



Cutting Tips

CONCOA/AIRCO Seat Acetylene General Purpose



Style 124 - 1 Piece

Light preheat, for clean surfaces; straight line and shape cutting. Four (4) preheat flames.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Fuel		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	
854-2499	1/8	00	69 (.029)	30	32	3	6	18-20
854-2400	1/4	0	64 (.036)	30	51	3	9	16-18
854-2401	3/8	1	57 (.043)	30	73	3	12	15-17
854-2402	3/4	2	55 (.052)	40	113	3	14	11-13 1/2
854-2403	1 1/4	3	53 (.059)	40	166	3	16	10-12
854-2403	1 1/2	3	53 (.059)	45	180	3	16	9-11
854-2403	2	3	53 (.059)	50	195	3	16	7-9



Style 138 - 1 Piece

Light preheat tip designed for fine contour cutting with hand cutting torches and is recommended for machine cutting applications. Six (6) preheat flames.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Fuel		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	
854-3899	1/8	00	69 (.029)	30	30	1 1/2	11	21-24
854-3800	1/4	0	64 (.036)	30	54	3	11	18-22
854-3801	3/8	1	57 (.043)	30	76	3	13	18-21
854-3802	3/4	2	55 (.052)	40	127	3	15	14-16
854-3803	1 1/2	3	53 (.059)	45	183	3	16	11-14
854-3804	2 1/2	4	50 (.070)	50	257	3	20	8-10



Style 144 - 1 Piece

Designed for general purpose hand cutting applications over wide range of plate surface conditions. For material over 7' use style 164. Four (4) preheat flames.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Fuel		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	
854-4499	1/8	00	69 (.029)	30	33	1 1/2	11	21-24
854-4400	1/4	0	64 (.036)	30	57	2	14	20-23
854-4401	3/8	1	57 (.043)	30	84	3	20	18-21
854-4402	3/4	2	55 (.052)	40	134	3	22	14-17
854-4403	1 1/2	3	53 (.059)	45	190	3	23	11-14
854-4404	2 1/2	4	50 (.070)	50	263	3	25	8-11
854-4405	3	5	47 (.078)	45	313	4	31	7-10
854-4406	5	6	42 (.093)	50	457	5	43	5-7
854-4406	6	6	42 (.093)	55	492	5	43	5-6
854-4406	7	6	42 (.093)	65	552	5	43	4-5

Cutting Tips



CONCOA/AIRCO Seat Acetylene General Purpose



Style 164 - 1 Piece

Very heavy preheat. It is well suited for work requiring heavy preheat such as rusted or heavily painted plate. Six (6) preheat flames.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Fuel		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	
854-6499	1/8	00	69 (.029)	25	33	1 1/2	13	22-26
854-6400	5/16	0	64 (.036)	30	60	2	17	20-24
854-6401	1/2	1	57 (.043)	40	105	3	25	17-20
854-6402	1	2	55 (.052)	50	160	3	27	14-16
854-6403	1 3/4	3	53 (.059)	50	210	3	29	11-15
854-6404	2 1/2	4	50 (.070)	50	275	3	31	9-13
854-6405	4	5	47 (.078)	60	400	4	45	7-10
854-6406	6	6	42 (.093)	55	505	5	52	5-8
854-6407	8	7	36 (.106)	60	680	6	70	4-6
854-6408	10	8	1/8 (.125)	55	760	6	70	3 1/2-5
854-6411	14	11	10 (.193)	90	1260	8	85	2 1/2-4
854-6412	16	12	2 (.221)	105	1450	7	125	2 1/2-3 1/2



Style 45 - 1 Piece Brass

Acetylene Machine Cutting Tips with Divergent Bore. This tip has medium preheat ideal for shape cutting. Six (6) preheat flames

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Fuel		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	
813-4500	1/4	1/4	74 (.022)	120	70	3	14	24-28
813-4501	3/8	3/8	69 (.029)	85	87	3	18	23-26
813-4501	1/2	1/2	69 (.029)	100	98	3	18	18-22
813-4502	3/4	3/4	65 (.035)	100	122	3	18	17-21
813-4502	1	1	65 (.035)	110	130	3	18	16-20
813-4503	1 1/4	1 1/4	58 (.042)	85	153	4	25	16-19
813-4503	1 1/2	1 1/2	58 (.042)	100	171	4	25	14-17
813-4504	2	2	56 (.046)	100	228	4	25	11-15
813-4504	2 1/2	2 1/2	56 (.046)	110	244	4	25	9-13



Style 112 - 1 Piece

Style 112 has a flat seat. It is a one-piece float seat design with a medium preheat. Used with 4490 cutting attachment which fits 475 torch (TOTE-WELD®)

Materials Thickness (Inches)	Tip Size	Stock Number	Drill Size
1/8	00	854-1229	68 (.031)
1/4	0	854-1200	62 (.038)
1	1	854-1201	56 (.046)
2	2	854-1202	54 (.055)
2 1/2	3	854-1203	52 (.063)

Cutting Tips



Cutting Tips

CONCOA/AIRCO Seat Acetylene Tips



Style 119 - 1 Piece

Light-preheat tip, milled on 2 sides for sheet metal cutting and restricted areas. (2 preheat flames)

Materials Thickness (Inches)	Tip Size	Stock Number	Preheat Flames
1/4	0	854-1900	2
3/8	1	854-1901	2
1/2	2	854-1902	2
3/4	3	854-1903	2

Use with Torch Series Cutting Attachment or Hand Cutting Torch
4700, 4800, 5700, 5800, 3000, 9000, 9500, 9700



Style 183 - 1 Piece

Medium-preheat tip, with 2 sides milled flat. It has a flared cutting orifice that provides large low velocity oxygen stream for grooving, gouging and removing imperfect welds. The tip is angled 20°. (6 preheat flames)

Stock Number	Depth	Gas Pressure Settings		Tip Size
		Acetylene	Oxygen	
854-8306	1/8-1/4	3	50-65	6
854-8308	1/4-3/8	5	65-85	8
854-8310	3/8-1/2	6	85-100	10
854-8312	> 1/2	6	85-100	12

Use With Torch Series Cutting Attachment or Hand Cutting Torch
4700, 4800, 5800, 3000, 9000, 9500, 9700



Style 185 - 1 Piece

Medium-preheat tip, with 2 sides milled flat for grooving, gouging, and removing imperfect welds. (6 preheat flames)

Stock Number	Gas Pressure Settings		Tip Size
	Acetylene	Oxygen	
854-8506	5-9	35-60	6
854-8508	9-12	35-60	8
854-8510	9-12	35-60	10

Use With Torch Series Cutting Attachment or Hand Cutting Torch
4700, 4800, 5700, 5800

Cutting Tips



CONCOA/AIRCO Seat Acetylene Tips



Style 195 - 1 Piece

Medium preheat tip. It has a flared cutting orifice that provides a large, low velocity oxygen stream with one side milled flat. It can be used for hand-cutting rivet heads and bulkheads. Tip is angled 45°. (3 preheat flames)

Materials Thickness (Inches)	Tip Size	Stock Number	Preheat Flames
3/8	1	854-9501	3
1/2	2	854-9502	3
3/4	3	854-9503	3
1	4	854-9504	3
2	5	854-9505	3

Use with Torch Series Cutting Attachment or Hand Cutting Torch
4700, 4800, 5700, 5800, 3000, 9000, 9500, 9700



Style 196 - 1 Piece

Flared cutting orifice that provides a large, low velocity oxygen stream for rivet washing. It has a heavy preheat. (6 preheat flames)

Stock Number	Tip Size	Cutting Attachment or Hand Cutting Torch
854-9608	8	4700, 4800, 5800, 3000, 9000, 9500, 9700
854-9610	10	
854-9612	12	
854-9614	14	



(Shown Actual Size)

STYLES 124, 138, 144 & 164 The physical dimensions and appearance of these four styles are similar. The variations are in size and number of preheat orifices and the cutting oxygen bore size. All are made of high quality tellurium cooper and have a 3/4" (19 mm) diameter.

Hand Cutting Torches Series	Cutting Attachments Series	Machine Torch Series
3000, 7000, 9000, 9500 & 9700	3500, 4700, 4800, 5700 & 5800	4700 Series

Cutting Tips



Cutting Tips

Stinger® CONCOA/AIRCO Seat Natural Gas and Propane Tips

Stinger® tips incorporate a new, more efficient design. These new cutting tips are made using state-of-the-art techniques and equipment. The result is a cutting tip that gives sharp, defined preheat flames for uniform heat transfer and a perfect oxygen cutting stream for smooth face cuts...every time.



- Available in all popular seat sizes for Airco torches.
- Straight bore for hand torches or divergent bore for high speed machine torches
- Splines are manufactured to exact tolerances for better preheat flames and maximum heat transfer
- Extra long oxygen stream for smoother face cuts



Style 275 - 2 Piece

This precision-made two-piece tip features excellent preheat flames and a cutting oxygen stream or "Stinger" which is significantly better than with conventional cutting tips. Sizes 00 through 5 feature a 22° "V" spline design that provides maximum heat transfer and flame stability. Sizes 6, 7 and 8 employ a 36° "V" spline design to provide increased gas flows and extra secondary flame length required on thicker plate. The Style 275 is for hand or machine cutting.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	PSI	CFH	
813-2799	3/16	00	72 (.025)	25	55	2-4	18	2	8	20-24
813-2750	1/4	0	68 (.031)	35	65	2-4	18	2	8	20-24
813-2750	3/8	0	68 (.031)	40	86	3-5	25	3	11	19-23
813-2751	1/2	1	62 (.038)	45	115	3-5	28	3	12	19-23
813-2752	1	2	56 (.046)	55	177	3-5	28	3	12	14-19
813-2753	1 1/2	3	54 (.055)	55	235	4-7	30	4	14	12-16
813-2754	2 1/2	4	52 (.063)	55	300	4-7	30	4	14	9-13
813-2755	3	5	49 (.073)	50	365	5-8	35	5	16	8-11
813-2756	6	6	39 (.128)	60	610	5-8	35	5	16	5-8
813-2756	8	6	39 (.128)	65	635	5-8	35	5	16	4-6
813-2757	10	7	30 (.169)	65	900	5-8	50	6	18	3-5
813-2757	12	7	30 (.169)	70	975	5-8	50	6	18	3-5
813-2758	14	8	18 (.169)	70	1290	5-8	50	6	18	2-4



Style 375 - 2 Piece

The 375 is identical to the 275, except the cutting oxygen bore is diverged to allow higher cutting oxygen pressure for increased speed in machine cutting operation. For plates over 4" use Style 275.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	PSI	CFH	
813-3750	3/8	0	68 (.031)	70	62	2-4	25-33	2-3	11-14	20-22
813-3751	1/2	1	62 (.038)	80	115	3-5	30-40	3-4	12-16	18-22
813-3751	5/8	1	62 (.038)	85	121	3-5	30-40	3-4	12-16	18-21
813-3752	1	2	56 (.046)	95	133	3-5	30-40	3-4	12-16	18
813-3753	1 1/2	3	54 (.055)	90	186	4-6	35-45	4-5	14-18	16
813-3754	2 1/2	4	52 (.063)	90	270	4-6	35-45	4-5	14-18	12
813-3755	3	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	11
813-3755	4	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	10

CONCOA

1501 Harpers Road • Virginia Beach, VA 23454 USA

1.800.225.0473 • 757.422.8330 • Fax: 757.422.3125 • www.concoa.com

Cutting Tips



CONCOA/AIRCO Seat Natural Gas and Propane Tips



Heavy Shell Style 219 - 2 Piece

This precision made two-piece hand or machine cutting tip features excellent preheat flames and a cutting oxygen stream or "Stinger" which is significantly better than with conventional cutting tips. Sizes 00 through 5 feature a 22° "V" spline design that provides maximum heat transfer and flame stability. Sizes 6, 7 and 8 employ a 36° "V" spline design to provide increased gas flows and extra secondary flame length required on thicker plate.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	PSI	CFH	
813-2190	1/4	00	72 (.025)	35	65	2-4	18	2	8	20-24
813-2190	3/8	0	72 (.025)	40	86	3-5	25	3	11	19-23
813-2191	1/2	1	68 (.031)	45	115	3-5	28	3	12	19-23
813-2192	1	2	62 (.038)	55	177	3-5	28	3	12	14-19
813-2193	1 1/2	3	56 (.046)	55	235	4-7	30	4	14	12-16
813-2194	2 1/2	4	54 (.055)	55	300	4-7	30	4	14	9-13
813-2195	3	5	52 (.063)	50	365	5-8	35	5	16	8-11
813-2196	6	6	39 (.089)	60	610	5-8	35	5	16	5-8
813-2196	8	6	39 (.089)	65	635	5-8	35	5	16	4-6
813-2197	10	7	30 (.169)	65	900	5-8	50	6	18	3-5
813-2197	12	7	30 (.169)	70	975	5-8	50	6	18	3-5
813-2197	14	8	18 (.169)	70	1290	5-8	50	6	18	2-4



Heavy Shell Style 319 - 2 Piece

The 319 is identical to the 219, except the cutting oxygen bore is diverged to allow higher cutting oxygen pressure for increased speed in machine cutting operation. For plates over 4" use Style 219.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	PSI	CFH	
813-3190	3/8	0	68 (.031)	70	62	2-4	25-33	2-3	11-14	20-22
813-3191	1/2	1	62 (.038)	80	115	3-5	30-40	3-4	12-16	18-22
813-3191	5/8	1	62 (.038)	85	121	3-5	30-40	3-4	12-16	18-21
813-3192	1	2	56 (.046)	95	133	3-5	30-40	3-4	12-16	18
813-3193	1 1/2	3	54 (.055)	90	186	4-8	35-45	4-5	14-18	16
813-3194	2 1/2	4	52 (.063)	90	270	4-8	35-45	4-5	14-18	12
813-3195	3	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	11
813-3195	4	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	10



CHT Cutting Tips

CHT Cutting Tips (concentrated heat tip) are a series of tips designed to bevel cut with propane or natural gas without the use of auxiliary preheat devices. For bevels up to 75°. NOTE: Intended for beveling only. CHT tips require special use procedure.

Materials Thickness (Inches)	Tip Size	Stock Number	Drill Size
1	3	813-2813	56 (.046)
1 1/2	4	813-2814	54 (.055)
2 1/2	5	813-2815	52 (.063)
4	6	813-2816	49 (.073)
6	7	813-2817	39 (.099)
8	8	813-2818	30 (.128)
10	9	813-2819	18 (.169)

Cutting Tips



Cutting Tips

CONCOA/AIRCO Seat Natural Gas and Propane Tips



Style 297 - 2 Piece

Rivet washing tip with heavy preheat and low velocity oxygen stream. It is also used for gouging.

Tip Size	Stock Number
8	813-1928
10	813-1930
12	813-1932



Style 287 - 2 Piece

Heavy preheat with low velocity oxygen stream. For grooving, gouging and removing imperfect welds. The tip is angled at 15°.

Tip Size	Stock Number
6	813-1876
8	813-1878
10	813-1880
12	813-1882



Style 244 - 2 Piece

Tips are heavy preheat, 2 piece tips without a center oxygen hole. Especially used as heating tips in standard cutting torches.

Stock Number	BTU's	Use For	PSIG Fuel	PSIG Oxygen
813-2441	50000	MAPP/Propylene	8	50
813-2443	50000	Natural Gas/Propane	8	50

MAPP/Propylene Tips



Style A-Sp - 1 Piece

One piece, solid copper, standard speed and have a straight bore oxygen orifice. They are most commonly used for hand cutting operations.

Materials Thickness (Inches)	Stock Number	Drill Size
3/16	856-0072	72 (.025)
1/4	856-0068	68 (.031)
3/8	856-0065	65 (.035)
1/2	856-0060	60 (.040)
3/4	856-0056	56 (.046)
1 1/4	856-0054	54 (.055)
2	856-0052	52 (.063)
3	856-0049	49 (.073)
4	856-0044	44 (.086)
8	856-0038	38 (.101)
10	856-0031	31 (.120)
12	856-0028	28 (.140)
14	856-0019	19 (.166)
15	856-0015	15 (.180)

CONCOA

1501 Harpers Road • Virginia Beach, VA 23454 USA

1.800.225.0473 • 757.422.8330 • Fax: 757.422.3125 • www.concoa.com

Cutting Tips



**Stinger® CONCOA/AIRCO Seat
MAPP/Propylene Tips**



Style 233 - 2 Piece

Style 233 tips are general purpose (straight bore) cutting tips for use with MAPP Gas and propylene. These tips feature thin rectangular spline (fine spline) design. This design provides uniform preheat flames with maximum heat transfer. These tips are superior performers for 822 4490 cutting attachment in combination with the 818 0475 torch.

Materials Thickness (Inches)	Tip Size	Stock Number	Drill Size
3/16	00	813-2329	72 (.025)
1/4-3/8	0	813-2330	68 (.031)
1/2	1	813-2331	62 (.038)
1	2	813-2332	56 (.046)
1 1/2	3	813-2333	54 (.055)
2 1/2	4	813-2334	52 (.063)



Style 245 - 2 Piece

General purpose (straight bore) cutting tips for use with MAPP Gas and propylene. These tips feature thin rectangular spline (fine spline) design. This design provides uniform preheat flames with maximum heat transfer. These tips are superior performers for both hand or machine cutting operations.

Materials Thickness (Inches)	Tip Size	Stock Number	Drill Size
3/16	00	813-2499	72 (.025)
1/4-3/8	0	813-2450	68 (.031)
1/2	1	813-2451	62 (.038)
1	2	813-2452	56 (.046)
1 1/2	3	813-2453	54 (.055)
2 1/2	4	813-2454	52 (.063)
3	5	813-2455	49 (.073)
6-8	6	813-2456	39 (.128)
10-12	7	813-2457	30 (.169)
14	8	813-2458	18 (.169)



Style 345 - 2 Piece

Identical to the Style 245 except that the cutting oxygen bore is diverged to allow use of higher cutting oxygen pressures for increased speed in machine cutting operations. For plate over 4" use 245.

Materials Thickness (Inches)	Tip Size	Stock Number	Drill Size
3/8	0	813-3450	68 (.031)
1/2-5/8	1	813-3451	62 (.038)
1	2	813-3452	56 (.046)
1 1/2	3	813-3453	54 (.055)
2 1/2	4	813-3454	52 (.063)
2 3/4	5	813-3455	49 (.073)



Style A-RW - 1 Piece

Tips are one piece, solid copper, high preheat. Used for rivet washing with a large oxygen stream with MAPP/Propylene.

Size	Stock Number
147	856-6401
191	856-6402

Cutting
Tips



Cutting Tips

CONCOA/AIRCO Seat MAPP/Propylene Tips



Style A-B45 - 1 Piece

Tips are one piece, solid copper, standard speed. They are milled flat on both sides, have four (4) preheat holes and are angled 45°. Especially useful for cutting close to bulkheads and cutting rivet heads.

Size	Stock Number
56	856-5256



Style A-G1 - 1 Piece

Tips are one piece, solid copper. They have a complete circle of preheat holes and are angled 30°. Used for deep gouging and de-seaming.

Size	Stock Number
8	856-7207
10	856-7208



Style A-GW30 - 1 Piece

Tips are one piece, solid copper, angled 30°. Used for gouge-washing operations with MAPP/Propylene, especially for removal of defective weld sections.

Size	Stock Number
147	856-7902
191	856-7903



Preheat Beveling Adapter Stinger® Style

When a cutting torch is used for bevel cutting, the glancing angle at which the preheat flames strike the work causes a considerable loss of heat input efficiency. To offset this loss of heat, a Preheat Beveling Adapter is recommended. **Adapters are only for propane or natural gas. Not for use with acetylene or MAPP.** The Adapter is not supplied with a cutting tip insert. Tip inserts for the proper bevel widths must be ordered as required.

CONCOA Stinger® Style Bevel Adapter - Stock No. 813-4404

Style 275 Propane and Natural Gas Straight Bore Tips

Bevel Cut Thickness (Inches)	Tip No.	Insert Stock Number
3/16	00	813-2759
1/4-3/8	0	813-2760
1/2	1	813-2761
1	2	813-2762
1 1/2	3	813-2763
2 1/2	4	813-2764

Style 375 Propane and Natural Gas Straight Bore Tips

Bevel Cut Thickness (Inches)	Tip No.	Insert Stock Number
3/8	0	813-3760
1/2-5/8	1	813-3761
1	2	813-3762
1 1/2	3	813-3763
2 1/2	4	813-3764