



KAYSER



CUTTING & WELDING

PRODUCT CATALOG

 made
 in
 Germany

COMPANY HISTORY

Made in Germany since 1929

In 1929 KAYSER was founded as a family company and is now proud of its three generations of experience and competence. Within years, the company was developing to one of the most important ones in the field of Cutting and Welding. In the 60's the product portfolio was extended to Propane products and the company's name was changed from Kuno Kayser into KAYSER-WERK GmbH. The customers of KAYSER are specialized traders, international groups and also the ship building industry.

At the beginning of the 90's, KAYSER was able to increase its export business by continuously improving quality standards. Parallel to this, KAYSER could also improve its position in the internal German market, despite of heavy competition and difficult economical situation. At the beginning of 1997, a lot of activities took place in order to consolidate and also looking forward to worldwide extending expectations on German products. As a result, the export share of our business has continuously grown.

Highly motivated employees - some even started their business education at KAYSER'S - take care of KAYSER'S leading role as a German enterprise being active in Cutting and Welding and Propane technique.

In the year 2007 Kuno and Detlef Kayser decided to sell the company to an investor, but - very welcome by its customers - KAYSER-WERK GmbH will still work as an independent company in Dortmund.

From 1. July 2011 KAYSER-WERK GmbH also takes over the business of the C. Klein Werk in Schwerte. In 2013, the supply range has been extended to Central Gas Supply components and Special Warm-up Torches.



**made
in
Germany**

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PRESSURE REGULATORS



PRESSURE REGULATOR K10

ACCORDING TO DIN EN ISO 2503

OXYGEN-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14000 0-10 bar

14007 0-2 bar

ACETYLENE-PRESSURE REGULATOR K10, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14100 0-1,5 bar

ARGON/CO₂-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14200 0-30 / 28 l/min

14223 0-2,5 bar

14220 0-10 bar

14801 0-20 bar

14225 0-25 bar

14242 0-30 bar

14227 0-40 bar

NITROGEN-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14430 0-1,5 bar

14431 0-3,5 bar

14400 0-10 bar

14410 0-20 bar

14420 0-25 bar

14425 0-40 bar

PRESSURE REGULATOR K10

ACCORDING TO DIN EN ISO 2503

COMPRESSED AIR-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14505 0-1,5 bar

14500 0-10 bar

14510 0-20 bar

14513 0-30 bar

14511 0-40 bar

HELIUM-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14800 0-10 bar

14801 0-20 bar

FORMING GAS-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Performance**

14700 0-30 l/min

14701 0-50 l/min

FUEL GAS-PRESSURE REGULATOR K10 - METHANE (NATURAL GAS), SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14550 0-1,5 bar

14560 0-10 bar

14562 0-20 bar

14571 0-25 bar

14563 0-40 bar

PRESSURE REGULATOR K10

ACCORDING TO DIN EN ISO 2503

NITROUS OXIDE-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14850 0-10 bar

14851 0-20 bar

PROPANE-PRESSURE REGULATOR K10, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14650 0-3,5 bar

TEST GAS-PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE



Outlet pressure adjustable

Art.-No. **Outlet pressure**

14750 0-2,5 bar

14753 0-4 bar

14760 0-10 bar

14762 0-20 bar

BALLOON FILLING VALVE - 200 BAR



Outlet pressure adjustable

Art.-No. **Type**

16800 Balloon charging valve with gauge

16810 Balloon charging valve without gauge

16820 Balloon charging valve with hand connection

16830 Film adapter for film balloons

16825 Outlet valve, complete

PRESSURE REGULATOR K10

ACCORDING TO DIN EN ISO 2503

BENT VALVE FOR BALLOON GAS - 200 BAR



Art.-No.	Type
CK1320	with cone shaped nozzle
CK1325	with flat nozzle (dispatch with needle)
CK1330	with beveled nozzle

PRESSURE REGULATOR K10 WITH FLOWMETER - 200 BAR, SINGLE STAGE



Art.-No.	Gas type	Performance
14240	Argon	2-9 l/min
14260	Argon/CO ₂	2-16 l/min
14270	Argon/CO ₂	3-30 l/min
14710	Forming gas	3-32 l/min
14711	Forming gas	4-50 l/min
14470	Nitrogen	3-32 l/min

PRESSURE REGULATOR K10 WITH 2 FLOWMETERS - 200 BAR, SINGLE STAGE



Art.-No.	Gas type	Performance
14275	Argon/CO ₂	3-30 l/min
14720	Forming gas	3-32 l/min

PRESSURE REGULATOR K10 WITH FLOWMETER - 300 BAR, SINGLE STAGE

Cylinder connection W 30 x 2 fem. acc. to DIN 477-5

Art.-No.	Gas type	Performance
12245	Argon	2-9 l/min
12265	Argon/CO ₂	5-16 l/min
12275	Argon/CO ₂	7-30 l/min
12715	Forming gas	3-32 l/min
12716	Forming gas	4-50 l/min

PRESSURE REGULATOR K10 / K96

ACCORDING TO DIN EN ISO 2503

PRESSURE REGULATOR K10 - 300 BAR, SINGLE STAGE

Cylinder connection W 30 x 2 fem. acc. to DIN 477-5



Art.-No.	Gas type	Outlet pressure
12225	Argon/CO2	0-10 bar
12205	Argon/CO2	0-28/30 l/min
12405	Nitrogen	0-10 bar
12410	Nitrogen	0-20 bar
12420	Nitrogen	0-25 bar
12425	Nitrogen	0-40 bar
12505	Compressed air, G3/8"	0-10 bar
12510	Compressed air, G3/8"	0-20 bar
12565	Hydrogen	0-10 bar
12765	Test gas	0-10 bar
12705	Forming gas	0-30 l/min
12707	Forming gas	0-50 l/min
12605	Helium	0-10 bar

PRESSURE REGULATOR K10 - 200 BAR, SINGLE STAGE, WITH METAL DIAPHRAGM, CHROMED



For non corrosive pure gas

Art.-No.	Gas type	Outlet pressure
14050	Nitrogen	0-10 bar
14052	Argon/CO2	0-10 bar

PRESSURE REGULATOR K96 - STAINLESS STEEL, SINGLE STAGE

Regulator housing: Stainless steel 1.4401
 Housing seal: Viton-A
 Diaphragm: Stainless steel 1.4310
 Seat: PVDF / Teflon
 Sealing cone: Stainless steel 1.4401

Gas inlet temperature: max. 150° C (for type H)
 Safety valve: built-in
 Gas inlet temperature: max. 205° C (for type L)
 Filter: Hastelloy
 Connection thread: 1/4" NPT



Art.-No.	Inlet pressure	Outlet pressure	Consumption (N2) at 210 bar-70 bar
11600	210 / 70 bar	0-1,5 bar	10 Nm ³ /h - 10 Nm ³ /h
11610	210 / 70 bar	0-3,5 bar	18 Nm ³ /h - 18 Nm ³ /h
11620	210 / 70 bar	0-7 bar	36 Nm ³ /h - 36 Nm ³ /h
11630	210 / 70 bar	0-15 bar	86 Nm ³ /h - 65 Nm ³ /h
11640	210 / 70 bar	0-30 bar	152 Nm ³ /h - 65 Nm ³ /h

PRESSURE REGULATOR

SPARE PART SEALING



Art.-No.	Abmessung	Application
1475020	14 x 9 x 2,2 mm	Cylinder connection Test gas
651045	15,8 x 9 x 2 mm	Cylinder connection Acetylene
1400020	18,4 x 11,6 x 2,5 mm	Cylinder connection andere gases
1400002	10 x 5,3 x 3,7 mm	Aludichtung
548900002011P	7,65 x 1,78 mm	O-Ring 300 bar

KAYSER INFORMATION: CYLINDER CONNECTIONS 200 BAR

For 200 bar cylinders acc. to DIN 477 - part 1

Gas type	Cylinder connection	Connection type	DIN 477 No.
Acetylene	—	Clamp connection	3
Argon/CO2	W 21,80 x 1/14"	Swivel nut	6
Compressed Air	G 5/8"	Male thread	13
Forming Gas	W 21,80 x 1/14" LH	Swivel nut	1
Helium	W 21,80 x 1/14"	Swivel nut	6
Hydrogen	W 21,80 x 1/14" LH	Swivel nut	1
Nitrogen	W 24,32 x 1/14"	Swivel nut	10
Oxygen	G 3/4"	Swivel nut	9
Propane	W 21,80 x 1/14" LH	Swivel nut	1
Test Gas	M 19 x 1,5 LH	Swivel nut	14

PRESSURE REGULATOR 97

According to DIN EN ISO 2503

HIGH PRESSURE REGULATOR K97 - 300 BAR, SINGLE STAGE

Standard outlet: 12 mm tube fitting, with safety valve, connection W 30 x 2 fem. acc. to DIN 477-5



Art.-No.	Gas type	Outlet pressure
11000	Argon	0-100 bar
11010	Compressed air*	0-100 bar
11020	Natural gas	0-100 bar
11030	Helium	0-100 bar
11042	Nitrogen	0-50 bar
11040	Nitrogen	0-100 bar
11050	Hydrogen	0-100 bar
11060	Test gas	0-100 bar
11100	Argon	0-200 bar
11110	Compressed air*	0-200 bar
11120	Natural gas	0-200 bar
11130	Helium	0-200 bar
11140	Nitrogen	0-200 bar
11150	Hydrogen	0-200 bar
11160	Test gas	0-200 bar

*Connection DIN (G 5/8" pressureschraube)

HIGH PRESSURE REGULATOR K97 - 200 BAR, SINGLE STAGE

Standard outlet: 12 mm tube fitting, with safety valve, connection DIN 477-1



Art.-No.	Gas type	Outlet pressure
11200	Argon	0-100 bar
11210	Compressed air	0-100 bar
11220	Natural gas	0-100 bar
11230	Helium	0-100 bar
11243	Nitrogen	0-50 bar
11240	Nitrogen	0-100 bar
11250	Hydrogen	0-100 bar
11300	Argon	0-200 bar
11310	Compressed air	0-200 bar
11320	Natural gas	0-200 bar
11330	Helium	0-200 bar
11348	Nitrogen	0-150 bar
11340	Nitrogen	0-200 bar
11350	Hydrogen	0-200 bar

ECOMAT 2000

ECOMAT 2000



Argon/CO₂-Pressure regulator with flowmeter and integrated gas saver

Art.-No.		Working pressure
17000	Cylinder pressure regulator bis 200 bar	3-30 l/min
17001	Cylinder pressure regulator bis 300 bar	3-30 l/min
17002	Cylinder pressure regulator bis 200 bar	2-16 l/min
17010	Point-of-use Pressure regulator	3-30 l/min
17011	Point-of-use Pressure regulator	2-16 l/min

KAYSER INFORMATION: GAS AND MONEY SAVING WITH ECO 2000

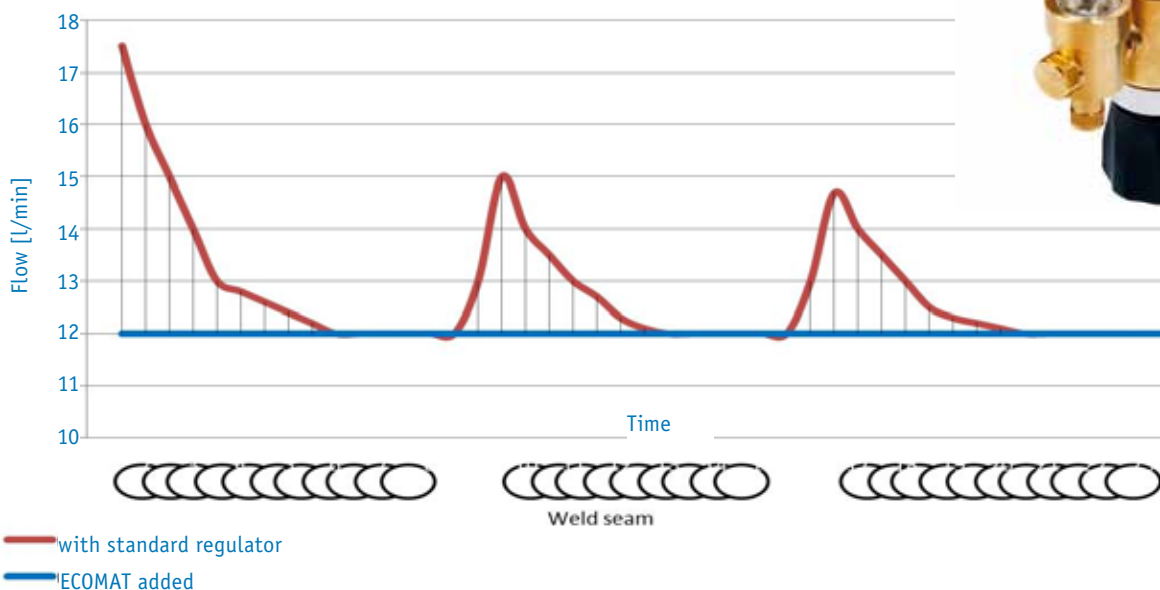
The ECOMAT 2000 is a pressure regulator with built-in gas saving device and flowmeter. It was developed to achieve a huge savings with inert gas welding (MIG / MAG, etc.). The device was developed from proven KAYSER parts and is produced in Dortmund. Gas savings achieved with reach the 50% level.

In TIG and MIG / MAG welding mostly single stage pressure regulators with or without flowmeters are used. If after the welding operation the solenoid valve of the welding system closes, an excess pressure between welding device and pressure regulator will be created. If thereafter the

welding process will be started again, this expensive pressurized gas volume will be lost unused. Applying ECOMAT 2000 pressure building is reduced to a minimum.

Resulting gas saving volumes are great. Examinations with spot and stitch welding show cost savings up to 50 %.

The ECOMAT 2000 ensures a constant gas flow during the entire welding process. The hose congestion pressure between welding device and regulator will never be build again.



POINT-OF-USE REGULATORS K10 / SETS

ACCORDING TO DIN EN ISO 2503

POINT-OF-USE REGULATOR K10, SINGLE STAGE



Inlet non flammable gases : G 3/8" - outlet G 1/4"

Inlet flammable gases : G 3/8" LH - outlet G 3/8" LH

Art.-No.	Gas type	Outlet pressure
15000	Oxygen	0-10 bar
15002	Oxygen	0-20 bar
15100	Acetylene	0-1,5 bar
15200	Argon/CO2	0-32/28 l/min
15210	Carbon dioxide	0-10 bar
15550	Hydrogen	0-10 bar
15400	Nitrogen	0-10 bar
15410	Nitrogen	0-20 bar
15650	Propane	0-3,5 bar
15500	Compressed air	0-10 bar
15700	Forming gas	0-30 l/min
15701	Forming gas	0-50 l/min

POINT-OF-USE REGULATOR K10 WITH FLOWMETER



Inlet non flammable gases : G 3/8" - outlet G 1/4"

Inlet flammable gases : G 3/8" LH - outlet G 3/8" LH

Art.-No.	Gas type	Outlet pressure
15230	Argon	2-9 l/min
15250	Argon/CO2	2-16 l/min
15260	Argon/CO2	3-30 l/min
15310	Forming gas	2-16 l/min
15320	Forming gas	4-50 l/min

POINT-OF-USE SET



Inlet 12mm welded nipple/ soldering bush,
outlet G 3/8" / G3/8" LH

Art.-No.	Gas type
59510	1er Set LH
59511	1er Set RH
59521	2er Set 1 x RH, 1 x LH
59522	2er Set 2 x LH
59523	2er Set 2 x RH
59531	3er Set 1 x LH, 2 x RH
59532	3er Set 2 x LH, 1 x RH
59534	3er Set 3 x RH
59535	3er Set 3 x LH
59540	4er Set 1 x LH, 3 x RH

PRESSURE REGULATOR ACCESSORY

PROTECTING GRID / PROTECTING CAP



Art.-No.		Color
18110	Protecting grid for Manometer	blue
18120	Protecting grid for Manometer	yellow
18130	Protecting grid for Manometer	grey
18210	Rubber protecting cap for Ø 63 mm	blue
18220	Rubber protecting cap for Ø 63 mm	yellow
18230	Rubber protecting cap for Ø 63 mm	red
18240	Rubber protecting cap for Ø 63 mm	grey
18250	Rubber protecting cap for Ø 63 mm	black

GAUGES ACC. TO ISO 5171

Diameter 63 mm, Connection G1/4"



Art.-No.	Gas type	Indicating range
18630	Acetylene	2,5/1,5 bar
18520	Acetylene	40/26 bar
18650	Argon/CO2	0-30/28 l min
18640	neutral	0-30 l/min
18641	neutral	0-50 l/min
18680	neutral	2,5/1,5 bar
18681	neutral	6/3,5 bar
18670	neutral	16/10 bar
18560	neutral	40/20 bar
18684	neutral	60/40 bar
18683	neutral	100/50 bar
18682	neutral	160/100 bar
18550	neutral	315/200 bar
18561	neutral	400/300 bar
18610	Oxygen	16/10 bar
18620	Oxygen	40/20 bar
18510	Oxygen	315/200 bar

1400002 Alu sealing

GAS PREHEATING DEVICE 200 BAR - 230 V / 25 W

Only for single cylinders suitable, connecting plug not included.
Electric heating.



Art.-No.	
66150	for Oxygen
66155	for Argon/Carbon Dioxide

PRESSURE REGULATOR ACCESSORY

FLOWMETER



Art.-No.	Gas type	Indicating range
66450	Argon/CO2	3 - 25 l/min

SOLDERING- AND WELDING NIPPLES



Art.-No.	Connection	Ø mm	Brass	Steel
59500	3/8"	12 outer	X	
59501	1/2"	14 outer	X	
59502	3/4"	15 inner	X	
59503	3/8"	12		X
59504	1/2"	14		X
59505	3/4"	15		X

HOSE NOZZLES, ACCORDING TO DIN EN 560

Other dimension available on demand



Art.-No.	Connection
65001	for G 1/4" x 4 mm
65002	for G 1/4" x 6 mm
65003	for G 1/4" x 9 mm
65010	for G 3/8" x 4 mm
65011	for G 3/8" x 6 mm
65012	for G 3/8" x 9 mm
65020	for G 1/2" x 6 mm
65021	for G 1/2" x 9 mm

SWIVEL NUT, ACCORDING TO DIN EN 560



Art.-No.	Connection
65049	G 1/4" (for nozzle 9 mm)
65050	G 1/4"
65051	G 1/4" LH
65060	G 3/8"
65062	G 3/8" LH
65070	G 1/2"
65071	G 1/2" LH
65073	G 3/4"
65083	G 3/4" LH

SAFETY DEVICE

SAFETY DEVICE, FOR CONNECTION AT PRESSURE REGULATOR

Acc. to ISO 5175, with non return valve, flame arrestor as well as of a temperature sensitive cutoff valve.



Art.-No.	Gas type	Type	Working pressure	Inlet	Outlet
64030	Fuel gas	1	max. 5 bar	G3/8" LH fem.	G3/8" LH male
64031	Fuel gas	1	max. 5 bar	G1/2" LH fem.	G1/2" LH male
64032	Fuel gas	1	max. 5 bar	G1/2" LH fem.	G3/8" LH male
64035	Oxygen	1	max. 20 bar	G1/4" fem.	G1/4" male
64036	Oxygen	1	max. 20 bar	G3/8" fem.	G3/8" male
64037	Oxygen	1	max. 20 bar	G1/2" fem.	G1/2" male

Oxygen

P1 = 5 bar

P2 = 3,5 bar = 34 m³/h flow

Fuel gas

P1 = 1,5 bar

P2 = 0,9 bar = 10,5 m³/h flow



64000	Fuel gas	2	max. 5 bar	G3/8" LH fem.	G3/8" LH male
64001	Oxygen	2	max. 20 bar	G1/4" fem.	G1/4" male
64005	Oxygen	2	max. 20 bar	G3/8" fem.	G3/8" male

Oxygen

P1 = 5 bar

P2 = 3,5 bar = 24 m³/h flow

Fuel gas

P1 = 1,5 bar

P2 = 0,9 bar = 6,5 m³/h flow

SAFETY DEVICE, FOR CONNECTION AT SHANK

Acc. to ISO 5175, with non return valve and flame arrestor



Art.-No.	Gas type	Type	Working pressure	Inlet	Outlet
64050	Fuel gas	3	max. 5 bar	nozzle 9 mm	G3/8" LH fem.
64051	Oxygen	3	max. 20 bar	nozzle 6,3 mm	G1/4" fem.
64052	Fuel gas	3	max. 5 bar	nozzle 6,3 mm	G3/8" LH fem.
64060	Fuel gas	3	max. 5 bar	G3/8" LH male	G3/8" LH fem.
64061	Oxygen	3	max. 20 bar	G1/4" male	G1/4" fem.
64067	Oxygen	3	max. 20 bar	G3/8" male	G3/8" fem.

Oxygen

P1 = 5 bar

P2 = 4 bar = 7 m³/h flow

Fuel gas

P1 = 0,6 bar

P2 = 0,3 bar = 2 m³/h flow

Attention:

The above pressure drop and flow rate data show that safety valves are only of limited use. For welding tips size. 7 & 8 as well as large heating torch safety device must be used.

NON RETURN VALVES

NON RETURN VALVE

Acc. to ISO 7289



Art.-No.	Connection
08635W61	1/4"
0863562	1/4" LH
0863563	3/8"
203011054P	3/8" LH

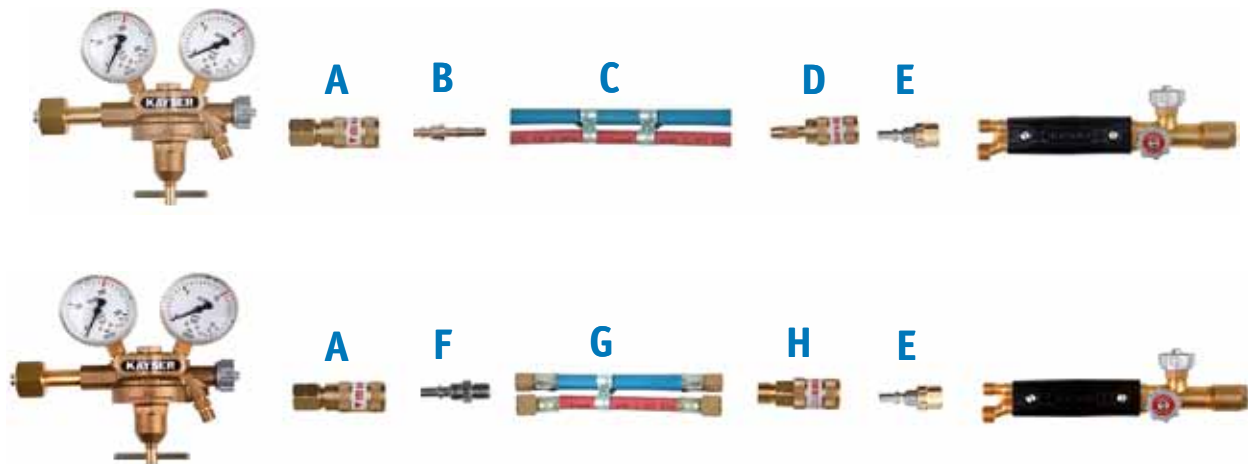
KAYSER INFORMATION: EXAMINATION REQUIREMENT FOR FLASHBACK

The law requires 1x annual testing of safety devices acc. BG R500 Section 2:26 Section 3:27 by a qualified person (proficiency level 2)

- No leaks
- On security against reverse gas flow
- In Flow

This test must be documented by the user.

KAYSER INFORMATION: COMBINATIONS COUPLINGS



- | | |
|--|-------------------------------|
| A) Quick coupling for pressure regulator | E) Shank coupling |
| B) Hose splicers | F) Hose tail pieces |
| C) Hoses unfitted | G) Hoses fitted |
| D) Coupling for unfitted hoses | H) Couplings for fitted hoses |

By appropriate couplings and pins hoses can be quickly connected and extended in this way.

QUICK COUPLING

COUPLING PINS STAINLESS STEEL

Acc. to ISO 7289. Marking: 1 stripe = Oxygen, 2 stripes = Fuel gas, 3 stripes = Neutral gases



Art.-No.	Gas	Inlet	Application
64196	Oxygen	G1/4" fem.	shank
64296	Fuel gas	G3/8" LH fem.	shank
64396	Neutral gases	G1/4" fem.	device
64195	Oxygen	Nozzle 6 mm	unfitted hose
64194	Oxygen	Nozzle 4 mm	unfitted hose
64295	Fuel gas	Nozzle 8 mm	unfitted hose
64294	Fuel gas	Nozzle 4 mm	unfitted hose
64293	Fuel gas	Nozzle 6 mm	unfitted hose
64330	Neutral gases	Nozzle 6 mm	unfitted hose
64300	Oxygen	G1/4" male	fitted hoses
64310	Fuel gas	G3/8" LH male	fitted hoses
64320	Neutral gases	G1/4" male	fitted hoses

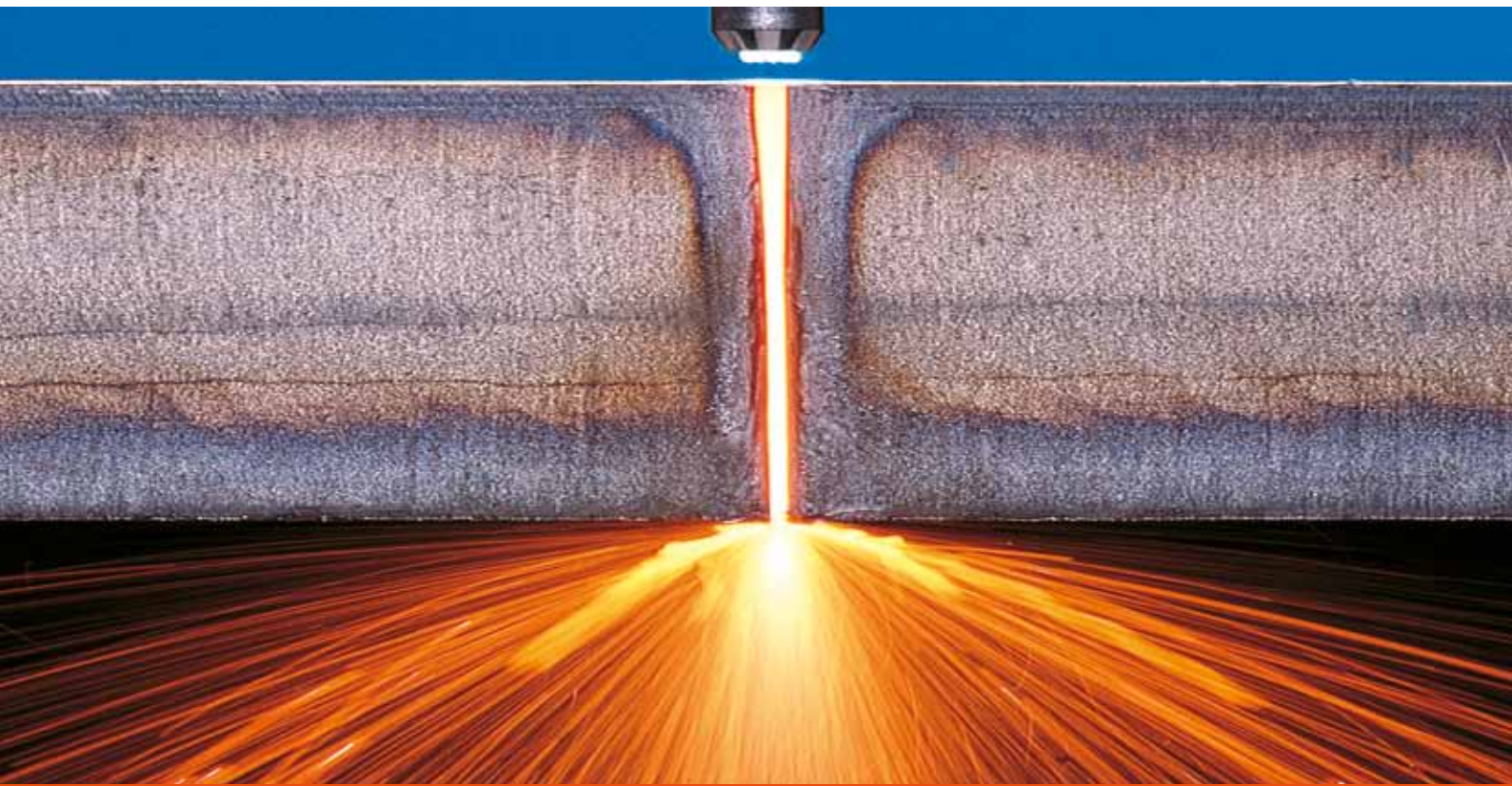
QUICK COUPLING WITH AUTOMATIC CUTOFF

Acc. to ISO 7289.



Art.-No.	Gas	Inlet	Application
64105	Oxygen	Nozzle 6 mm	unfitted hose
64305	Neutral gases	Nozzle 6 mm	unfitted hose
64205	Fuel gas	Nozzle 9 mm	unfitted hose
64207	Fuel gas	Nozzle 11 mm	unfitted hose
64208	Fuel gas	Nozzle 6 mm	unfitted hose
64110	Oxygen	G1/4" male	fitted hoses
64210	Fuel gas	G3/8" LH male	fitted hoses
64215	Neutral gases	G1/4" male	fitted hoses
64600	Oxygen	G1/4" male	pressure regulator
64610	Fuel gas	G3/8" LH male	pressure regulator
64620	Neutral gases	G1/4" male	pressure regulator

CUTTING AND WELDING EQUIPMENT



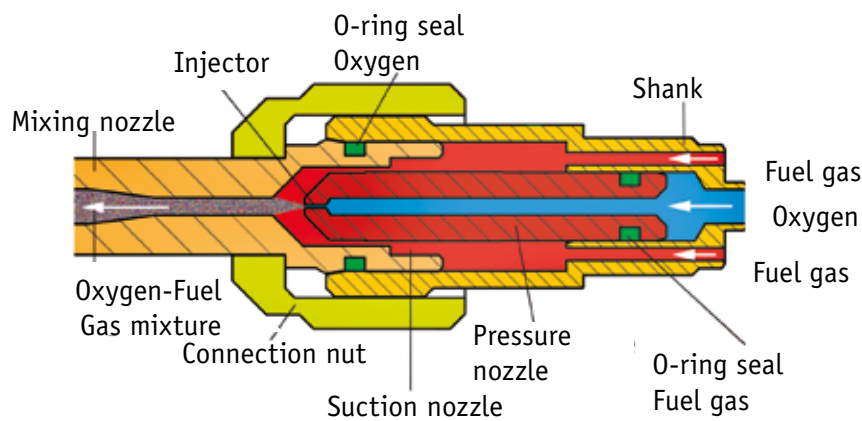
CUTTING AND WELDING SYSTEM KM15

ACC. TO EN ISO 5172

KAYSER PRESENTS: THE NEW CUTTING AND WELDING SET KM15

ADVANTAGES OF THE NEW KAYSER LIGHT METAL GRIP

- Low weight and excellent handling
- Production according to the latest technical and ergonomic aspects
- The monoblock valves and the torch connection made of brass for long life
- Advantages of chromed welding tube nozzles with hammered tips
- With the chrome plating a very good heat dissipation is guaranteed
- High flash back insensitivity
- Having a nozzle defect the tip might be shortened due to the great gas discharge channel length more than 2 mm
- The slim design ensures good visibility and accessibility for all welding work
- Long service life through high copper quality
- Chromed tube nozzles are not more expensive than conventional copper tips.



WORK RULES

- a. Choose a welding tip, depending on the material thickness.
- b. Adjust the Oxygen quantity according to markings on pressure regulator. The Acetylene pressure is adjusted between 0.2 and 0.7 bar.
- c. First open the Oxygen then the Fuel gas valve.
- d Close the torch valves after working in reverse order.

The 2-fold O-ring seal ensures optimum safety. Even when the swivel nut wa's not not tightened firmly the overflow of Oxygen into the fuel gas supply passage is excluded.

CUTTING AND WELDING SYSTEMV KM15

ACC. TO EN ISO 5172



BOXED CUTTING AND WELDING SET KM15

Oxygen - Acetylene

Consisting of: shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box



Spring lever-cutting tube nozzle with AR nozzles

22100 for welding 0,5 - 14 mm, for cutting 3 - 100 mm



Spring lever-cutting tube nozzle with AGN nozzles

22101 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

23140 sheet steel box empty

SHANK KM15



Art.-No.

22200 shank with connection nut

2220001 connection nut

SPRING LEVER CUTTING ATTACHMENT KM15

Without nozzles



Art.-No.

22301 for gas mixing AGN, PNME nozzles

22300 for AR, ARS nozzles

22302 for block nozzles

Suitable nozzles please see page 63.

CUTTING AND WELDING SYSTEM KM15

ACC. TO EN ISO 5172

WELDING SWAGED NOZZLES KM15

Oxygen - Acetylene



Art.-No.	Size		Acetylene cons. [m3/h]	Oxygen cons. [m3/h]
22400	0	0,2 - 0,5 mm	0,075	0,08
22401	1	0,5 - 1 mm	0,075	0,08
22402	2	1 - 2 mm	0,15	0,16
22403	3	2 - 4 mm	0,30	0,315
22404	4	4 - 6 mm	0,475	0,5
22405	5	6 - 9 mm	0,75	0,8
22406	6	9 - 14 mm	1,15	1,25

HEATING SWAGED NOZZLES KM15

with multi hole copper tip



Art.-No.	Size	
22407	3	2 - 4 mm
22408	4	4 - 6 mm

TUBE NOZZLES KM15

Cu-tube \varnothing 6 mm, pliable



Art.-No.	Size	
22502	2	1 - 2 mm
22503	3	2 - 4 mm
22504	4	4 - 6 mm
22505	5	6 - 9 mm

TUBE NOZZLES FRONT PARTS KM15

Cu-tube \varnothing 6 mm, pliable



Art.-No.	Size	
22532	2	1 - 2 mm
22533	3	2 - 4 mm
22534	4	4 - 6 mm
22535	5	6 - 9 mm

CUTTING AND WELDING SYSTEM KM15

ACC. TO EN ISO 5172

COPPER NOZZLES KM15

For swaged nozzles (old design, not for chromed versions)



Art.-No.	Size	
2240001	0	0,2 - 0,5 mm
2240101	1	0,5 - 1 mm
2240201	2	1 - 2 mm
2240301	3	2 - 4 mm
2240401	4	4 - 6 mm
2240501	5	6 - 9 mm
2240601	6	9 - 14 mm

MULTIHOLE COPPER NOZZLES KM15

For warming tips



Art.-No.	Size	
2240701	3	2 - 4 mm
2240801	4	4 - 6 mm

WELDING SWAGED NOZZLES KM15, CHROMED

Thread 1-5 - W 5/16" x 32 Gg, thread 6 - 6 M 9 x 1



Art.-No.	Size	
14081221	1	0,5 - 1 mm
14081222	2	1 - 2 mm
14081223	3	2 - 4 mm
14081224	4	4 - 6 mm
14081225	5	6 - 9 mm
9389870	6	9 - 14 mm

CUTTING AND WELDING SYSTEM KM17

ACCORDING TO EN ISO 5172



SET BOX KM17 A



Oxygen - Acetylene

connection A consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box with AR nozzles

Spring lever cutting attachment with short shaft

23100 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

23101 for welding 0,5 - 30 mm, for cutting 3 - 100 mm

Spring lever cutting attachment with long spindle

23130 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

23131 for welding 0,5 - 30 mm, for cutting 3 - 100 mm

SET BOX KM17 B (BAYONET)



Oxygen - Acetylene

Connection B consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box with AR nozzles

Spring lever cutting attachment with short shaft

24100 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

24101 for welding 0,5 - 30 mm, for cutting 3 - 100 mm

Spring lever cutting attachment with long spindle

24130 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

24131 for welding 0,5 - 30 mm, for cutting 3 - 100 mm

23140 sheet steel box empty

SHANKS KM17



Connection A

23200 shank with connection but

2320001 connection but

Connection B

24200 shank with connection but

2420001 connection but

CUTTING AND WELDING SYSTEM KM17

ACCORDING TO EN ISO 5172

SPRING LEVER CUTTING ATTACHMENT KM17



Oxygen - Acetylene
with short spindle

For connection A

23300 without nozzles

23301 with cutting and welding nozzle AR H1 + S2

For connection B

24300 without nozzles

24301 with cutting and welding nozzle AR H1 + S2

SPRING LEVER CUTTING ATTACHMENT KM17



Oxygen - Acetylene
with long spindle

For connection A

23310 without nozzles

23311 with cutting and welding nozzle AR H1 + S2

For connection B

24310 without nozzles

24311 with cutting and welding nozzle AR H1 + S2

HOLE CUTTING ATTACHMENT KM17



Oxygen - Acetylene
with long spindle

For connection A

23321 für block nozzles, without nozzles

23320 with cutting and welding nozzle AR H1 + S2

For connection B

24420 with cutting and welding nozzle AR H1 + S2

FLAT HEADED CUTTING ATTACHMENT KM17



Oxygen - Acetylene
with short spindle

For connection A

23330 with cutting and welding nozzle FK H1 + S2

For connection B

24330 with cutting and welding nozzle FK H1 + S2

CUTTING AND WELDING SYSTEM KM17

ACC. TO EN ISO 5172

FLACHKOPF CUTTING ATTACHMENT KM17

Oxygen - Acetylene

With long spindle



Connection B

24335 with cutting and welding nozzle FK H1 + S2

SPRING LEVER-CUTTING ATTACHMENT KM17

Oxygen - Acetylene

Connection A

23340 for AR / ARS nozzles without nozzles

23343 for AGN nozzles without nozzles

23344 with cutting and welding nozzle AR H1 + S2



Connection B

24345 for AR / ARS nozzles, without nozzles

24341 for block nozzles AB, without nozzles

24340 with cutting and welding nozzle AR H1 + S2

WELDING SWAGED NOZZLES KM17

Oxygen - Acetylene

Connection A



Art.-No.	Size		Cons. [m3/h]	Cons. [m3/h]
23401	1	0,5 - 1 mm	0,075	0,08
23402	2	1 - 2 mm	0,15	0,16
23403	3	2 - 4 mm	0,30	0,315
23404	4	4 - 6 mm	0,475	0,5
23405	5	6 - 9 mm	0,75	0,8
23406	6	9 - 14 mm	1,15	1,25
23407	7	14 - 20 mm	1,70	1,8
23408	8	20 - 30 mm	2,50	2,6

Connection B



Art.-No.	Size		Cons. [m3/h]	Cons. [m3/h]
24401	1	0,5 - 1 mm	0,075	0,08
24402	2	1 - 2 mm	0,15	0,16
24403	3	2 - 4 mm	0,30	0,315
24404	4	4 - 6 mm	0,475	0,5
24405	5	6 - 9 mm	0,75	0,8
24406	6	9 - 14 mm	1,15	1,25
24407	7	14 - 20 mm	1,70	1,8
24408	8	20 - 30 mm	2,50	2,6

CUTTING AND WELDING SYSTEM KM17

ACC. TO EN ISO 5172

HEATING SWAGED NOZZLES KM17

with multi hole copper tip



Connection A **Size**

23409 3 2 - 4 mm

23410 4 4 - 6 mm

Connection B **Size**

24409 3 2 - 4 mm

24410 4 4 - 6 mm

TUBE NOZZLES KM17

Connection \varnothing 17mm, Cu-tube \varnothing 6 mm, pliable



Connection A **Size**

23502 2 1 - 2 mm

23503 3 2 - 4 mm

23504 4 4 - 6 mm

23505 5 6 - 9 mm



Connection B **Size**

24502 2 1 - 2 mm

24503 3 2 - 4 mm

24504 4 4 - 6 mm

24505 5 6 - 9 mm

TUBE NOZZLES FRONT PART KM17

Cu-tube \varnothing 6 mm, pliable



Art.-No. **Size**

23532 2 1 - 2 mm

23533 3 2 - 4 mm

23534 4 4 - 6 mm

23535 5 6 - 9 mm

CUTTING AND WELDING SYSTEM KM17

ACC. TO EN ISO 5172

COPPER TIPS KM17

for welding tips



Art.-No.	Size	Range
2340101	1	0,5 - 1 mm
2340201	2	1 - 2 mm
2340301	3	2 - 4 mm
2340401	4	4 - 6 mm
2340501	5	6 - 9 mm
2340601	6	9 - 14 mm
2340701	7	14 - 20 mm
2340801	8	20 - 30 mm

MULTI HOLE COPPER TIP KM17

for heating tips



Art.-No.	Size	Range
2340901	3	2 - 4 mm
2341001	4	4 - 6 mm

CUTTING AND WELDING SYSTEM KM17

ACC. TO EN ISO 5172

PREHEATING TORCH KM17 - ACETYLENE

With Material copper

Connection A



Art.-No.	Size		Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
23420	7	14 - 20 mm	0,5	2,5	1,7	1,8
23421	8	20 - 30 mm	0,5	3,0	2,5	2,6
23422	9	30 - 50 mm	0,5	3,0	4,0	4,2

Connection B

Art.-No.	Size		Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
24600	7	14 - 20 mm	0,5	2,5	1,7	1,8
24601	8	20 - 30 mm	0,5	3,0	2,5	2,6
24602	9	30 - 50 mm	0,5	3,0	4,0	2,2

SPARE PART PREHEATING NOZZLES KM17 - ACETYLENE

Material copper



Art.-No.	Size	
2460011	7	14 - 20 mm
2460111	8	20 - 30 mm
2460211	9	30 - 50 mm

PREHEATING TORCH KM17 - PROPANE

With copper nozzle



Art.-No.	Size		Fuel gas pressure	O2 press.	Fuel gas cons.	O2 cons.
23414	7	14 - 20 mm	0,3	3,5	1,8	6,0
23415	8	20 - 30 mm	0,3	4,0	2,6	8,5
23416	9	30 - 50 mm	0,5	4,0	4,0	13,0

Art.-No.	Size		Fuel gas pressure	O2 press.	Fuel gas cons.	O2 cons.
24650	7	14 - 20 mm	0,3	3,5	1,8	6,0
24651	8	20 - 30 mm	0,3	4,0	2,6	8,5
24652	9	30 - 50 mm	0,5	4,0	4,0	13,0

CUTTING AND WELDING SYSTEM KM17

ACC. TO EN ISO 5172

SPARE PART PREHEATING NOZZLES KM17 - PROPANE

Material copper



Art.-No.	Size	
2465011	7	14 - 20 mm
2465111	8	20 - 30 mm
2465211	9*	30 - 50 mm

head wird angelötet

HEAVY DUTY PREHEATING ATTACHMENT KM17 - ACETYLENE



Art.-No.	Size	Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
23640	12	0,5	2,5	3,75	3,8
23645	13	0,5	2,5	4,3	4,4

SPARE PART HEAVY DUTY PREHEATING NOZZLE KM17 - ACETYLENE

Material copper



Art.-No.	Size
2364012	12
2364013	13

Please kepp in mind:

Using torches with an Acetylene consumption of more than 1 m³/h several cylinders have to be coupled.

The maximum consumption per cylinder is limited to 1 m³/h. Matching cylinder couplings can be found in our catalog on „Central gas supply“.

CUTTING AND WELDING SYSTEM KE17

ACC. TO EN ISO 5172



SET BOX KE17



Oxygen - Acetylene

Consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box, spring lever-cutting tube nozzle

Art.-No.

25100 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

25101 for welding 0,5 - 30 mm, for cutting 3 - 100 mm

SET BOX KE17



Oxygen - Acetylene

Consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box, spring lever-cutting tube nozzle

Art.-No.

25120 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

25121 for welding 0,5 - 30 mm, for cutting 3 - 100 mm

23140 sheet steel box empty

MINI SET BOX (KE17)



Oxygen - Acetylene

consisting of:

shank, cleaning needles, torch wrench, sheet steel box, spring lever - cutting tube nozzle

Art.-No.

25131 for welding 0,5 - 9 mm, for cutting 3 - 100 mm

25135 sheet steel box empty

CUTTING AND WELDING SYSTEM KE17

ACC. TO EN ISO 5172

SET BOX KE17



Oxygen - Acetylene

Consisting of: Pressure regulator Oxygen and Acetylene, safety device for Oxygen and Acetylene, 10m hose, welding goggle, nozzle cleaning needle set, torch wrench, clamp enlighter, welding gloves, spring lever-cutting tube nozzle with AR nozzles, swaged nozzles, heating attachment

Art.-No.

25141 for welding 0,5 - 14 mm, for cutting 3 - 100 mm

SHANK KE17



Art.-No.

25200 shank with connection nut

2320001 connection nut

SPRING LEVER CUTTING ATTACHMENT KE17

Oxygen - Acetylene



Art.-No.

25300 without nozzles

25301 with cutting and welding nozzle KE H1 + S2

25304 for block nozzles AB, without nozzles

SPRING LEVER CUTTING ATTACHMENT KE17

Oxygen - Acetylene



Art.-No.

25340 with cutting and welding nozzle KE H1 + S2

25341 for block nozzles AB, without nozzles

CUTTING AND WELDING SYSTEM KE17

ACC. TO EN ISO 5172

WELDING SWAGED NOZZLES KE17

Oxygen - Acetylene



Art.-No.	Size		Acetylene- cons. [m3/h]	Oxygen cons. [m3/h]
25401	1	0,5 - 1 mm	0,075	0,08
25402	2	1 - 2 mm	0,15	0,16
25403	3	2 - 4 mm	0,30	0,315
25404	4	4 - 6 mm	0,475	0,5
25405	5	6 - 9 mm	0,75	0,8
25406	6	9 - 14 mm	1,15	1,25
25407	7	14 - 20 mm	1,70	1,8
25408	8	20 - 30 mm	2,50	2,6

HEATING SWAGED NOZZLES KE17

With multi hole copper tip



Art.-No.	Size	
25409	3	2 - 4 mm
25410	4	4 - 6 mm

TUBE NOZZLES KE17

Cu-tube ø 6 mm, pliable



Art.-No.	Size	
25502	2	1 - 2 mm
25503	3	2 - 4 mm
25504	4	4 - 6 mm
25505	5	6 - 9 mm

TUBE NOZZLES FRONT PARTS KE17

Cu-tube ø 6 mm, pliable



Art.-No.	Size	
25532	2	1 - 2 mm
25533	3	2 - 4 mm
25534	4	4 - 6 mm
25535	5	6 - 9 mm

CUTTING AND WELDING SYSTEM KE17

ACC. TO EN ISO 5172

COPPER NOZZLE KE17

For welding tips



Art.-No.	Size
2140101	1 0,5 - 1 mm
2140201	2 1 - 2 mm
2140301	3 2 - 4 mm
2540401	4 4 - 6 mm
2540501	5 6 - 9 mm
2540601	6 9 - 14 mm
2540701	7 14 - 20 mm
2540801	8 20 - 30 mm

MULTIHOLE COPPER NOZZLE KE17

For heating tips



Art.-No.	Size
2540901	3 2 - 4 mm
2541001	4 4 - 6 mm

PREHEATING TORCH KE17 - ACETYLENE

With Material copper



Art.-No.	Size	Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
23420	7 14 - 20 mm	0,5	2,5	1,7	1,8
23421	8 20 - 30 mm	0,5	3,0	2,5	2,6
23422	9 30 - 50 mm	0,5	3,0	4,0	4,2

SPARE PART PREHEATING NOZZLES KE17 - ACETYLENE

Material copper



Art.-No.	Size
2460011	7 14 - 20 mm
2460111	8 20 - 30 mm
2460211	9* 30 - 50 mm



head to be soldered

CUTTING AND WELDING SYSTEM KE17

ACC. TO EN ISO 5172

PREHEATING TORCH KE17 - PROPANE

With nozzle material copper



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
23414	7	14 - 20 mm	0,3	3,5	1,8	6,0
23415	8	20 - 30 mm	0,3	4,0	2,6	8,5
23416	9	30 - 50 mm	0,5	4,0	4,0	13,0

SPARE PART PREHEATING TORCH KE17 - PROPANE

Material copper



Art.-No.	Size	
2465011	7	14 - 20 mm
2465111	8	20 - 30 mm
2465211	9	30 - 50 mm

HEAVY DUTY PREHEATING ATTACHMENT KE17 - ACETYLENE



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
23640	12		0,5	2,5	3,75	3,8
23645	13		0,5	2,5	4,3	4,4

SPARE PART PREHEATING NOZZLE KE17 - ACETYLENE

Material copper



Art.-No.	Size
2364012	12
2364013	13

Please keep in mind:

Using torches with an Acetylene consumption of more than 1 m³/h several cylinders have to be coupled.

The maximum consumption per cylinder is limited to 1 m³/h. Matching cylinder couplings can be found in our catalog on „Central gas supply“.

SOLDERING AND CUTTING SYSTEM KEP17

ACC. TO EN ISO 5172

BOXED SOLDERING SET KEP17



Oxygen - Propane

Consisting of: shank, torch wrench, mini pressure regulator without gauge with combi connection, sheet steel box, 5 soldering tips 0,5-9 mm, 1 soldering tip pliable 2-4 mm

Art.-No.

25150 for brazing 0,5 - 9 mm

BOXED SOLDERING AND CUTTING SET KEP17



Oxygen - Propane

Consisting of: shank, torch wrench, mini pressure regulator without gauge with combi connection, sheet steel box, 5 soldering tips 0,5-9 mm, 1 soldering tip pliable 2-4 mm, spring lever-cutting tube nozzle, PR-nozzles 3-100

Art.-No.

25151 for brazing 0,5 - 9 mm, for cutting 3-100 mm

25135 sheet steel box empty

KAYSER INFORMATION: SET KEP17 FOR PROPANE / NATURAL GAS - OXYGEN

Ideal set for brazing, where higher flame temperatures are required. With the Propane-Oxygen flame temperatures can be reached up to about 2800 °C.

The Nozzles design of the solder and heat tps generates a tapered, concentric primary flame. The past primary flame causes additional protection from the atmosphere.

Another advantage: For torch cutting the low cost gas Propane or Natural gas can be used.

This alternative applies for flame cutting and soldering!

- Ideal for brazing
- For higher flame temperatures up to 2800 ° C
- Tapered, centric primary flame
- Added protection from the atmosphere

SOLDERING AND CUTTING SYSTEM KEP17

ACC. TO EN ISO 5172

SHANK KEP17

Oxygen-Propane



Art.-No.

25250 shank with connection nut

2320001 connection nut

SPRING LEVER CUTTING ATTACHMENT KEP17

Oxygen-Propane



Art.-No.

25350 with cutting and welding nozzle PR (PH1 + P2)

SPRING LEVER CUTTING ATTACHMENT KEP17

Oxygen - Propane



Art.-No.

25351 with cutting and welding nozzle PR (PH1 + P2)

BRAZING TIPS KEP17

Oxygen - Propane



Art.-No.

Size

25451 1 0,5 - 1 mm

25452 2 1 - 2 mm

25453 3 2 - 4 mm

25454 4 4 - 6 mm

25455 5 6 - 9 mm

25456 6 9 - 14 mm

25457 7 14 - 20 mm

25458 8 20 - 30 mm

SOLDERING AND CUTTING SYSTEM KEP17

ACC. TO EN ISO 5172

HEATING SWAGED NOZZL KEP17 E

Oxygen - Propane
with multihole - copper tip



Art.-No.	Size
25459	3 2 - 4 mm
25460	4 4 - 6 mm

SOLDERING TIP KEP17

Cu-tube \varnothing 6 mm, pliable



Art.-No.	Size
25552	2 1 - 2 mm
25553	3 2 - 4 mm
25554	4 4 - 6 mm
25555	5 6 - 9 mm

SOLDERING TIP FRONT PART KEP17

Cu-tube \varnothing 6 mm, pliable



Art.-No.	Size
25562	2 1 - 2 mm
25563	3 2 - 4 mm
25564	4 4 - 6 mm
25565	5 6 - 9 mm

COPPER TIPS KEP17

For soldering tips



Art.-No.	Size
2545101	1 0,5 - 1 mm
2545201	2 1 - 2 mm
2545301	3 2 - 4 mm
2545401	4 4 - 6 mm
2545501	5 6 - 9 mm
2545601	6 9 - 14 mm
2545701	7 14 - 20 mm
2545801	8 20 - 30 mm

BRAZING AND CUTTING SYSTEM KEP17

ACC. TO EN ISO 5172

KEP17 - MULTI HOLE COPPER TIP KEP17

For warming tips



Art.-No.	Size
2545901	3 2 - 4 mm
2546001	4 4 - 6 mm

PREHEATING TORCH KEP17 - PROPANE

With Material copper



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
23414	7	14 - 20 mm	0,3	3,5	1,8	6,0
23415	8	20 - 30 mm	0,3	4,0	2,6	8,5
23416	9	30 - 50 mm	0,5	4,0	4,0	13,0

SPARE PART PREHEATING TORCH KEP17 - PROPANE

Material copper



Art.-No.	Size
2465011	7 14 - 20 mm
2465111	8 20 - 30 mm
2465211	9* 30 - 50 mm

* head will be soldered

CUTTING AND WELDING SYSTEM KG20

ACC. TO EN ISO 5172



Connection thread: M 27 × 1,5, shank- Ø 20 mm

BOXED CUTTING AND WELDING SET KG20 R



Oxygen - Acetylene

consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box, hand wheel cutting attachment for ring nozzles KG20

Art.-No.

26100 for welding 0,5 - 14 mm, for cutting 3-100 mm

26101 for welding 0,5 - 30 mm, for cutting 3-100 mm

BOXED CUTTING AND WELDING SET KG20 B



Oxygen - Acetylene

consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box, hand wheel cutting attachment for block nozzles

Art.-No.

26110 for welding 0,5 - 14 mm, for cutting 3-100 mm

26111 for welding 0,5 - 30 mm, for cutting 3-100 mm

23140 sheet steel box empty

SHANK KG20



Oxygen-Acetylene

Art.-No.

26200 shank with connection nut

2620001 connection nut

HANDWHEEL CUTTING ATTACHMENT KG20



Art.-No.

26300 for ring nozzles KG, without nozzles

26301 with 1 heating- and 1 cutting nozzle KG (H 3-30, S 10-30)

26303 for AR / ARS nozzles, without nozzles

26304 for PLRC nozzles (Propane), without nozzles

26310 for block nozzles AB, without nozzles

CUTTING AND WELDING SYSTEM KG20

ACC. TO EN ISO 5172

SPRING LEVERCUTTING ATTACHMENT KG20



Art.-No.

26307 for nozzles suitable to AR, ARS, without nozzles

26309 for block nozzles AB, without nozzles

HANDWHEEL - HOLE CUTTING ATTACHMENT KG20



Art.-No.

26320 with 1 heating and 1 cutting nozzle (KG: H 3 - 30, S 10 - 30)

26321 for block nozzles AB, without nozzles

26322 for AR, ARS-nozzles, without nozzles

SPRING LEVER CUTTING ATTACHMENT KG20



Art.-No.

26400 with 1 heating and 1 cutting nozzle (KG: H 3 - 30, S 10 - 30)

26401 for block nozzles AB, without nozzles

26402 for AR, ARS-nozzles, without nozzles

SWAGED CUTTING NOZZLES KG20



Art.-No.	Size		Acetylene- cons. [m3/h]	Oxygen- cons. [m3/h]
26401	1	0,5 - 1 mm	0,075	0,08
26402	2	1 - 2 mm	0,15	0,16
26403	3	2 - 4 mm	0,30	0,315
26404	4	4 - 6 mm	0,475	0,5
26405	5	6 - 9 mm	0,75	0,8
26406	6	9 - 14 mm	1,15	1,25
26407	7	14 - 20 mm	1,70	1,8
26408	8	20 - 30 mm	2,50	2,6
26419	9	30 - 50 mm	4,0	4,2

CUTTING AND WELDING SYSTEM KG20

ACC. TO EN ISO 5172

HEATING TIPS KG20

multi hole - copper tips



Art.-No. **Size**

26409 3 2 - 4 mm

26410 4 4 - 6 mm

TUBE NOZZLES KG20

Cu-tube ø 6 mm, pliable



Art.-No. **Size**

26502 2 1 - 2 mm

26503 3 2 - 4 mm

26504 4 4 - 6 mm

26505 5 6 - 9 mm

TUBE NOZZLES-FRONT PARTS KG20

Cu-tube ø 6 mm, pliable



Art.-No. **Size**

23532 2 1 - 2 mm

23533 3 2 - 4 mm

23534 4 4 - 6 mm

23535 5 6 - 9 mm

COPPER TIPS KG20

For swaged tube nozzles



Art.-No.

2340101 1 0,5 - 1 mm

2340201 2 1 - 2 mm

2340301 3 2 - 4 mm

2340401 4 4 - 6 mm

2340501 5 6 - 9 mm

2340601 6 9 - 14 mm

2340701 7 14 - 20 mm

2340801 8 20 - 30 mm

2340901 9 30 - 50 mm

MULTI HOLE - COPPER TIPS KG20

For swaged tube nozzles



Art.-No. **Size**

2340901 3 2 - 4 mm

2341001 4 4 - 6 mm

CUTTING AND WELDING SYSTEM KG20

ACC. TO EN ISO 5172

PREHEATING TORCH KG20 - ACETYLENE

With Material copper



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
26600	7	14 - 20 mm	0,5	2,5	1,7	1,8
26601	8	20 - 30 mm	0,5	3,0	2,5	2,6
26602	9	30 - 50 mm	0,5	3,0	4,0	4,2

SPARE PART PREHEATING NOZZLE KG20 - ACETYLENE

Material copper



Art.-No.	Size	
2460011	7	14 - 20 mm
2460111	8	20 - 30 mm
2460211	9*	30 - 50 mm

*head will be soldered

PREHEATING TORCH KG20 - PROPANE

With Material copper



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
26650	7	14 - 20 mm	0,3	3,5	1,8	6,0
26651	8	20 - 30 mm	0,3	4,0	2,6	8,5
26652	9	30 - 50 mm	0,5	4,0	4,0	13,0

SPARE PART PREHEATING NOZZLE KG20 - PROPANE

Material copper



Art.-No.	Size	
2465011	7	14 - 20 mm
2465111	8	20 - 30 mm
2465211	9*	30 - 50 mm

*head will be soldered

CUTTING AND WELDING SYSTEM KG20

ACC. TO EN ISO 5172

PREHEATING TORCH KG20 - ACETYLENE

Brass head



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
26610	7	20-30 mm	0,5	3,0	2,15	2,3
26615	9	30-50 mm	0,5	3,0	4,1	4,3

SPARE PART PREHEATING TORCH KG20 - ACETYLENE

Brass head



Art.-No.	Size	
3160008	7	20-30 mm
3161008	9	30-50 mm

HEAVY DUTY PREHEATING TORCH KG20 - ACETYLENE



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
26640	12		0,5	2,5	3,75	3,8
26645	13		0,5	2,5	4,3	4,4

SPARE PART PREHEATING HEAD KG20 - ACETYLENE

Material copper



Art.-No.	Size
2364012	12
2364013	13

Please keep in mind:

Using torches with an Acetylene consumption of more than 1 m³/h several cylinders have to be coupled.

The maximum consumption per cylinder is limited to 1 m³/h. Matching cylinder couplings can be found in our catalog on „Central gas supply“.

CUTTING AND WELDING SYSTEM K3000

ACC. TO EN ISO 5172



Connection thread: M 27 × 1,5, Schaft: Ø 20 mm

COMBI CUTTING AND WELDING SET K3000 14

Consisting of:
shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box,
for welding 0,5 - 14 mm, for cutting 3 - 100 mm



Art.-No.	design
27100	spring lever-cutting tube nozzle with ring nozzles AR
27101	spring lever-cutting tube nozzle with block nozzles AB
27103	hand wheel-cutting tube nozzle with block nozzles AB
27105	spring lever-cutting tube nozzle with AR/ARS-nozzles

COMBI CUTTING AND WELDING SET K3000 30

Consisting of:
shank, torch carriage, check rail, cleaning needles,
torch wrench, sheet steel box,
for welding 0,5 - 30 mm, for cutting 3 - 100 mm



Art.-No.	design
27110	spring lever-cutting tube nozzle with ring nozzles AR
27111	spring lever-cutting tube nozzle with block nozzles AB
27113	hand wheel-cutting tube nozzle with block nozzles AB
23140	sheet steel box empty

SHANK K3000



Art.-No.	design
27200	shank with connection nut
2620001	connection nut

SPRING LEVER - CUTTING ATTACHMEND K3000



Art.-No.	Type
27340	for AR/ARS-nozzles, without nozzles
27341	with 1 cutting and welding nozzle (AR: H1, S2)
27342	for block nozzles AB, without nozzles
27343	for nozzles suitable to LPN, PR, PLRC, without nozzles
27352	for FK-nozzles

CUTTING AND WELDING SYSTEM K3000

ACC. TO EN ISO 5172

SPRING LEVER CUTTING ATTACHMENT K3000

Oxygen / Acetylene - Propane - Methane (Natural gas)



Art.-No.

27350 for gas mixing nozzles AGN, PNME

HAND WHEEL - CUTTING ATTACHMENT K3000



Art.-No.

27330 for nozzles suitable to AR, ARS, without nozzles

27331 with 1 cutting and welding nozzle (AR: H1, S2)

27332 for block nozzles AB, without nozzles

HAND WHEEL - HOLE CUTTING ATTACHMENT K3000



Art.-No.

27335 for nozzles AR/ARS, without nozzles

27336 for block nozzles, without nozzles

SWAGED WELDING NOZZLES K3000

Oxygen / Acetylene



Art.-No.	Size		Acetylene-	Oxygen-
			cons.	cons.
			[m3/h]	[m3/h]
27401	1	0,5 - 1 mm	0,075	0,08
27402	2	1 - 2 mm	0,15	0,16
27403	3	2 - 4 mm	0,30	0,315
27404	4	4 - 6 mm	0,475	0,5
27405	5	6 - 9 mm	0,75	0,8
27406	6	9 - 14 mm	1,15	1,25
27407	7	14 - 20 mm	1,70	1,8
27408	8	20 - 30 mm	2,50	2,6
27419	9	30 - 50 mm	4,0	4,2

CUTTING AND WELDING SYSTEM K3000

ACC. TO EN ISO 5172

HEATING SWAGED NOZZLES K3000

multi hole - copper tips



Art.-No.	Size	
27409	3	2 - 4 mm
27410	4	4 - 6 mm

TUBE NOZZLES K3000

Copper tube \varnothing 6 mm, pliable



Art.-No.	Size	
27502	2	1 - 2 mm
27503	3	2 - 4 mm
27504	4	4 - 6 mm
27505	5	6 - 9 mm

TUBE NOZZLES-FRONT PARTS K3000

Cu-tube \varnothing 6 mm, pliable



Art.-No.	Size	
23532	2	1 - 2 mm
23533	3	2 - 4 mm
23534	4	4 - 6 mm
23535	5	6 - 9 mm

COPPER TIPS K3000



Art.-No.	Size	
2340101	1	0,5 - 1 mm
2340201	2	1 - 2 mm
2340301	3	2 - 4 mm
2340401	4	4 - 6 mm
2340501	5	6 - 9 mm
2340601	6	9 - 14 mm
2340701	7	14 - 20 mm
2340801	8	20 - 30 mm
2340901	9	30 - 50 mm

MULTI HOLE - COPPER TIPS K3000



Art.-No.	Size	
2340901	3	2 - 4 mm
2341001	4	4 - 6 mm

CUTTING AND WELDING SYSTEM K3000

ACC. TO EN ISO 5172

PREHEATING TORCH K3000 - ACETYLENE

With Material copper



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
27600	7	14 - 20 mm	0,5	2,5	1,7	1,8
27601	8	20 - 30 mm	0,5	3,0	2,5	2,6
27602	9	30 - 50 mm	0,5	3,0	4,0	4,2

SPARE PART PREHEATING NOZZLE K3000 - ACETYLENE

Material copper



Art.-No.	Size	
2460011	7	14 - 20 mm
2460111	8	20 - 30 mm
2460211	9*	30 - 50 mm

*head will be soldered

PREHEATING TORCH K3000 - PROPANE

With Material copper



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
27650	7	14 - 20 mm	0,3	3,5	1,8	6,0
27651	8	20 - 30 mm	0,3	4,0	2,6	8,5
27652	9	30 - 50 mm	0,5	4,0	4,0	13,0

SPARE PART PREHEATING NOZZLE K3000 - PROPANE

Material copper



Art.-No.	Size	
2465011	7	14 - 20 mm
2465111	8	20 - 30 mm
2465211	9*	30 - 50 mm

*head will be soldered

CUTTING AND WELDING SYSTEM K3000

ACC. TO EN ISO 5172

PREHEATING TORCH K3000 - ACETYLENE

Brasskopf



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
27610	7	20-30mm	0,5	3,0	2,15	2,3
27615	9	30-50mm	0,5	3,0	4,1	4,3

SPARE PART PREHEATING NOZZLE K3000 - ACETYLENE

Brasskopf



Art.-No.	Size	
3160008	7	20-30 mm
3161008	9	30-50 mm

HEAVY DUTY PREHEATING TORCH K3000 - ACETYLENE



Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
27640	12		0,5	2,5	3,75	3,8
27645	13		0,5	2,5	4,3	4,4

SPARE PART PREHEATING HEAD K3000 - ACETYLENE

Material copper



Art.-No.	Size
2364012	12
2364013	13

Please keep in mind:

Using torches with an Acetylene consumption of more than 1 m³/h several cylinders have to be coupled.

The maximum consumption per cylinder is limited to 1 m³/h. Matching cylinder couplings can be found in our catalog on „Central gas supply“.

HEAVY DUTY SYSTEM KS22

ACC. TO EN ISO 5172



HEAVY DUTY SHANK KS22

Connection thread: W 27 × 20 Gg, Schaft: Ø 22 mm

Flow: 30 m³/h
 Connection: Oxygen: G 3/8" , Fuel gas: G 1/2" LH



Art.-No.

31050 Heavy duty shank

HEAVY DUTY SWAGED NOZZLES KS22

Oxygen / Acetylene



Art.-No.	Size		Acetylene	Oxygen
			cons. [m ³ /h]	cons. [m ³ /h]
31100	9	30 - 50 mm	0,075	0,08
31110	10	50 - 100 mm	0,15	0,16

Oxygen / Propane

Art.-No.

31101 9 30 - 50 mm 0,075 0,08

SPARE PART COPPER NOZZLE FOR HEAVY DUTY SWAGED NOZZLES KS22

Oxygen / Acetylene



Art.-No.	Size	
3110001	9	30 - 50 mm
3110010	10	50 - 100 mm

Oxygen / Propane

Art.-No. Size

3110001 9 30 - 50 mm

SUPERHEATING NECKS KS22 - ACETYLENE

With Material copper



Art.-No.	Size		Fuel gas pressure	O ₂ -pressure	Fuel gas cons.	O ₂ cons.
31200	9	30 - 50 mm	0,5	3,0	4,1	4,2
31210	10	50 - 100 mm	0,5	3,0	7,5	7,8

HEAVY DUTY SYSTEM KS22

ACC. TO EN ISO 5172

SPARE PART SUPERHEATING NECKS KS22 - ACETYLENE



Material copper

Art.-No. Size

2460211 9 30 - 50 mm

3121008 10 50 - 100 mm

PREHEATING NOZZLE KS22 - PROPANE



With Material copper

Art.-No. Size

Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
31500	9*	30-50mm	0,6	6,0	4,5	16
31510	10*	50-100mm	0,8	6,0	8,1	27

*head will be soldered

SPARE PART PREHEATING TORCH KS22 - PROPANE



Material copper

Art.-No. Size

2465211 9 30 - 50 mm

3151008 10 50 - 100 mm

PREHEATING TORCH KS22 - ACETYLENE



Brasskopf

Art.-No. Size

Art.-No.	Size		Fuel gas- pressure	O2- pressure	Fuel gas- cons.	O2- cons.
31600	7	20-30mm	0,5	3,0	2,15	2,3
31610	9	30-50mm	0,5	3,0	4,1	4,3

SPARE PART PREHEATING NOZZLE KS22 - ACETYLENE



Brasskopf

Art.-No. Size

3160008 7 20-30 mm

3161008 9 30-50 mm

HEAVY DUTY SYSTEM KS22

ACC. TO EN ISO 5172

PREHEATING TORCH KS22 - PROPANE

Brasskopf



Art.-No.	Size	
31620	9	30-50 mm
31630	10	50-100 mm

SPARE PART PREHEATING NOZZLE KS22 - PROPANE

Brasskopf



Art.-No.	Size	
3162008	9	30-50 mm
3163008	10	50-100 mm

HEAVY DUTY PREHEATING TORCH KS22 - ACETYLENE



Art.-No.	Size	Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
31640	12	0,5	2,5	3,75	3,8
31645	13	0,5	2,5	4,3	4,4

SPARE PART PREHEATING HEAD KS22 - ACETYLENE

Material copper



Art.-No.	Size
2364012	12
2364013	13

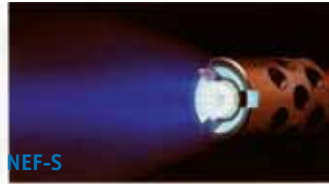
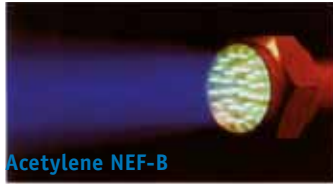
Please keep in mind:

Using torches with an Acetylene consumption of more than 1 m³/h several cylinders have to be coupled.

The maximum consumption per cylinder is limited to 1 m³/h. Matching cylinder couplings can be found in our „Central gas supply“ catalog.

PREHEATING AND STRAIGHTENING

KAYSER INFORMATION: HEATING / PREHEATING



These thermal processes are difficult to separate, often these terms are used for the same task.

Here to allow some delineation of the process:

- Flame heating for shaping
- Preheating: reaching or maintaining a certain temperature level

In both methods, the aim is to completely warm-up the material. For that a flame with low heat flux is used.

The selection of the gases needed depends on the technical requirements and/or the temperature to be reached. Selecting the burner the multi hole nozzle should given preference to the single-hole nozzle, this one works much more quiet and prevents the „streaking“.

HEATING AND STRAIGHTENING

HEATING ATTACHMENT D - PROPANE / NATURAL GAS

For the heating of steel constructions with high flame consumption.
The primary flame appears focused, which results in easily controlled warm-up processing.



Art.-No.	System	Size	Length
27604	K3000	D1	290
27605	K3000	D2	490
27606	K3000	D3	650
23423	KM17A/KE17	D1	290
23424	KM17A/KE17	D2	490
23425	KM17A/KE17	D3	650
31220	KS22	D3	710
31230	KS22	D4	710
31240	KS22	D5	710

HEATING NOZZLES D AS SPARE PART (CHROMED)

Fits to KE17 heating tips



Art.-No.	Size	Oxygen pressure (bar)	Propane pressure (bar)	Oxygen Cons. (m3/h)	Propane Cons. (m3/h)
2760401	D1	3	0,5	1,8	0,5
2760402	D2	5	0,5	6,5	2,03
2760403	D3	6	0,8/1,3	13,0/18,6	4,0/5,5
2760404	D4	6	1,3	21,6	6,2
2760405	D5	6	1,3	23	6,6

Second value applies for type D3 for maximum consumption with shank \varnothing 22 cm

HEATING ATTACHMENT DK - PROPANE / NATURAL GAS

For central heating steel building constructions at extreme flame concentration. The heating head works with optimal heating time.
Due to the big heating power this article should only be used in areas without heating jam.



Art.-No.	System	Size	Length
23426	KM17A/KE17	DK2	490
23427	KM17A/KE17	DK3	650
27608	K3000	DK3	650
31250	KS22	DK3	710

HEATING NOZZLES DK AS SPARE PART (CHROMED)



Art.-No.	Type	Oxygen pressure (bar)	Propane pressure (bar)	Oxygen Cons. (m3/h)	Propane Cons. (m3/h)
2760702	DK2	5	0,5	6,5	2,03
2760803	DK3	6	0,8/1,3	13,0/18,6	4,0/5,5

Second value applies for type D3 for maximum consumption with shank \varnothing 22 cm

HEATING AND STRAIGHTENING

THREE-FLAME STRAIGHTENING TORCH

Acetylene - Oxygen
Switchable 3/2 Flames, with copper tips 4-6 mm

Art.-No.

32012 suitable System K3000



FIVE-FLAME STRAIGHTENING TORCH

Acetylene - Oxygen
Switchable 5/3 Flames, with copper tips 4-6 mm

Art.-No.

31212 suitable System K3000



SPARE PART COPPER NOZZLES



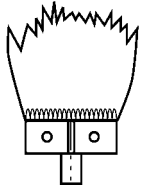
Art.-No.

32200 3 2 - 4 mm

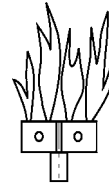
32201 4 4 - 6 mm

FLAME CLEANING & DERUSTING

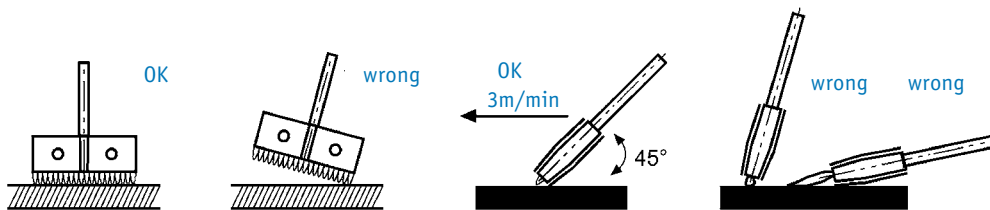
KAYSER INFORMATION: ADJUST THE FLAME WITH OXYGEN OVERFLOW



Adjusting of a neutral flame with adjusting valve at handle.
 Sharp contoured flame cone.
 Adjusting the operating flame to „Oxygen surplus“ blue flame.
 Flames takes off from torch.

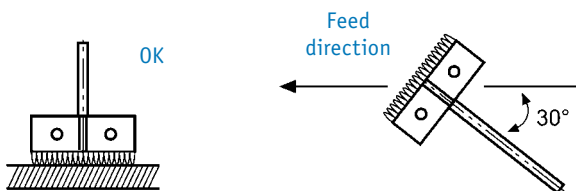


KAYSER INFORMATION: WORKING WITH CONCRETE



Place torch carefully on surface. Torch cleaning in an 45° angle to surface.
 The tips of the flame cone have to touch the surface.

KAYSER INFORMATION: ARBEITSTECHNIK BEI DER STEELBEARBEITUNG



Achtung Flammstrahlbrenner!

Bei den Brennerbreiten 100, 150, 200 and 250 mm hoher Acetyleneconsumpt..
 Max. Acetyleneentnahme aus einer 50l Cylinder = ca. 1m³/h.
 Diesem Richtwert entsprechend sind Acetylenecylinders zu koppeln.

FLAME CLEANING & DERUSTING

FLAME JET TORCH ACETYLENE

Nozzle head with single row borings



Art.-No.	suitable to	Brennerbreite	Length
32305	KM17 A / KE17	50 mm	440 mm
32310	KM17 A / KE17	100 mm	470 mm
32315	KM17 A / KE17	150 mm	470 mm
32320	KM17 A / KE17	200 mm	1117 mm
32325	KM17 A / KE17	250 mm	1117 mm
32405	KG20	50 mm	440 mm
32410	KG20	100 mm	470 mm
32415	KG20	150 mm	470 mm
32420	KG20	200 mm	1117 mm
32425	KG20	250 mm	1117 mm

KAYSER INFORMATION: CONSUMPTION FLAMMSTRAHLBRNNER

Burner width [mm]	Oxygen press. bar / m ³ /h	Acetylene press. bar / m ³ /h	Acetylene cons. m ³ /h
50	3 / 1,25	0,5	1
100	4 / 2,50	0,6	2
150	5 / 3,75	0,7	3
200	5 / 5,00	0,7	4
250	5 / 6,25	0,7	5

Attention: flame jet torch!

For torch width 100, 150, 200 and 250 mm the Acetylene consumption is high.

Max. Acetylene consumption from out a 50l cylinder = ca. 1m³/h.

Referring to this value Acetylene cylinders have to be coupled to reach the consumption level needed.

For cylinder couplings, please regard page 78.

FLAME CLEANING & DERUSTING

DERUSTING TORCH PROPANE / NATURAL GAS

Torch head with single-rowed borings



Art.-No.		Width	Length
32330	suitable to KM17 A / KE17	50 mm	360 mm
32335	suitable to KM17 A / KE17	100 mm	370 mm
32430	suitable to KG20	50 mm	360 mm
32435	suitable to KG20	100 mm	370 mm

DERUSTING TORCH PROPANE / NATURAL GAS

Torch head with borings arranged in three rows



Art.-No.		Width	Length
32640	suitable to KS22	150 mm	550 mm
32645	suitable to KS22	200 mm	570 mm
32650	suitable to KS22	250 mm	570 mm

KAYSER INFORMATION: CONSUMPTION DERUSTING TORCH

Width [mm]	Oxygen pressure [bar]	Propane pressure [bar]	Oxygen consumption [m ³ /h]	Propane consumption [m ³ /h]
50	5,0	0,5	3,5	0,9
100	5,0	0,5	7,7	1,8
150	5,0	0,5	11,3	3,05
200	5,0	0,5	16,2	4,25
250	5,0	0,5	17,5	4,45

For additional special torches please regard our catalog "Special Torches"!

MOBILE CUTTING & WELDING SETS / CUTTING TORCHES



MOBILE SETS

MOBILE CUTTING AND WELDING SET EUROPROP 08

Connection \varnothing 17 mm, Oxygen - Propane.

Consisting of:

Shank KEP17, heating attachment 3, Oxygen/Propane hose 4x4, length 2,5 m, safety device for Oxygen and Fuel gas, Oxygen pressure regulator, Propane regulator Mini, 2 l full Oxygen cylinder, 25 gr full Propane cylinder

Art.-No.

25758* Portable soldering unit



MOBILE CUTTING AND WELDING SET ON TROLLEY

Connection \varnothing 17 mm, Oxygen - Acetylene.

Consisting of:

Cutting and welding uni KEK17 (for welding 0,5 - 9 mm, for cutting 3 - 100 mm, im sheet steel box), Pressure regulator for Oxygen and Acetylene, Safety device for Oxygen and Acetylene, Oxygen/Acetylene Hose 5m eingebanden, Cylinder trolley

Art.-No.

25760* incl. 5l cylinder, full

25762 for 5l cylinder, without cylinders

25770* incl. 10l cylinder, full

25772 for 10l cylinder, without cylinders

25771* incl. 20l cylinder, full

25773 for 20l cylinder, without cylinders

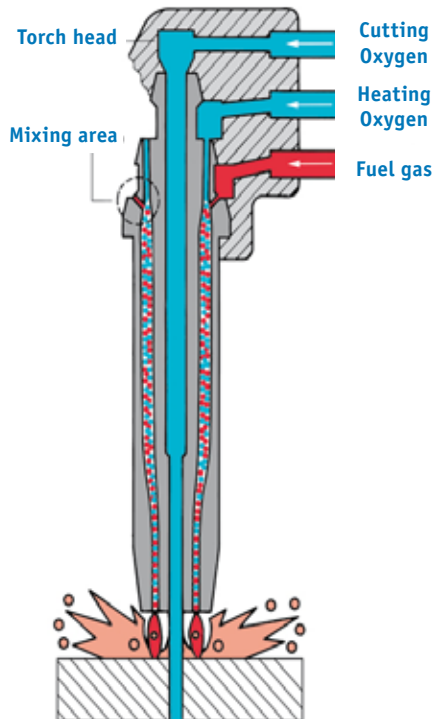


* Full cylinders apply as dangerous freight and have to be supplied accordingly to the shipping company possibly causing additional freightage.

CUTTING TORCHES DORTMUND

KAYSER INFORMATION: GAS MIXING CUTTING SYSTEM DORTMUND I

For AGN and PNME nozzles



VERY ECONOMICAL

- Through long torch and nozzle life time.
- An integrated nozzle mixing system guarantees maximum life for gas-mixing nozzles.
- Its long torch and nozzle life time significantly affects the efficiency of the cutting process.

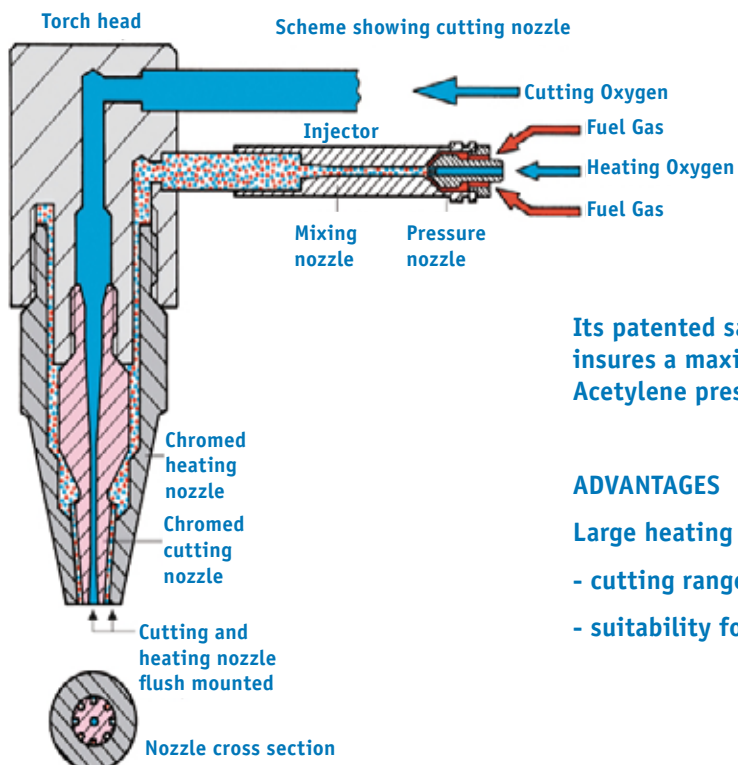
FLASHBACK SAFETY

The geometry of the mixture hole (oxygen / fuel gas) of a gas mixing nozzle is designed to prevent flashbacks making the most of the gas hole back to the torch, ie the flash back flame will be extinguished already inside the nozzle.

Therefore flashbacks do not reach (twin tube) the shank as it occurs with the injector torches.

KAYSER INFORMATION: INJECTOR CUTTING SYSTEM DORTMUND II

For AR / ARS / AB / NX / NFF And LPN / PLRC nozzles



Its patented safety injector design (double safety-injector) insures a maximum of flashback safety independent of the Acetylene pressure level.

ADVANTAGES

Large heating Oxygen flow, by that

- cutting range more than 100 mm beyond
- suitability for gouging

CUTTING TORCHES DORTMUND I

HAND CUTTING TORCHES DORTMUND I - SPRING LEVER DESIGN

Oxygen/Acetylene - Propane - Methane (Natural gas)
For gas mixing nozzles AGN, PNME, cutting up to 300 mm



Art.-No.	Length	Torch head
33600	500 mm	90°
33603	700 mm	90°
33601	800 mm	90°
33602	1000 mm	90°
33617	1200 mm	90°
33618	1500 mm	90°
33610	500 mm	105°
33611	800 mm	105°
33612	1000 mm	105°
33614	1500 mm	105°
33606	500 mm	180°
33605	800 mm	180°
33609	1000 mm	180°
33607	1200 mm	180°
33608	1600 mm	180°

HAND CUTTING TORCHES DORTMUND I - HAND WHEEL DESIGN

Oxygen/Acetylene - Propane - Methane (Natural gas)
For gas mixing nozzles AGN, PNME, cutting up to 300 mm



Art.-No.	Length	Torch head
33620	500 mm	90°
33621	800 mm	90°
33622	1000 mm	90°
33630	500 mm	105°
33631	800 mm	105°
33632	1000 mm	105°
33634	1400 mm	105°
33623	1500 mm	105°
33624	500 mm	180°
33641	1500 mm	180°

HAND CUTTING TORCHES DORTMUND I - HAND WHEEL

Oxygen/Acetylene - Propane - Methane (Natural gas)
For gas mixing nozzles AGN, PNME, cutting up to 300 mm, with angular shaped shank.

Art.-No.	Length	Torch head
33682	500 mm	90°

CUTTING TORCHES DORTMUND II

INJECTOR-HAND CUTTING TORCHES DORTMUND II - SPRING LEVER DESIGN

Cutting range up to 300 mm
Oxygen - Acetylene



Art.-No.		Torch head	Length
33650	for AR / ARS nozzles	90°	500 mm
33633	for AR / ARS nozzles	90°	800 mm
33657	for AR / ARS nozzles	180°	500 mm
33659	for AR / ARS nozzles	180°	1000 mm
33651	for gouging block nozzles AB	180°	500 mm
33652	for block nozzles AB	90°	500 mm
33658	for block nozzles AB	90°	800 mm
33661	for block nozzles AB	90°	1000 mm
33667	for block nozzles AB	90°	1200 mm
33653	for gouging-block nozzles AB	90°	500 mm
33654	for flat head nozzles	90°	500 mm

Oxygen - Propane, Natural gas

Art.-No.			
33655	for LPN / PLRC / PR nozzles	90°	500 mm
33663	for LPN / PLRC / PR nozzles	180°	500 mm
33656	for NFF / NX nozzles	90°	500 mm
33666	for NFF / NX nozzles	90°	1000 mm
33664	for NFF / NX nozzles	90°	1200 mm

INJECTOR-HAND CUTTING TORCHES DORTMUND II - HAND WHEEL DESIGN

Cutting range up to 300 mm, length 500 mm
Oxygen - Acetylene



Art.-No.		Torch head
33670	for AR / ARS nozzles	90°
33672	for block nozzles AB	90°
33673	for gouging-block nozzles AB	90°
33677	for flat head nozzles	90°

Oxygen - Propane, Natural gas

Art.-No.		Torch head
33675	for LPN / PLRC / PR nozzles	90°
33676	for NFF / NX nozzles	90°

INJECTOR-HAND CUTTING TORCHES DORTMUND II - HAND WHEEL DESIGN

Oxygen - Acetylene
Cutting range up to 300 mm, length 500 mm
with angular shaped shank



Art.-No.		Torch head
33680	for AR / ARS nozzles	90°

INJECTOR-CUTTING TORCHES

INJECTOR-CUTTING TORCHES SKR / SKF

Oxygen - Acetylene
shank angular shaped, head 90°



Art.-No.

33400 for AR / ARS nozzles, without nozzles

33401 for AR / ARS nozzles, with cutting and welding nozzle AR H1 + S3

33500 for flat head, without nozzles

INJECTOR-CUTTING TORCHES SKR / SKB

Oxygen - Acetylene
shank straight shaped, head 90°



Art.-No.

33410 for AR / ARS nozzles, without nozzles

33411 for AR / ARS nozzles, with cutting and welding nozzle AR H1 + S3

33510 for block nozzles AB, without nozzles

Oxygen - Propane, Natural gas

Art.-No.

33460 for LPN / PLRC / PR nozzles, without nozzles

INJECTOR-CUTTING TORCHES SKFB / SKFR

Oxygen - Acetylene
shank straight shaped, head 145°



Art.-No.

33511 with angular shaped gouging block nozzle AB, 2

33415 with twin gouging, cutting and welding nozzle FHR H 0-1, S 1

INJECTOR-CUTTING TORCHES SKFB / SKFR

Oxygen - Acetylene
shank straight shaped, head 180°



Art.-No.

33416 with twin gouging, cutting and welding nozzle FHR H 0-1, S 1

MACHINE CUTTING TORCHES

MACHINE CUTTING TORCHES - 3 HOSES



without nozzles

Art.-No.

33700	Oxygen - Propane	for NFF / NX nozzles
33710	Oxygen - Acetylene	for AR / ARS nozzles
33720	Oxygen - Propane	for LPN / PLRC nozzles

ADJUSTMENT VALVE



Art.-No.

KAY500	for heating Oxygen	G 1/4"
KAY501	for cutting Oxygen	G 3/8"
502	for Fuel gas	G 3/8" LH

HOSE FOR MACHINE TORCHES

Steel coated, length ca. 1000 mm



Art.-No.

3370016	for heating Oxygen	G 1/4"
3370017	for cutting Oxygen	G 3/8"
3370018	for Fuel gas	G 3/8" LH

FLASHBACK ARRESTOR FOR MACHINE TORCH



Art.-No.	Gas	Type	Working pressure	Inlet	Outlet
64060	Fuel gas	3	max. 5 bar	G3/8" LH male	G3/8" LH fem.
64061	Oxygen	3	max. 20 bar	G1/4" male	G1/4" fem.
64067	Oxygen	3	max. 20 bar	G3/8" male	G3/8" fem.

NOZZLES



NOZZLES

CUTTING NOZZLE KE17 - ACETYLENE



Art.-No.	Type	Class.	Cutting range
61000	Heating nozzle	H 1	3 - 100 mm
61005	Heating nozzle	H 2	100 - 300 mm
61006	Cutting nozzle	S 0	3 - 12 mm
61007	Cutting nozzle	S 1	12 - 25 mm
61008	Cutting nozzle	S 2	25 - 50 mm
61009	Cutting nozzle	S 3	50 - 100 mm
61010	Cutting nozzle	S 4	100 - 200 mm
61011	Cutting nozzle	S 5	200 - 300 mm

Only suitable to KE17

CUTTING NOZZLE KG20 - ACETYLENE



Art.-No.	Type	Cutting range
61100	Heating nozzle	3 - 30 mm
61101	Heating nozzle	30 - 100 mm
61102	Heating nozzle	100 - 200 mm
61110	Cutting nozzle	3 - 10 mm
61111	Cutting nozzle	10 - 30 mm
61112	Cutting nozzle	30 - 60 mm
61113	Cutting nozzle	60 - 100 mm
61114	Cutting nozzle	100 - 200 mm

only suitable to KG20 Standardkopf

FK - FLAT HEAD NOZZLE



Art.-No.	Type	Gas type	Cutting range
61150	Heating nozzle	Acetylene H 1	2 - 100 mm
61151	Heating nozzle	Acetylene H 2	100 - 300 mm
61152	Heating nozzle	Propane H 3	3 - 100 mm
61160	Cutting nozzle S 0		1 - 3 mm
61161	Cutting nozzle S 1		3 - 12 mm
61162	Cutting nozzle S 2		12 - 25 mm
61163	Cutting nozzle S 3		25 - 40 mm
61164	Cutting nozzle S 4		40 - 65 mm
61165	Cutting nozzle S 5		65 - 100 mm
61166	Cutting nozzle S 6		100 - 150 mm
61167	Cutting nozzle S 7		150 - 220 mm

only suitable to for Flachkopfbrenner

NOZZLES

CUTTING NOZZLE AR - ACETYLENE



Art.-No.	Type	Class.	Cutting range
61201	Heating nozzle	H 1	3 - 100 mm
61202	Heating nozzle	H 2	100 - 300 mm
61210	Cutting nozzle	S 0	1 - 3 mm
61211	Cutting nozzle	S 1	3 - 10 mm
61212	Cutting nozzle	S 2	10 - 25 mm
61213	Cutting nozzle	S 3	25 - 40 mm
61214	Cutting nozzle	S 4	40 - 60 mm
61215	Cutting nozzle	S 5	60 - 100 mm
61216	Cutting nozzle	S 6	100 - 200 mm
61217	Cutting nozzle	S 7	200 - 300 mm

suitable to KM15, KM17, KG20 with AR head, K3000, Dortmund II, SKR

NOZZLES SUITABLE TO ARS - ACETYLENE



Art.-No.	Type	Cutting range
61250	Heating nozzle HA	3 - 100 mm
61251	Heating nozzle HA	100 - 300 mm
61261	Cutting nozzle SA	3 - 10 mm
61262	Cutting nozzle SA	10 - 25 mm
61263	Cutting nozzle SA	25 - 40 mm
61264	Cutting nozzle SA	40 - 60 mm
61265	Cutting nozzle SA	60 - 100 mm
61266	Cutting nozzle SA	100 - 200 mm
61267	Cutting nozzle SA	200 - 300 mm

suitable to KM15, KM17, KG20 with AR head, K3000, Dortmund II, SKR

PR - NOZZLES - PROPANE



Art.-No.	Type	Class.	Cutting range
61050	Heating nozzle	PH1	3 - 100 mm
61051	Heating nozzle	PH2	100 - 300 mm
61056	Cutting nozzle	P1	3 - 12 mm
61057	Cutting nozzle	P2	12 - 25 mm
61058	Cutting nozzle	P3	25 - 40 mm
61059	Cutting nozzle	P4	40 - 65 mm
61060	Cutting nozzle	P5	65 - 100 mm
61061	Cutting nozzle	P6	100 - 150 mm
61062	Cutting nozzle	P7	200 - 300 mm

suitable to KEP17, SKR, Dortmund II, KM17, K3000

NOZZLES

NOZZLES SUITABLE TO LPN - PROPANE / METHANE (NATURAL GAS) / LEUCHTGAS

suitable to Dortmund II, SKR, KEP17



Art.-No.	Type	Class.	Cutting range
61300	Heating	KHPL	2 - 100 mm
61301	Heating	KHPL	100 - 300 mm
61310	Cutting	KSPL	3 - 10 mm
61311	Cutting	KSPL	10 - 25 mm
61312	Cutting	KSPL	25 - 40 mm
61313	Cutting	KSPL	40 - 60 mm
61314	Cutting	KSPL	60 - 100 mm
61315	Cutting	KSPL	100 - 200 mm
61316	Cutting	KSPL	200 - 300 mm

NOZZLES SUITABLE TO PLRC - PROPANE / METHANE (NATURAL GAS) / LEUCHTGAS

suitable to Dortmund II, SKR, KEP17



Art.-No.	Type	Class.	Cutting range
61350	Heating	HPL	2 - 100 mm
61351	Heating	HPL	100 - 300 mm
61360	Cutting	SPL	3 - 10 mm
61361	Cutting	SPL	10 - 25 mm
61362	Cutting	SPL	25 - 40 mm
61363	Cutting	SPL	40 - 60 mm
61364	Cutting	SPL	60 - 100 mm
61365	Cutting	SPL	100 - 200 mm
61366	Cutting	SPL	200 - 300 mm

BLOCK NOZZLES AB - ACETYLENE

suitable to KE17, KM17, KG20, K3000, Dortmund II, SKR B



Art.-No.	Cutting range
61400	3 - 10 mm
61401	10 - 25 mm
61402	25 - 40 mm
61403	40 - 60 mm
61404	60 - 100 mm
61405	100 - 200 mm
61406	200 - 300 mm
2631032	Pressure screw

NOZZLES

GOUGING NOZZLES AB - ACETYLENE



suitable to Dortmund II, SKB / SKFB

Art.-No.	Type	Depth	Width
61430	1 bent shape	3 - 9 mm	6 - 8 mm
61431	2 bent shape	6 - 11 mm	8 - 11 mm
61432	3 bent shape	10 - 12 mm	10 - 12 mm
61440	1 straight shape	3 - 9 mm	6 - 8 mm
61441	2 straight shape	6 - 11 mm	8 - 11 mm
61442	3 straight shape	10 - 12 mm	10 - 12 mm
2631032	pressure screw		

GAS MIXING NOZZLES AGN - ACETYLENE



suitable to KM15, K3000, Dortmund 1

Art.-No.	Range
61460	3 - 10 mm
61461	10 - 25 mm
61462	25 - 40 mm
61463	40 - 60 mm
61464	60 - 100 mm
61465	100 - 200 mm
61466	200 - 300 mm
3320040	pressure screw

GAS MIXING NOZZLES PNME - PROPANE / METHANE (NATURAL GAS) / ILLUMINATING GAS



suitable to KM15, K3000, Dortmund 1

Art.-No.	Range
61470	3 - 10 mm
61471	10 - 25 mm
61472	25 - 40 mm
61473	40 - 60 mm
61474	60 - 150 mm
61476	150 - 300 mm
3320040	pressure screw

CUTTING NOZZLE NFF - PROPANE / NATURAL GAS



suitable to Dortmund II machine cutting torches, twin shaped, outer nozzle chromed copper

Art.-No.	Range
61520	6 - 25 mm
61521	25 - 50 mm
61522	50 - 75 mm
61523	75 - 150 mm
61524	150 - 200 mm
61525	200 - 300 mm
3325602	pressure screw

NOZZLES

GOUGING NOZZLES FAGN - ACETYLENE

suitable to Dortmund 1, K3000 - one-piece, gas mixing



Art.-No.	Type	Depth	Width
61580	1 straight shaped	3 - 9 mm	6 - 8 mm
61581	2 straight shaped	6 - 11 mm	8 - 11 mm
61582	3 straight shaped	10 - 12 mm	10 - 12 mm
61570	1 bent shape	3 - 9 mm	6 - 8 mm
61571	2 bent shape	6 - 11 mm	8 - 11 mm
61572	3 bent shape	10 - 12 mm	10 - 12 mm
3320040	pressure screw		

GOUGING NOZZLES FHR - ACETYLENE

suitable to SKFR, Dortmund II, KM17, KG20 with AR head, K3000, SKR



Art.-No.	Type	Range
61600	Heating nozzle	0 - 1
61602	Heating nozzle	2 - 3
61605	Cutting nozzle	0
61606	Cutting nozzle	1
61607	Cutting nozzle	2
61608	Cutting nozzle	3

GOUGING HEATING AND CUTTING NOZZLE - ACETYLENE

Attention: suitable to only for thread W 23,3 x 19 for large torch heads



Art.-No.	Type	Range
61620	Heating nozzle	0 - 1
61621	Heating nozzle	2 - 3
61625	Cutting nozzle	0
61626	Cutting nozzle	1
61627	Cutting nozzle	2
61628	Cutting nozzle	3

NOZZLES

HEAVY DUTY MACHINE CUTTING NOZZLES - ACETYLENE

suitable to Dortmund II, KM17, KG20 with AR head, K3000, SKR, machine cutting torches, similar to V1215



Art.-No.	Type	Range
61920	Heating nozzle	3 - 150 mm
61921	Heating nozzle	150 - 300 mm
61924	Cutting nozzle	6 - 10 mm
61925	Cutting nozzle	10 - 25 mm
61926	Cutting nozzle	25 - 40 mm
61927	Cutting nozzle	40 - 60 mm
61928	Cutting nozzle	60 - 100 mm
61929	Cutting nozzle	100 - 150 mm
61930	Cutting nozzle	150 - 230 mm
61931	Cutting nozzle	230 - 300 mm

HEAVY DUTY CUTTING NOZZLE - ACETYLENE

suitable to Dortmund II, KM17, KG20 with AR head, K3000, SKR, machine cutting torches, similar to V1210



Art.-No.	Type	Range
61950	Heating nozzle	2 - 150 mm
61954	Cutting nozzle	6 - 10 mm
61955	Cutting nozzle	10 - 25 mm
61956	Cutting nozzle	25 - 40 mm
61957	Cutting nozzle	40 - 60 mm
61958	Cutting nozzle	60 - 100 mm
61959	Cutting nozzle	100 - 150 mm

GAS MIXING NOZZLES PSD - PROPANE / METHANE (NATURAL GAS) / ILLUMINATING GAS

suitable to Dortmund II, KM17, KG20 with AR head, K3000, SKR, machine cutting torches, similar to C1230



Art.-No.	Type	Range
61970	Heating nozzle	3 - 100 mm
61971	Heating nozzle	100 - 300 mm
61973	Cutting nozzle	3 - 6 mm
61974	Cutting nozzle	6 - 15 mm
61975	Cutting nozzle	15 - 25 mm
61976	Cutting nozzle	25 - 40 mm
61977	Cutting nozzle	40 - 60 mm
61978	Cutting nozzle	60 - 100 mm
61979	Cutting nozzle	100 - 150 mm
61980	Cutting nozzle	100 - 200 mm
61981	Cutting nozzle	150 - 250 mm
61982	Cutting nozzle	250 - 300 mm

NOZZLE CONSUMPTION VALUES

KAYSER INFORMATION: TYPE AR



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3 - 10	2,5 - 3,5	0,3	1,2 - 1,5	0,30
10 - 25	3,0 - 4,0	0,3	1,5 - 2,8	0,40
25 - 60	3,5 - 4,5	0,3	2,8 - 5,1	0,50
40 - 40	4,0 - 5,0	0,5	4,2 - 5,5	0,60
60 - 100	4,5 - 5,5	0,8	5,5 - 8,9	0,80

KAYSER INFORMATION: TYPE ARS



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3 - 10	2,0 - 3,0	0,5	1,5 - 2,0	0,30
10 - 25	3,0 - 4,0	0,5	2,7 - 3,2	0,35
25 - 40	4,0 - 5,0	0,5	2,7 - 3,2	0,35
40 - 60	4,0 - 5,0	0,5	4,5 - 5,5	0,35
60 - 100	5,0 - 6,0	0,5	8,6 - 10,0	0,40
100 - 200	7,5	0,5	16,0	0,85
200 - 300	7,5	0,5	31,0	0,85

KAYSER INFORMATION: TYPE LPN



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3 - 10	2,0 - 3,0	0,2	2,6 - 3,0	0,35
10 - 25	3,5 - 4,5	0,2	3,2 - 4,1	0,40
25 - 40	4,0 - 5,0	0,2	4,3 - 4,9	0,40
40 - 60	4,5 - 5,5	0,2	6,1 - 7,1	0,40
60 - 100	5,0 - 6,0	0,2	9,6 - 11,0	0,40
100 - 200	5,5 - 8,5	0,3	14,3 - 16,9	0,55
200 - 300	6,5 - 8,5	0,3	25,6 - 32,4	0,75

KAYSER INFORMATION: TYPE PLRC



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3 - 10	2,0 - 3,0	0,2	2,6 - 3,0	0,33
10 - 25	3,0 - 4,0	0,2	4,3 - 4,9	0,38
25 - 60	4,0 - 5,0	0,2	4,3 - 4,9	0,30
40 - 40	4,5 - 5,5	0,2	6,1 - 7,1	0,38
60 - 100	5,5 - 6,0	0,2	9,6 - 11,0	0,38
100 - 200	5,5 - 6,5	0,2	14,3 - 16,9	0,50 - 0,70
200 - 300	6,5 - 8,5	0,2	25,6 - 32,4	0,70 - 0,90

NOZZLE CONSUMPTION VALUES

KAYSER INFORMATION: TYPE AB



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3-10	2,5-3,5	0,3	1,6-2,0	0,30
10-25	3,0-4,0	0,3	2,8-3,5	0,40
25-60	3,5-4,5	0,3	4,5-5,3	0,60
40-60	4,0-5,0	0,3	6,5-8,0	0,70
60-100	4,5-5,5	0,3	10,0-13,0	0,80
100-200	5,0-6,0	0,8	15,0-19,0	1,00
200-300	7,0-8,0	0,8	24,0-28,0	1,50

KAYSER INFORMATION: TYPE AGN



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3 - 10	2,5 - 3,5	0,3	1,25 - 1,65	0,30
10 - 25	3,0 - 4,0	0,3	2,12 - 3,20	0,40
25 - 40	3,5 - 4,5	0,3	3,20 - 4,45	0,45
40 - 60	4,5 - 5,0	0,5	4,50 - 5,50	0,50
60 - 100	4,5 - 5,5	0,5	8,40 - 9,80	0,60
100 - 200	5,0 - 6,5	0,5	13,0 - 15,0	0,75
200 - 300	6,0 - 7,5	0,8	15,0 - 19,0	1,00

KAYSER INFORMATION: TYPE PNME



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
3 - 10	2,0	0,3	2,1	0,30
10 - 25	3,0	0,3	3,2	0,40
25 - 40	3,0	0,3	5,2	0,60
40 - 60	3,5	0,3	7,4	0,80
60 - 150	3,5	0,3	13,6	1,00
150 - 300	3,5 - 6,5	0,3	34,7	1,30

KAYSER INFORMATION: TYPE NFF



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen consumpt. [m ³ /h]	Fuel gas consumpt. [m ³ /h]
6 - 25	2,5 - 3,5	0,5	3,5 - 4,5	0,40
25 - 50	3,0 - 4,0	0,5	4,0 - 4,8	0,40
50 - 75	3,0 - 4,5	0,5	5,0 - 6,5	0,40
75 - 150	3,5 - 5,5	0,5	6,5 - 9,5	0,50
150 - 200	4,5 - 5,5	0,5	10,0 - 14,0	0,60
200 - 300	5,0 - 6,5	0,5	15,0 - 19,0	0,70

NOZZLE CONSUMPTION VALUES

KAYSER INFORMATION: TYPE FAGN



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen cons. [m ³ /h]	Fuel gas cons. [m ³ /h]
1	4,0 - 5,0	0,6	4,0 - 4,7	1,10
2	5,0 - 6,0	0,7	6,3 - 7,3	1,30
3	6,0 - 7,0	0,8	9,3 - 10,0	1,50

KAYSER INFORMATION: TYPE FHR



Cutting range [mm]	Oxygen pressure [bar]	Fuel gas pressure [bar]	Oxygen cons. [m ³ /h]	Fuel gas cons. [m ³ /h]
1	6,0	0,5	5,50	0,60
2	7,0	0,5	6,40	0,90
3	8,0	0,5	16,90	1,10

KAYSER INFORMATION: TYPE PSD



Cutting range [mm]	Cutting speed [bar]	Cutting Oxygen [bar]	Heating Oxygen pressure [bar]	Fuel gas pressure [bar]
3 - 6	740 - 750	2,0 - 5,0	1,5	0,2
7 - 15	560 - 670	5,0 - 7,0	2	0,2
15 - 25	460 - 560	6,0 - 7,0	2	0,2
25 - 40	400 - 460	6,0 - 7,5	2	0,2
40 - 60	340 - 400	5,5 - 7,5	2	0,2
60 - 100	270 - 340	6,0 - 8,5	2	0,2
100 - 200	180 - 270	7,5 - 9,5	4,5	0,6
100 - 150	180 - 270	6,5 - 7,5	4,5	0,3
150 - 250	130 - 180	6,5 - 8,5	4,5	0,3
250 - 300	110 - 130	6,5 - 8,5	5	0,3

Cutting Oxygen cons. [m ³ /h]	Fuel gas cons. [m ³ /h]	Heating Oxygen cons. [m ³ /h]
0,5 - 1,0	0,25	1
1,6 - 2,0	0,32	1,3
2,5 - 3,1	0,32	1,3
3,8 - 4,5	0,32	1,3
4,2 - 5,6	0,32	1,3
7,6 - 10,6	0,32	1,3
13,3 - 16,5	0,60	2,4
13,3 - 16,5	0,32	2,4
18,0 - 22,0	0,60	2,4
23,0 - 30,0	0,62	2,5

CYLINDER COUPLINGS, CONNECTIONS, ACCESSORY, HOSES



CYLINDER COUPLINGS AND TRANSFILLING PIPES

CYLINDER COUPLINGS ACETYLENE



With ball valve and non return valve at cylinder connection acc. to TRAC 206,

Art.-No.	Cylinders
14037463	2
14037464	3
14037465	4
14037466	5
14037467	6

Attention! Please keep in mind Acetylene hoses have to be checked in 5 year terms acc. to TRAC 204, 5.3.7

CYLINDER COUPLINGS PROPANE



With high pressure hoses

Art.-No.	Cylinders
14037822	2
14037823	3
14037824	4
14037825	5
14037826	6

CYLINDER COUPLINGS FOR HIGH PRESSURE GASES



Art.-No.	Gas type	Cylinders
14037621	Oxygen	2
14037341	Oxygen	3
14037350	Oxygen	4
14037352	Oxygen	5
14037624	Nitrogen	2
14037623	Compressed Air	2
14037622	Hydrogen	2

TRANSFILLING PIPES FOR HIGH PRESSURE GASES



Art.-No.	Gas type
14037616	Oxygen
14037617	Hydrogen
14037618	Compressed air
14037619	Nitrogen
14037620	Argon / CO2

ACCESSORY

GAS SAVER WITH PILOT FLAME



Art.-No.	Gases
66390	Acetylene / Oxygen
66395	Propane / Oxygen

GUIDING CARRIAGE FOR TORCHES



Art.-No.	Use
66000	head ø 27 mm (short brackets) for ring nozzles
66003	head ø 25 mm for KE17
9430440	for gas mixing nozzles



Art.-No.	Use
66054	margin guidance bar for guidance carriage length ca. 400 mm
3370017	single wheel guidance carriage (head ø 27 mm)

TWIN VALVE



Art.-No.	Inlet	Use
66100	G 1/4"	for non flammable gases
66110	G 3/8"	for non flammable gases
66120	G 3/8" LH	for flammable gases

TEST GAUGE



Art.-No.	Connection	Indicating range
14008259	G 1/4"	0-10 bar
14008569	G 3/8"	0-10 bar
14008567	G 3/8" LH	0-2,5 bar

ACCESSORY

LIGHTER / FLINT STONES



Art.-No.

66200 pistol form lighter

66201 spare part flint stone 2,6 x 5 mm

66220 clamp form lighter

66221 spare part flint stone 3 x 20 mm

TORCH WRENCH

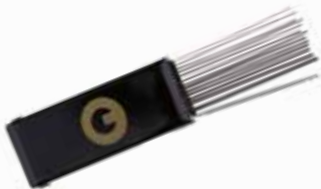


Art.-No.

66230 torch wrench

CLEANING NEEDLES WITH ALU-BOX

consisting of 9 needles (0,5 - 1,6 mm) and 1 rasp



Art.-No.

66300 cleaning needles in Alu box

SCRAPER

Material brass, 3 x 6 rows, diameter of wire 0,15 mm



Art.-No.

66305 scraper

ACCESSORY

HAND CUTTING MIRROR WITH MAGNET

Art.-No.

66380 hand cutting mirror with magnet

66381 replacement mirror blade 1,5 mm



PROTECTION GOGGLES ALU WITH SCREWED RING GLASSES

According to EN 166/170

Art.-No.

66360 goggles Alu 5A DIN

66361 replacement glasses 4A DIN

66362 replacement glasses 5A DIN



PROTECTION GOGGLES SYNTHETICS

Art.-No.

66375 goggles 5A DIN

6637505 replacement glasses 5A DIN (10-pack)

6637506 replacement glasses 6A DIN (10-pack)



ACCESSORY

LCD WELDING HELMET ECLIPSE II



Adjustable helmet with blackness values DIN 9,10,11,12 and 13. Density value DIN 4. closure time 0,3 ms, view field 92 x 42 mm, optical classes 1/2/1, DIN Certco Germany certified

Art.-No.

67300 helmet Eclipse II

LCD WELDING HELMET CHAMPION I



Adjustable helmet with blackness values DIN 9,10,11,12 and 13. Density value DIN 4. Closure time 0,2 ms, 2 optical sensors changeable 3V battery view field 97 x 60 mm, double LCD layer for improved visibility, optical classes 1/1/1/2

Art.-No.

67100 helmet Champion I

SPARE PARTS FOR LCD HELMET

Champion I



Art.-No.

6710002 headband

6710006 headband cushion

6710007 fixing nut for head band

6710008 sweat band

6710009 rubber seal

6710003 helmet casing

6710005 inner attachment pane

6710001 outer attachment pane



6710004 LCD filter

Eclipse II

Art.-No.

6730002 headband

6730008 sweat band

6730003 helmet casing

6730005 inner attachment pane

6730001 outer attachment pane



ACCESSORY

CYLINDER TROLLEY


Art.-No.

66405 suitable for 5l and 10l cylinders

CYLINDER TROLLEY


Art.-No.

66407 suitable for 20l cylinders

CYLINDER TROLLEY


Art.-No.

66409 suitable for 50l cylinders

THREADED NOZZLE


Art.-No.

65100 G 1/8" x 6 mm

65110 G 1/4" x 6 mm

65111 G 1/4" x 9 mm

65120 G 3/8" x 6 mm

65130 G 3/8" LH x 6 mm

65121 G 3/8" x 9 mm

65131 G 3/8" LH x 9 mm

65132 G 1/2" x 9 mm

ACCESSORY

HOSE TAILPIECES ACC. TO DIN EN 560



Art.-No.

65001	G 1/4" x 4 mm
65002	G 1/4" x 6 mm shortened
65003	G 1/4" x 9 mm shortened
65010	G 3/8" x 4 mm
65011	G 3/8" x 6 mm shortened
65012	G 3/8" x 9 mm shortened
65020	G 1/2" x 6 mm
65021	G 1/2" x 9 mm

other dimension available on demand

SWIVEL NUT ACC. TO DIN EN 560



Art.-No.

65049	G 1/4" (for nozzle 9 mm)
65050	G 1/4"
65051	G 1/4" LH
65060	G 3/8"
65062	G 3/8" LH
65070	G 1/2"
65071	G 1/2" LH
65073	G 3/4"
65083	G 3/4" LH

CRIMPING ACCORDING TO DIN EN 1256

Application: assembling of cutting and welding and Propane hoses



Art.-No.	Type	Outer Ø	Inner Ø	Wandstärke
66355	H 10/17	16	6,3 mm	5 mm
		16,3	9 mm	3,5 mm
66356	H 8/13,5	13,3	6,3 mm	3,5 mm
		12	4 mm	4 mm
66357	H 6/12	11	4 mm	3,5 mm

ASS HOSE CLAMPS



Art.-No.	Material	Dimension
66320	synthetics	16 x 16 mm
66335	Aluminium	11 x 11 mm
66340	Aluminium	16 x 16 mm

ACCESSORY

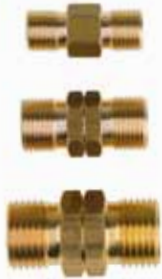
HOSE FITTINGS ACC. TO DIN EN 560


Art.-No.

65150	4 x 4 mm
65151	6 x 6 mm
65153	8 x 8 mm
65152	9 x 9 mm

HOSE COUPLERS

cone shaped seal face


Art.-No.

65200	G 1/4" x G 1/4"
65201	G 1/4" x G 1/4" LH
65202	G 1/4" LH x G 1/4" LH
65203	G 1/4" x G 3/8"
65204	G 1/4" x G 3/8" LH
65208	G 1/4" LH x G 3/8" LH
65216	G 1/4" LH x G 3/8"
65205	G 3/8" x G 3/8"
65206	G 3/8" LH x G 3/8" LH
65207	G 3/8" x G 3/8" LH
65223	G 3/8" x G 1/2"
65224	G 3/8" x G 1/2" LH
65225	G 3/8" LH x G 1/2"
65226	G 3/8" LH x G 1/2" LH
65227	G 3/8" LH x G 3/4"
65230	1/2" x 1/2"
65209	1/2" x 1/2" LH
65232	1/2" LH x 1/2" LH
65233	1/2" x 3/4"
65234	1/2" x 3/4" LH
65235	1/2" LH x 3/4" LH
65243	3/4" x 3/4"
65244	3/4" x 3/4" LH
65245	3/4" LH x 3/4" LH
65246	3/4" x 1"

HOSES

MANUFACTURED ACC. TO EN 1256 / ISO 3821

KAYSER INFORMATION: HOSES

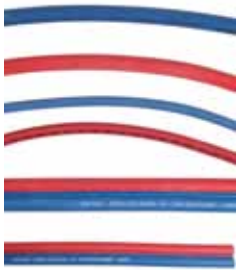
	Inner diameter	Material thickness
Oxygen	6,3	5
Acetylene	9	3,5
Oxygen Lilliput	4	3,5
Acetylene Lilliput	4	3,5

Twin hoses

	Inner diameter	Material thickness
Oxygen / Acetylene	6,3 and 9	5 and 3,5
Oxygen / Acetylene Lilliput	4 and 4	3,5 and 3,5

These Acetylene hoses are also suitable for Hydrogen and Natural Gas, but not for Propane and Propane mixtures.

HOSE UNFITTED



Up to 40m rolls, larger rolls on demand

Art.-No.	Type	Application
63010	Single hose	Oxygen
63011	Single hose	Acetylene
63012	Single hose	Oxygen Lilliput
63013	Single hose	Acetylene Lilliput
63014	Twin hose	Oxygen - Acetylene
63015	Twin hose	Oxygen - Acetylene Lilliput

For Propane hoses please look into our Propane Catalog !

TWIN HOSE FITTED OXYGEN / ACETYLENE



with ASS - clamps, 6,3 x 9,0 mm, fitted

Art.-No.	Length
63107	3 m
63100	5 m
63106	7 m
63200	10 m
63208	15 m
63300	20 m
63311	25 m
63400	30 m
63500	40 m

TWIN HOSE FITTED OXYGEN / ACETYLENE



Lilliput with ASS - clamps, 4,0 x 4,0 mm, fitted

Art.-No.	Length
63050	2,5 m
63101	5 m
63201	10 m
63212	15 m
63301	20 m
63401	30 m
63501	40 m

HOSES

MANUFACTURED ACC. TO EN 1256 / ISO 3821

TWIN HOSE FITTED - OXYGEN / PROPANE

with ASS - clamps, 6,3 x 9,0 mm, fitted



Art.-No.	Length
63155	3 m
63104	5 m
63204	10 m
63304	20 m
63308	25 m
63404	30 m
63504	40 m

TWIN HOSE FITTED - OXYGEN / PROPANE

Liliput with ASS - clamps, 4,0 x 4,0 mm, fitted



Art.-No.	Length
63051	2 m
63052	2,5 m
63053	3 m
63105	5 m
63205	10 m
63305	20 m
63405	30 m
63505	40 m

TWIN HOSE FITTED - OXYGEN / ACETYLENE

6,3 x 9,0 mm, fitted



Art.-No.	Length
63054	2 m
63102	5 m
63202	10 m
63206	15 m
63302	20 m
63402	30 m
63502	40 m

TWIN HOSE FITTED - OXYGEN / ACETYLENE

Liliput, 4,0 x 4,0 mm, fitted



Art.-No.	Length
63005	1,5 m
63003	2,5 m
63103	5 m
63203	10 m
63209	15 m
63303	20 m
63403	30 m
63503	40 m

TERMS AND CONDITIONS OF DELIVERY AND PAYMENT

I. General and Conclusion of Agreement

1. Unless otherwise agreed in writing, our deliveries shall be subject exclusively to the conditions below. On receipt of the goods at the latest, our General Terms and Conditions shall be taken as accepted. The customer's purchasing terms and conditions are hereby expressly excluded, nor shall they comit with us in any way even if they are not expressly excluded at the time of conclusion of the Agreement. In the event of amendments or other subsidiary agreements, the remaining conditions shall retain their full validity.

2. Our offers are always without obligation. In order to be valid, all transactions, orders and other agreements require our confirmation in writing. Our written order confirmation or agreement shall determine the nature and scope of the delivery.

II. Price and Invoicing, Terms of Payment etc.

1. Our normal terms of payment are as follows: 2 % discount for payment within 10 days of date of invoice, 30 days net cash after date of invoice.

2. Unless otherwise agreed, our prices are to be understood in Euros, ex works, excluding packaging.

3. The customer may only set off payment against counterclaims which are undisputed or legally determined.

4. In the event that payment schedules are not maintained, interest of 3 % above the respective EURIBOR interest rate for 3 months.

5. Where payment by bill of exchange is agreed, said bill will only be accepted for payment purposes; in particular, the existing retention of title shall not be affected. In the event that cheques or bills of exchange have not been encashed, either in whole or in part, by the date on which invoices are due for payment, all our unpaid claims shall be due immediately, even where bills of exchange with later due date have been subwithted. We shall only be obliged to make further deliveries if the entire unpaid balance is settled immediately and if cash in advance is provided for the entire amount of the goods to be delivered.

6. For orders below 100 € net value we will charge 10 € arrangement fee. The minimum order value is 50 €.

III. Retention of Title

1. Title shall be retained on all delivered goods (reserve items) until all claims against the customer, for whatever legal reason, have been met in full. This is also then applicable when separate claims or our claims have been included in a current invoice and the account has been balanced and accepted. Any contingent treatment or processing of the reserve items shall be performed by the purchaser on behalf of the seller, without any obligation being placed on the latter as a result. In the event that the reserve items are joined, blended or processed by the customer with other items which do not belong to us, we shall have title to the new object in the proportion of the value of the reserve item to the other items used for joining or processing at the time of such joining or processing.

2. Claims owing to the customer through further sale are herewith already assigned to us together with all accessory claims. In the event of the sale of reserve items together with other items or the sale of processed reserve items (Section 1, 2nd sentence) the claim is herewith assigned to the extent of our invoice amount for the reserve items.

3. In the event of resale abroad, the entire invoice amount shall be due for payment before the goods leave the country.

4. Excess Safeguarding Clause. Provided that the existing collateral security exceeds the debt claims to be secured by more than 15 %, the seller shall undertake to release the appertaining security to the purchaser upon request.

IV. Delivery Schedule and Unforeseen Circumstances

1. The schedule for deliveries and performance shall begin on the day on which agreement is reached between the customer and the supplier in writing. Maintenance of this schedule is subject to provision in due course of all documents, authorisation and releases, to be supplied by the customer, the acceptance and approval of plans, observance of agreed payment schedules and other obligations. In the event that these conditions are not met punctually, the delivery schedule may be extended accordingly.

2. The delivery schedule is deemed to have been maintained if the goods are ready for delivery or fetched within the agreed delivery and performance schedule. In the event that delivery is delayed at the fault of the customer, the delivery schedule is deemed to have been met if the Supplier notifies readiness for dispatch within the said schedule.

3. In the event of unforeseen hindrances outside of our control which occur either with us or with our own suppliers, such as force majeure, transport disruptions, strikes and lockouts and other operating disruptions which we are unable to prevent, the delivery schedule shall be extended accordingly.

4. In the event that the customer does not collect the ordered goods within 14 days of notification of readiness for dispatch or after shipment, we shall be entitled, after allowing an additional period of 14 days, to withdraw from the Agreement and/or claim for damages on account of non-fulfilment.

5. In the event that dispatch of the ordered goods is delayed at the request of the customer and with our agreement, he shall be charged for the costs of storage in our factory, a minimum of 0.5 % of the invoice value, for every month or part thereof, starting from the month following notification of readiness for dispatch.

6. If the customer suffers damage because we are in arrears with the delivery, he shall be entitled to demand a lump-sum compensation for damage resulting from delay. It shall be 0.5% for each full week of delay, however altogether a maximum of 5% of the value of the portion of the overall delivery that cannot be used in due time or not at all pursuant to the contract as a result of the delay. If the customer grants us an appropriate period for performance because of the delay in delivery taking the legal exceptions into consideration and if we do not comply with the period, the customer shall be entitled to withdraw in the framework of the legal regulations.

7. Further claims arising from a delay in delivery are exclusively determined according to section VII.2 of these conditions.

V. Transfer of Risk

1. Complaints can only be taken into account if subwithted within 8 days of receipt of the goods. Delivered goods will only be accepted in return in their original packing. Illustrations and brochures etc. are not binding. Measurements and utilisation data are only to be regarded as approximate and are also not binding.

2. The risk shall pass to the customer, even in the event of delivery carriage-paid, as soon as the ready delivery is dispatched or collected. Unless the customer has given special dispatch instructions, delivery may be made at our discretion by the most suitable means. On request of the customer the delivery will be insured at his cost against breakage, transport and damage from fire or water.

3. In the event that dispatch or delivery is delayed at the request of the customer or for

reasons for which he is responsible, the risk shall pass to the customer for the period of the delay, however at the request of the customer, we shall arrange the insurance cover he requires at his expense.

VI. Warranty Claims

Warranty claims shall be recognised, if the defect has been reported to us in writing within 12 months of the delivery date. To the exclusion of further claims – subject to section VII – we will provide a warranty as follows:

1. We shall have the option to either replace or to carry out repairs free of charge on all those parts which prove to be defective due to circumstances which occurred prior to the transfer of risk. The discovery of such defects must be reported to us immediately in writing. Replaced parts become our property.

2. If we have to supply according to drawings, specifications, samples etc. provided by the customer, then the customer carries the risk for the suitability for the intended purpose. Decisive for the condition of the goods conforming to the agreement is the point in time of the transfer of risk according to section V.

3. If a final inspection of the goods has been agreed or an inspection of the first sample, then customer's complaints will not be recognised later concerning defects which the customer should have noticed at the final inspection or inspection of the first sample if it had been carried out with due care and attention.

4. We must be given an opportunity to confirm the defect the complaint is being made about. Rejected goods must be returned to us immediately on demand. We will bear the transport costs if the customer complaint is justified. If the customer does not comply with these obligations or makes changes to the rejected goods without our agreement, then he forfeits any claims under warranty of quality.

5. Only in urgent cases, in which operational security is endangered or to prevent a disproportionate amount of damage being incurred, does the customer have the right to remedy the defect or have it remedied by a third party and to demand compensation from us for expenses thus incurred, whereby we must be informed immediately.

6. Of costs incurred due to the rectification of defects or the replacement delivery, providing the complaint proves to be justified, we will bear the costs for the replacement goods including transport and also reasonable costs for disassembly and assembly.

7. Within the framework of legal provisions, the customer has the right to withdraw from the contract if, taking the legal exceptions into consideration, we do not successfully make use of a reasonable period of time given to us for rectification of defects or a replacement delivery due to a redhibitory defect. If the defect is insignificant, then the customer only has the right to claim a reduction of the contractual price. In all other cases the right to a reduction of the agreed price is excluded.

8. No warranty will be given in the following cases in particular: Unsuitable or inappropriate use, faulty installation or start-up by the customer or a third party, natural wear and tear, incorrect or negligent treatment, maintenance not carried out correctly, unsuitable construction work, unsuitable foundation, chemical, electrochemical or electrical influences providing we are not liable for them.

9. If the customer or a third party reworks the goods incorrectly, then we are not liable for the consequences arising from this. The same applies to changes made to the delivery item without our prior agreement.

10. We only provide a warranty for accessories added on within the framework of the warranty provided by our supplier.

VII. Liability

1. If we are responsible for the customer not being able to use the delivery item as stipulated in the contract as a consequence of suggestions made and consultations carried out before or after the contract was concluded which were omitted or carried out incorrectly or through infringing upon other subsidiary obligations - in particular instructions for operating and maintaining the delivery item - then to the exclusion of further claims made by the customer, the stipulations in sections VI and VII.2 apply correspondingly.

2. For damages, which have not been incurred by the delivery item itself, we only accept liability - whatever legal reasons are given - in the case of

- intent
 - gross negligence by executive employees
 - culpable injury of life, body, health
 - malicious silence with regard to a defect or the nonexistence of which had been guaranteed
 - defects of the delivery item for which liability must be accepted according to the German Law on Product Liability for damages to persons or property with regards to privately used objects. In the case of culpable infringement of essential contractual obligations, we also accept liability for gross negligence of non-executive employees and in the case of slight negligence, in the latter case liwithed to reasonable, foreseeable damages
- Typical to a contract. Any further claims shall be excluded.

VIII. Statutory Liwithation

All claims made by the customer - for whatever legal reasons - are subject to a liwithation period of 12 months. For wilful or fraudulent behaviour and for claims based on the German Product Liability Law, the legal liwithations apply. They shall also apply to defects in a building structure or for delivery items that were used in accordance with the normal use for a building structure and caused its defectiveness.

IX. Place of performance and jurisdiction

1. Place of fulfilment and exclusive place of jurisdiction for all claims arising out of this agreement, including proceedings related to bills of exchange, cheques or documents, shall be Dortmund.

2. German law shall be applicable to matters arising out of this Agreement.

X. Validity of the Agreement

Should one or more of the provisions of this Agreement be or become invalid for any reason, the provisions should be interpreted to ensure that the commercial aim of the original, invalid provision is upheld. The validity of the remaining provisions shall remain unaffected.



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