445	CS31015	50 / 55	425 / 450	7 / 20	29 / 41	5 / 13	26 / 38	7 / 9	.15

Data compiled using mild steel as test material.

* Applicable for three hose machine torch only. With a two hose cutting torch, preheat pressure is set by the cutting oxygen.

** For best results use ST2600FC series torches and 3/8" hose when using tip size 6 or larger.

*** All pressures are measured at the regulator using 25' x 1/4" hose through tip size 5 and 25' x 3/8" hose for tip size 6 and larger.

**** Oxygen consumption is 1.1 times the acetylene under neutral flame conditions.

Clam Shell Packaging

WARNING: At no time should the withdrawal rate of an individual acetylene cylinder exceed 1/7 of the cylinder contents per hour. If additional flow capacity is required use an acetylene manifold system of sufficient size to supply the necessary volume.