

WELDING TORCHES**TYPE 147.5 / 147.5.5**

Welding torches operate with Acetylene as burning gas.

The torches are used for welding of metal plates of thickness from 0.5 to 30 mm.

TYPE TYPE 147.8

The Torches are manufactured in eight sizes, for different thickness of the material, and are labeled with numbers from 1 through 8.

Correct operation of welding torches is guaranteed only with the universal holder 146.1

TYPE TYPE 147.3 / 147.3.4

Welding torches of types 147.3 and 147.4 are designed for welding in places that are difficult to access, such as corners, pipes, and other places where basic welding torches, the torches of types 147.5, 147.7 and 147.8 can not be used because of their size.

TYPE TYPE 147.4

The welding torches of type 147.4 are easily bent, and can be modeled depending on the position of the weld.

**A.D. INSA - MANUFACTURER OF
MEASUREMENT INSTRUMENTS**

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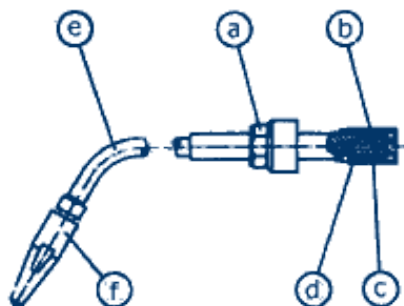


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WELDING TORCHES

WELDING TORCH DESIGN



- a Connection Sleeve
- b Mixer
- c Chamber
- d Gasket
- e Extender
- f Nozzle

TYPES OF WELDING TORCHES

147.3	147.4	Torch Type 147.5	147.7	147.8	plate thickness (mm)
147.3 .1	147.4 .1	147.5 .1			.5 - 1
147.3 .2	147.4 .2	147.5 .2			1 - 2
147.3 .3	147.4 .3	147.5 .3			2 - 4
147.3 .4	147.4 .4	147.5 .4			4 - 6
147.3 .5	147.4 .5	147.5 .5			6 - 9
		147.5 .6			9 - 14
			147.7		14 - 20
				147.8	20 - 30

WELDING OXYGEN AND ACETYLENE USAGE

Oxygen and Acetylene usage ratio is approximately 1:1.

torch size (no.)	1	2	3	4	5	6	7	8
Oxygen Usage (l/h \pm 10%)	75	150	300	500	750	1150	1700	2500

With Oxygen working pressure of 2.5 bar.

Minimal working pressure for Acetylene is 2.5 bar.

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