



PRODUCT INFORMATION

PROPANE SUPERHEATING EQUIPMENT

DESCRIPTION

Propane heating is an ideal process for when large volumes of intense heat over a wide area are required, in applications such as shaft bending or straightening, brazing or heavy copper pipe manipulation. The equipment required for this process is Type 3 or 'HD' style gas equipment, with the simple addition of a propane mixer (BB5004), the appropriate length neck and a suitable nozzle.

Alternatively, an NM cutter can be used with the NM propane superheating adapter nozzle (BFNMSHA).



BF1H



BFNMSHA

FURTHER INFORMATION

Compatible Equipment: Type 3 'HD' style shank (BB5001) with superheating mixer (BB5004), NM 18/90 or 27/90 universal cutters. Weldability also provide **acetylene** heating gas equipment, which provide quick and efficient heat provision with economically low oxygen use. See sheet BFAHT05.

The flame size and heat output of these nozzles vary considerably with the pressure setting used. Two typical alternatives are given for each size of nozzle. Heat output figures are quoted for combined torches using necks. Figures up to 20% higher will be achieved by using a NM type cutter with a superheating adapter. To identify the correct pressure settings for your application, see the Superheating Nozzle Data chart below.

| Nozzle Type | Propane | | Oxygen Pressure | | Propane Consumption | | Oxygen Consumption | | Heat Output (est) | |
|-------------|---------|-----|-----------------|-----|---------------------|--------------------|--------------------|--------------------|-------------------|--------|
| | bar | psi | bar | psi | l/h | ft ³ /h | l/h | ft ³ /h | W | Btu/h |
| 1H | 0.14 | 2 | 0.7 | 10 | 830 | 29 | 350 | 121 | 244800 | 72000 |
| | 0.49 | 7 | 2.1 | 30 | 1900 | 65 | 7300 | 255 | 554200 | 163000 |
| 2H | 0.21 | 3 | 1.1 | 15 | 1200 | 41 | 4800 | 168 | 348800 | 102000 |
| | 0.56 | 8 | 2.5 | 35 | 2100 | 75 | 8700 | 304 | 639200 | 188000 |
| 3H | 0.28 | 4 | 1.8 | 25 | 2100 | 75 | 8300 | 290 | 62200 | 18300 |
| | 1.1 | 15 | 5.0 | 70 | 4100 | 144 | 16500 | 575 | 1227400 | 361000 |
| 4H | 0.35 | 5 | 2.5 | 35 | 2700 | 94 | 10600 | 370 | 802400 | 236000 |
| | 1.3 | 18 | 5.7 | 80 | 4800 | 162 | 18800 | 650 | 1380400 | 406000 |
| 5H | 0.85 | 12 | 3.5 | 50 | 3200 | 112 | 12700 | 444 | 955400 | 281000 |
| | 2.1 | 30 | 8.7 | 125 | 7000 | 246 | 28000 | 964 | 2101200 | 618000 |



ARTICLES & ACCESSORIES

| Part Number | Product Description |
|-------------|--------------------------------|
| BB5001 | HD SHANK (T3) |
| BB5004 | PROPANE SUPERHEATING MIXER |
| BFSN11 | SUPERHEATING NECK 11" |
| BFSN27 | SUPERHEATING NECK 27" |
| BF1H | 1H TYPE SUPERHEATING NOZZLE |
| BF2H | 2H TYPE SUPERHEATING NOZZLE |
| BF3H | 3H TYPE SUPERHEATING NOZZLE |
| BF4H | 4H TYPE SUPERHEATING NOZZLE |
| BF5H | 5H TYPE SUPERHEATING NOZZLE |
| BFNMSHA | NM SUPERHEATING NOZZLE ADAPTER |

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@weldability-sif.com

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