

4200 Group Tips

One-Piece Acetylene



4202 Series Acetylene Tips

Hand Cutting Tips

Metal Thickness		Tip Size		Part Number	Number Preheat Holes	Cleaning Preheat	Drill Size Cutting	
in.	mm	in.	mm				in.	m
1/8	3	1/8	3	638869	4	73	76	1.9
3/16-1/4	4-6	1/4	6	16K08	6	73	68	1.7
1/2	13	1/2	13	16K09	6	73	60	1.5
3/4-1-1/2	19-38	1-1/2	38	16K10	6	69	55	1.4
2-4	50-100	4	100	16K11	6	68	50	1.3
6	150	6	150	16K12	6	64	43	1.1
8-10	200-250	10	250	16K13	6	60	35	0.9
12	300	12	300	16K14	6	56	30	0.8

- General purpose
- Medium preheat, sufficient for beveling



Operating Data

Metal Thickness		Tip Size		Part Number	Gas Pressure			Gas Consumption			Average Kerf Width	
					Cutting Oxygen	Acetylene	Cutting Speed	Total Oxygen	Acetylene			
in.	mm	in.	mm		psig	psig	ipm	mm/min	cfh	cfh	in.	mm
1/16	1.6	1/8	3.2	638869	30-40	5-7	36-40	914-1016	20-25	5-8	.050	1.3
1/8	3.2	1/8	3.2	638869	30-40	5-7	34-38	864-965	25-32	8-10	.055	1.4
1/4	6	1/4	6.4	16K08	30-40	5-7	28-32	711-813	38-45	8-10	.055	1.4
3/8	9.5	1/2	13	16K09	30-40	5-7	23-27	584-685.5	55-60	9-11	.060	1.5
1/2	13	1/2	13	16K09	30-40	5-7	18-22	457-589	70-75	10-12	.065	1.7
5/8	16	1-1/2	38	16K10	30-40	5-7	16-20	406-508	78-83	10-12	.070	1.8
3/4	19	1-1/2	38	16K10	30-40	5-7	14-18	356-457	95-102	12-14	.075	1.9
1	25	1-1/2	38	16K10	35-40	5-7	13-15	330-381	120-125	14-16	.080	2.0
1-1/2	38	1-1/2	38	16K10	50-55	5-7	11-13	279-330	168-175	16-20	.090	2.3
2	50	4	100	16K11	40-45	6-10	10-12	254-305	195-205	18-20	.095	2.4
3	76	4	100	16K11	50-60	6-10	10-11	254-279	230-240	18-22	.100	2.5
4	100	4	100	16K11	60-75	6-10	8-10	203-254	300-325	21-25	.110	2.8
5	127	6	152	16K12	60-70	10-12	7-9	178-229	340-380	22-25	.130	3.3
6	152	6	152	16K12	60-70	10-12	6-8	152-203	410-460	25-28	.160	4.0
8	200	10	250	16K13	65-75	10-12	4-6	102-152	600-640	30-35	.170	4.3
10	250	10	250	16K13	80-90	10-12	1-2	25-50	680-740	40-45	.190	4.8
12	305	12	305	16K14	75-85	10-12	1-2	25-50	800-860	48-52	.210	5.3

4216 Series Propylene Tips

Hand Cutting Tips

Metal Thickness		Tip Size		Part Number	Number Preheat Holes	Cleaning Preheat	Drill Size Cutting	
in.	mm	in.	mm				in.	m
1/8-1/4	3-6	1/4	6	998589	8	67	68	1.7
1/2	13	1/2	13	998590	8	67	60	1.5
3/4-1-1/2	19-38	1-1/2	38	998591	8	64	53	1.3
2-4	50-100	4	100	998592	8	62	46	1.2
6-8	150-200	8	200	998593	8	59	39	1.0

- Heavy preheat for scrap cutting and beveling in excess of 45°
- See torch datapage for operating data



Given pressures are torch inlet pressures, not what to set regulator at; hose length, diameter, flash arrestor use, and many other factors affect pressure. Use test gauge adaptors to check pressure at back of torch.

When using tips larger than 6 in. (152 mm), ESAB recommends using straight (hand) cutting torches, not combination torches.

ESAB Welding and Cutting Products

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4200 Group Tips

One-Piece Alternate Fuels



4203 Series Natural Gas & Propane Tips

Hand Cutting Tips

Metal Thickness		Tip Size		Part Number	Number Preheat Holes	Cleaning Preheat	Drill Size Cutting	
in.	mm	in.	mm				in.	m
3/8-5/8	9-15	3/4	19	16K15	6	73	60	1.5
3/4-1-1/2	19-38	1-1/2	38	16K16	6	69	55	1.4
2-4	50-100	4	100	16K17	6	68	50	1.3
5-6	125-150	6	150	16K18	6	64	43	1.1

- General purpose cutting with natural gas or propane
- Medium preheat sufficient for beveling



Operating Data

Metal Thickness		Tip Size		Part Number	Gas Pressure		Cutting Speed		Gas Consumption		Average Kerf Width	
					Cutting Oxygen	Propane or Natural Gas			Total Oxygen	Propane or Natural Gas		
in.	mm	in.	mm		psig	psig	ipm	mm/min	cfh	cfh	in.	mm
3/8	9	4	100	16K15	20-28	3-5	19-23	483-584	70-80	6-8	.060	1.5
1/2	13	4	100	16K15	30-35	3-5	17-21	432-533	80-100	8-10	.065	1.7
5/8	15	4	100	16K15	38-45	3-5	15-19	381-483	110-120	9-11	.070	1.8
3/4	19	5	125	16K15	25-30	3-5	15-19	381-483	125-140	9-11	.075	1.9
1	25	5	125	16K16	30-40	3-5	13-17	330-432	140-150	10-12	.080	2.0
1-1/2	38	5	125	16K16	48-62	3-5	11-15	280-381	190-210	12-14	.090	2.3
2	50	7	180	16K17	35-44	5-10	10-14	254-356	225-245	12-16	.095	2.4
3	76	7	180	16K17	40-56	5-10	8-10	203-356	250-290	13-18	.100	2.5
4	100	7	180	16K17	62-74	5-10	7-9	180-230	300-340	14-18	.110	2.8
5	130	9	230	16K18	58-62	10-15	3-4	76-100	400-450	15-20	.130	3.3
6	150	9	230	16K18	68-74	10-15	3-4	76-100	470-520	16-20	.170	4.3

Given pressures are torch inlet pressures, not what to set regulator at; hose length, diameter, flash arrestor use, and many other factors affect pressure. Use test gauge adaptors to check pressure at back of torch.

When using tips larger than 6 in. (152 mm), ESAB recommends using straight (hand) cutting torches, not combination torches.

4200 Group Tips

Two-Piece Alternate Fuels



4217 Series

Hand Cutting Tips

Metal Thickness		Tip Size		One-Piece or Internal Part Number	External Sleeve Natural Gas Propane	Number Preheat Holes	Cleaning Preheat	Drill Size Cutting	
in.	mm	in.	mm					in.	m
1/4	6	1/4	6	19485	19518	12	◇	68	1.7
1/2	13	1/2	13	19486	19518	12	◇	60	1.5
1	25	1	25	19487	19518	12	◇	53	1.3
2	50	2	50	19488	19518	12	◇	50	1.3
4	100	4	100	19489	19519	20	◇	43	1.1
6	150	6	150	19490	19519	20	◇	39	1.0
8	200	8	200	19491	19519	20	◇	35	0.9
12	300	12	300	19492	19519	20	◇	31	0.8

- General purpose
- Medium preheat sufficient for beveling



◇ Use soft bristled brush to clean preheat slots of internals.

Ordering Information

Metal Thickness		Alternate Fuels		
in.	mm	Set Part Number	Internal	External
1/4	6	0558005123	19485	19518
1/2	13	0558005124	19486	19518
1	25	0558005125	19487	19518
2	50	0558005126	19488	19518
4	100	0558005127	19489	19519
6	150	0558005128	19490	19519
8	200	0558005129	19491	19519
12	300	0558005130	19492	19519

Operating Data

Metal Thickness		Internal Part Number	Gas Pressure				Gas Consumption				Cleaning Drill Size	
in.	mm		Oxygen	Propylene	Propane	Natural Gas ¹	Oxygen	Propylene	Propane	Natural Gas	in.	m
		Number	psig	psig	psig	psig	cfh	cfh	cfh	cfh		
1/4	6	19485	30	4	6	7	70	8	12	30	68	1.7
1/2	13	19486	35	4	7	8	120	9	14	32	60	1.5
1	25	19487	40	4	8	9	180	10	15	35	53	1.3
2	50	19488	45	5	9	10	250	11	16	40	50	1.3
4	100	19489	40	4	8	10	370	12	18	45	43	1.1
6	150	19490	50	5	12	13	520	14	20	50	39	1.0
8	200	19491	50	6	15	16	610	16	22	55	35	0.9
12	300	19492	75	8	18	20	860	20	30	85	31	0.8

Given pressures are torch inlet pressures, not what to set regulator at; hose length, diameter, flash arrestor use, and many other factors affect pressure. Use test gauge adaptors to check pressure at back of torch.

When using tips larger than 6 in. (152 mm), ESAB recommends using straight (hand) cutting torches, not combination torches.

4200 Group Tips Specialty



4206 Series Acetylene Tips

Special Tips Acetylene

Tip Size		No Preheat Holes	Part Number	Drill Size Cutting
in.	mm			
3/16	5	5	16K33	68

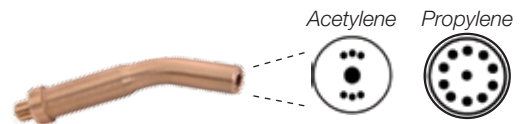
- Light preheat for cutting sheet metal



4207 & 4218 Tips

Special Tips Acetylene, Propylene-Gouging

- Designed for grooving, gouging, and plate edge preparation



Operating Data

Tip Series	Approximate Groove Dimensions				Tip Size	Part Number	Gas Pressure			Gas Consumption			Gouging Speed		
	Width		Depth				Oxygen	Acetylene	Propylene	Oxygen	Total Acetylene	Propylene			
	in.	mm	in.	mm			in.	mm	psig	psig	psig	cfh	cfh	cfh	ft./min.
4207	1/4-5/16	6-8	1/8-1/4	3-6	13	330	16K67	35-40	9-10	-	157-180	33-38	-	1.0-1.8	0.3-0.5
4207	3/8-7/16	9.5-11	1/4-3/8	6-9.5	19	483	16K35	45-50	12-14	-	268-303	50-55	-	1.6-2.2	0.5-0.7
4218	3/8-7/16	9.5-11	1/4-3/8	6-9.5	18	457	0558011948	80-90	-	5-10	270-300	-	50-55	1.6-2.2	0.5-0.7

4209 Series Acetylene Tips

Special Tips Hand Cutting, Gouging, Groove Cutting

Rivet or Bolt Diameter		Tip Size		Number Preheat Holes	Part Number
in.	mm	in.	mm		
5/8-3/4	16-19	5	127	2	16K47

- Designed for rivet busting and bolt removal



Operating Data

Rivet or Bolt Diameter		Tip Size		Part Number	Gas Pressure		Gas Consumption	
					Oxygen	Acetylene	Oxygen	Total Acetylene
in.	mm	in.	mm		psig	psig	cfh	cfh
5/8-3/4	16-19	5	127	16K47	20-35	3-5	85-92	12-14

Given pressures are torch inlet pressures, not what to set regulator at; hose length, diameter, flash arrestor use, and many other factors affect pressure. Use test gauge adaptors to check pressure at back of torch.

When using tips larger than 6 in. (152 mm), ESAB recommends using straight (hand) cutting torches, not combination torches.