

Centralised gas dispenser systems

Installations for supplying gas to a network of welding and cutting workstations.



2148-001

Centralised gas dispenser systems



Centralised gas dispenser systems are justified as soon as the question of supplying gas to multiple oxyacetylene (oxyacetylene, TIG or MIG/MAG) welding or cutting stations arises.

These distribution networks have many advantages:

Safety:

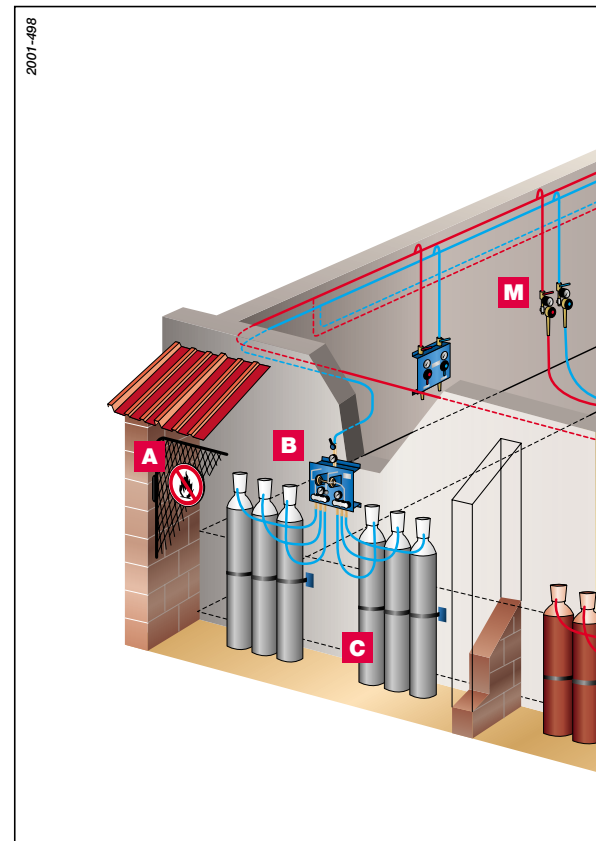
- Cylinders are stored outside the workshop
- Working and traffic areas are clear
- Safety devices at various points in the circuit eliminate any danger of an accident
- Possibility of feeding high power torches

Productivity:

- Continuous supply at a constant regulated pressure eliminates interruptions to workstation productivity (semi-automatic units)

Economy:

- Reduced cylinder storage
- Cylinder grouping considerably reduces handling costs



How is a central gas regulator unit defined?

■ Choose the welding process.

- It defines the gasses to be used.

■ List:

- The number of workstations.
- The type of equipment used (welding and heating torches, etc)
- The actual welding time per appliance

■ Determining the instantaneous outlet

- For this operation refer to the calculation sheet on pages 4 & 5.

The instantaneous volume will enable you to determine the capacity needed for your dispenser system

- Normal glow unit
- High flow unit

It depends on your work.

■ Define the autonomy of the regulator unit

- This stage enables you to determine the number of cylinders or frames to be used.

- Cylinder unit
- Frame unit

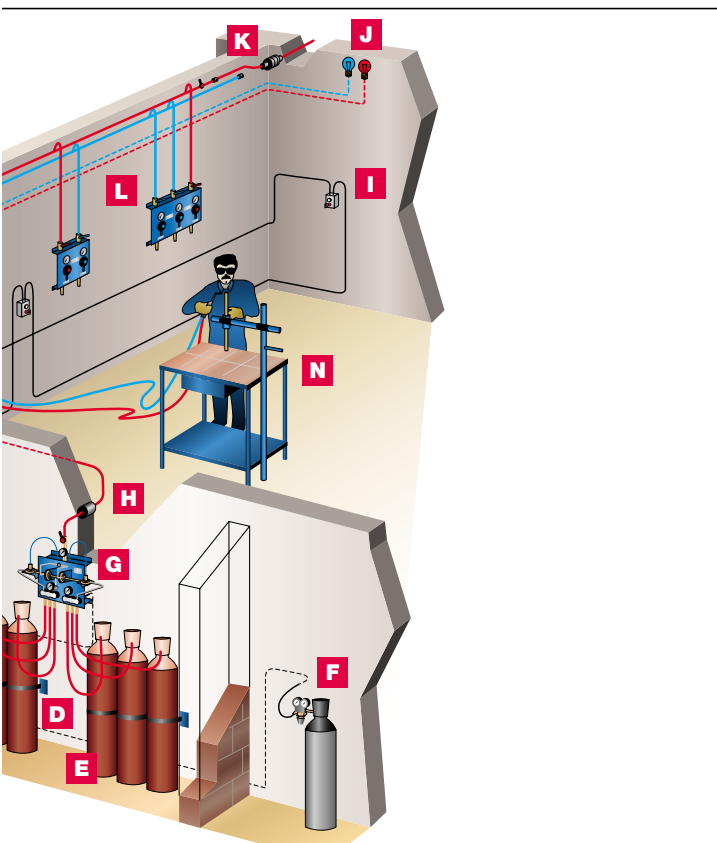
■ Determine the productivity of your dispenser unit

- Productivity is directly linked to the way you manage down-time caused by cuts in the gas supply when the cylinders or frames are empty.

- Cuts in the gas supply do not cause any major operational problems in your workshop => **Simplified regulator units***
- Gas cuts must be avoided as far as possible => **Semi-automatic regulator units****

* with reversal system

** with a semi-automatic reversal board



Standard layout of a centralised gas dispenser system:

- A - Mandatory notices**
- B - 1st stage regulator**
- C - Gas 1 storage (oxygen or inert gasses)**
- D - Rack**
- E - Gas 2 storage (combustible gasses)**
- F - Nitrogen supply for the pneumatic safety device**
- G - Pneumatic safety device**
- H - Flow limiter**
- I - Emergency nitrogen cut-off palm button**
- J - Reversal signal**
- K - Bursting disc**
- L - 2nd stage regulator board**
- M - 2nd stage regulator unit**
- N - Workstation**

Definitions

DIAPHRAL bursting disc

Normally fitted at the end of the acetylene pipe and exhausting outside the premises. It comprises a failure disc which tears in the event of accidental overpressure or explosion.

Reversal signal

Fitted to a semi-automatic system.

This system uses a warning light to inform the user by that the current gas source is about to run out.

Flow limiter

Used with systems consisting of 2 x 6 or more cylinders or frames. It is used with a DIAPHRAL bursting disc to limit the flow to a minimum if the disc bursts.

Pneumatic safety device*** (Nitrogen safety device)***

Cuts off the combustible gas supply to the workshop in an emergency.

Operated by one or more palm buttons in the workshop.

Racks

Mandatory, to prevent cylinders falling.

Heater

Fitted at the inlet to each regulator in a system to prevent icing by inert gasses containing CO₂ or NO₂ when flow levels are high and/or outside temperatures low.

Calculating the instantaneous flow and autonomy



Recommendation: to avoid any risk of undersizing the regulator unit, always consider the maximum flow capacity of each torch / TIG or MIG set.

■ Calculation sheet

| Type of equipment | Max. flow (1) | | | | | Max flow chosen (2) | Number of workstations (3) | Instantaneous flow Type of equipment (4) = (2) x (3) | Actual welding hours/day (5) | Daily flow Type of equipment (6) = 4 x 5 | Number of days autonomy required | Autonomy of regulator unit (AJ)=(DJ)x(NJ) |
|----------------------------------|-------------------|-----------------|------------------------|-------------------------|-------------------|---------------------|----------------------------|--|------------------------------|--|----------------------------------|---|
| | Acetylene in m³/h | Propane in m³/h | Oxygen OX - AD in m³/h | Oxygen OX - PRO in m³/h | Inert gas en m³/h | | | | | | | |
| Welding torches | | | | | | | | | | | | |
| VARIAL 00 | 0.1 | 0.04 | 0.11 | 0.16 | / | | | | | | | |
| VARIAL 400 C/400 | 0.4 | 0.2 | 0.44 | 0.65 | / | | | | | | | |
| SPEEDFIRE S | 0.4 | 0.2 | 0.44 | 0.65 | / | | | | | | | |
| Heating / forming torches | | | | | | | | | | | | |
| PYROSAF 1000 | 1 | 0.7 | 1.1 | 2.43 | / | | | | | | | |
| VARIAL G2 | 4 | 1.1 | 4.4 | 3.82 | / | | | | | | | |
| FIXAL G2 | / | 5 | / | 17.51 | / | | | | | | | |
| FIXAL G3 R | / | 10 | / | 32.5 | / | | | | | | | |
| VARIAL H3 | 8 | / | 8.8 | / | / | | | | | | | |
| SPEEDFIRE H | / | 6.2 | / | 21.67 | / | | | | | | | |
| Cutting torches | | | | | | | | | | | | |
| PYROCOPT 0 | 0.7 | 0.8 | 14 | 14 | / | | | | | | | |
| PYROCOPT G1 | 1 | 1.2 | 20.1 | 25 | / | | | | | | | |
| SPEEDFIRE C | 1 | 1.2 | 20.1 | 25 | / | | | | | | | |
| ALCOPT G1 | 1 | 1.2 | 20.1 | 25 | / | | | | | | | |
| PYROMAX | 1 | 1.2 | 20.1 | 25 | / | | | | | | | |
| PYROCOPT G2 | / | 1.5 | 22.5 | 29 | / | | | | | | | |
| Power sources | | | | | | | | | | | | |
| TIG set 16 l/min | / | / | / | / | 1.02 | | | | | | | |
| MIG set 32 l/min | / | / | / | / | 1.92 | | | | | | | |

(2) Depending on the gas and the device used, choose the maximum flow in column (1) and transpose it into column (2).
Warning: the maximum oxygen flow volume differs according to the combustible gas used (propane or acetylene).

(3) Note the number of workstations fitted with the equipment selected.

(5) Determine the actual number of welding hours per day and per type of equipment.

(6) The daily flow volume is the sum of the daily flow volumes for each type of equipment.

DI This is the instantaneous flow needed from the centralised gas dispenser system for the chosen gas.

NJ This is the number of days autonomy you need.
That is the number of days before replacing the cylinders or frames.

AI This is the Centralised gas dispenser system autonomy you need for the chosen gas.

| DI | DJ | NJ | AI |
|----|----|----|----|
|----|----|----|----|

| Sum of lines (4) | Sum of lines (6) | Sum of lines (6) |
|------------------|------------------|---|
| Cylinders | Capacity | Comments |
| AD B50 | 6 m³ | Do not exceed 1000l outlet per cylinder |
| OX B50 | 10.6 m³ | - |
| Propane | 35 kg | i.e. 18 m³ |
| Gaz neutre | 11.6 m³ | - |
| Frames | Capacity | |
| OX and inert gas | 6 B50 cylinders | |
| AD B50 | 8 B50 cylinders | |

Choice criteria

■ 1st stage regulator unit

| Gas | Acetylene | | | | Propane | | Oxygen | | | Inert gas | | | Characteristics and use |
|-------------------------------|-----------|-----------|-------------|--------------|---------|-------------|--------|-------------|----------------|-----------|-------------|----------------|--|
| Max. pressure in bars | 1.4 | | | | 4 | | 9 | | | 9 | | | |
| Max flow in m ³ /h | d ≤ 3 | 3 ≤ d ≤ 6 | 6 ≤ d ≤ 9 * | 9 ≤ d ≤ 15 * | d ≤ 12 | 12 ≤ d ≤ 16 | d ≤ 30 | 30 ≤ d ≤ 38 | 38 ≤ d ≤ 100 * | d ≤ 30 | 30 ≤ d ≤ 38 | 38 ≤ d ≤ 100 * | |
| Simplified units | | | | | | | | | | | | | |
| Cylinders | • | | | | • | | • | | | • | | | Workstation interruptions accepted. Number of cylinders limited. |
| Frames | • | • | • | | | | • | | • | • | | • | |
| Semi-automatic units | | | | | | | | | | | | | |
| Cylinders | • | • | | | • | • | • | • | • | • | • | • | Workstation interruption not acceptable. Replacement of empty cylinders in masked time. |
| Frames | • | • | • | • | | | • | • | • | • | • | • | |
| Extras | | | | | | | | | | | | | |
| Reversal warning | | • | | | | | • | | | • | | | Shows that the current cylinder is practically empty. |
| Heaters | | | | | | | | | | • | | | Prevents freezing of gas containing CO ₂ or NO ₂ |
| Clamps | | • | | | • | | • | | | • | | | Required under the NF A 84 440 standard. Prevent cylinders falling. |
| Bursting discs | | • | | | | | | | | | | | Prevents overpressure by means of its bursting disc. |
| Flow limiters | | • | | | | | | | | | | | In series with the bursting disc. It reduces the gas loss in the event of the disc bursting. |
| Pneumatic safety device | | • | | | • | | | | | | | | Cuts off combustion gas supply in the event on an emergency stop. |
| Mandatory notices | | • | | | • | | • | | | • | | | Required under the NF A 84 440 standard in premises in which cylinders or frames are stored, and on supply lines to workshops. |

* High flow.

■ 2nd stage regulator board

Services associated with 1st and 2nd stage regulator units:

- Audit of your existing equipment.
- “Turnkey” installations.
- Maintenance contracts.
- Training in the dangers inherent to the use of gas.
- For further information, please contact us.

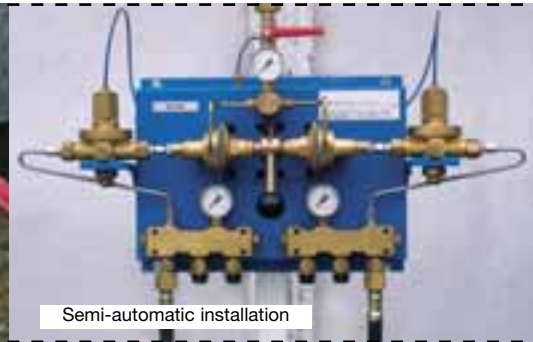
First stage pressure regulation equipment



Simplified installations with cylinders



GD regulator unit



Semi-automatic installation

Acetylene

Simplified installations

• Cylinders

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|---------------|
| 1 x 1 cylinder | 1 | 6 | W 000 257 946 |
| 1 x 2 cylinders | 2 | 12 | W 000 257 947 |
| 1 x 3 cylinders | 3 | 18 | W 000 257 948 |

Possibility of up to 6 cylinders

Please contact us

• Frames

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|----------------|-----------------------------------|-------------------------------|--------------------------------|
| 1 x 1 frame | 6 | 48 | W 000 257 959 |
| 1 x 2 frames | 6 | 96 | Please contact us |
| 1 x 1 frame GD | 15 | 48 | W 000 257 962 Wall mounting |

Composition:

- 1 GD/AC regulator
- 2 AD frame connection
- 3 LP hose
- 4 ARPF

W 000 100 714
0993-0710
W 000 261 273
0141-8159

Acetylene options

• Reversal warning (24V supply needed)

| Description | Part numbers |
|--|-------------------|
| OX - AD reversal warning * Triggering threshold 1 bar | 0141-9067 |
| 24V distribution board** Comprising 1 cabinet + 1 transformer | Please contact us |
| Audible alarm | Please contact us |

* Combines oxygen warning + acetylene warning

** A single board feeds the acetylene + oxygen warning devices

4 Flow limiters (+ ARPF)

| Description | Part numbers |
|-----------------------------------|--------------|
| 10 m ³ /h flow limiter | 0534-0145 |

5 Bursting disc

| Description | Comments | Part numbers |
|----------------------------|-------------------------------|--------------|
| DIAPHRAL | New installations | 0534-0122 |
| DIAPHRAL with interface | Can be fitted to the old disc | 0534-0124 |
| Bursting disc for DIAPHRAL | - | 0534-0123 |

Semi-automatic installations

• Cylinders

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|---------------|
| 2 x 1 cylinder | 1 | 12 | W 000 257 970 |
| 2 x 2 cylinders | 2 | 24 | W 000 257 971 |
| 2 x 3 cylinders | 3 | 36 | W 000 257 972 |
| 2 x 4 cylinders | 4 | 48 | W 000 257 973 |
| 2 x 5 cylinders | 5 | 60 | W 000 257 974 |
| 2 x 6 cylinders | 6 | 72 | W 000 257 975 |

• Frames

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|-------------------|
| 2 x 1 frame | 9 | 96 | W 000 257 989 |
| 2 x 2 frames | 9 | 192 | W 000 257 990 |
| 2 x 1 GD frame | 15 | 96 | Please contact us |
| 2 x 2 GD frames | 15 | 192 | Please contact us |

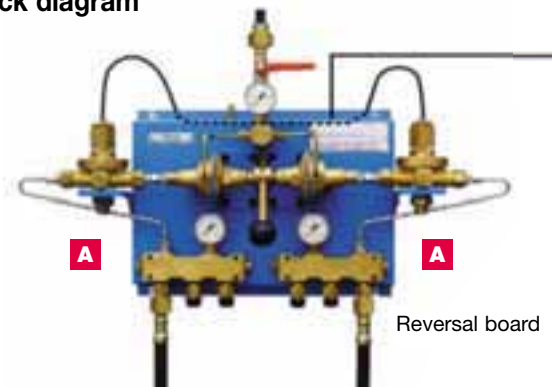
Spare parts for acetylene

2 Frame connector

| Inlet | Outlet | Part number |
|----------------|---------------|-------------|
| Female 33 x 2G | Female H type | 0993-0710 |

Connector for adapting a cylinder regulator onto an acetylene frame.

Block diagram



Reversal board

- A** Isolation valves
- B** Nitrogen supply to circuit keeping the isolation valves open.
- C** "Palm button" bleed system

DI : Instantaneous flow

AI : Regulator unit autonomy



■ Hydrogen

Simplified installations

• Cylinders

| Description | DI Max. flow in m³/k | AI Autonomy in m³ | Part numbers |
|-----------------|----------------------|-------------------|---------------|
| 1 x 1 cylinder | 100 | 9 | W 000 257 955 |
| 1 x 2 cylinders | 100 | 18 | W 000 257 956 |
| 1 x 3 cylinders | 100 | 27 | W 000 257 957 |

Semi-automatic installations

• Cylinders

| Description | DI Max. flow in m³/k | AI Autonomy in m³ | Part numbers |
|----------------|----------------------|-------------------|---------------|
| 2 x 1 cylinder | 100 | 18 | W 000 257 985 |

Spare parts (for combustible gasses)

6 High pressure hoses

| Description | Length | Inlet | Outlet | Part numbers |
|-------------------|--------|---------------------|-----------------|---------------|
| AD H cyl. | 1.5 m | Male H type | Female 20 x 1.5 | W 000 242 337 |
| AD frame | 2.5 m | Female 32 x 2G | Female 20 x 1.5 | W 000 242 475 |
| Pro cyl. | 1.5 m | Industrial LPG type | 20 x 1.5 | W 000 242 471 |
| Hydrogen cylinder | 1.5 m | E type | Female 20 x 1.5 | W 000 242 473 |

7 Extension pipe set

| Description | Part numbers |
|---|---------------|
| Extension pipe set Acetylene Female 20 x 1.5 | W 000 260 519 |
| Extension pipe set Hydrogen/Propane Female 20 x 1.5 | W 000 260 518 |

■ Propane (LPG)

Simplified installations

• Cylinders

| Description | DI Max. flow in m³/k | AI Autonomy in m³ | Part numbers |
|-----------------|----------------------|-------------------|---------------|
| 1 x 1 cylinder | 12 | 18 | W 000 257 952 |
| 1 x 2 cylinders | 12 | 36 | W 000 257 953 |
| 1 x 3 cylinders | 12 | 54 | W 000 257 954 |

Possibility of up to 6 cylinders

Please contact us

Semi-automatic installations

• Cylinders

| Description | DI Max. flow in m³/h | AI Autonomy in m³ | Références |
|-----------------|----------------------|-------------------|---------------|
| 2 x 1 cylinder | 16 | 36 | W 000 257 982 |
| 2 x 2 cylinders | 16 | 72 | W 000 257 983 |
| 2 x 3 cylinders | 16 | 108 | W 000 257 984 |

Possibility of up to 2 x 6 cylinders

Please contact us

Options

• Mandatory notices

| Description | Part numbers |
|---|---------------|
| Set of boards for acetylene room | W 000 260 560 |
| Set of boards for propane room | W 000 260 559 |
| Set of marking labels for acetylene pipes | W 000 260 512 |
| Set of marking labels for acetylene pipes | W 000 260 561 |

• Pneumatic safety device

| Description | Part numbers |
|--|-------------------|
| Pneumatic safety device for acetylene*** | W 000 235 209 |
| Pneumatic safety device for propane*** | Please contact us |
| Nitrogen cylinder - 1 m³ | |
| C Extra palm button | 0140-0227 |
| Flexible hose, Ø 4 | 0101-7107 |
| Flexible hose connection kit | 0101-7108 |

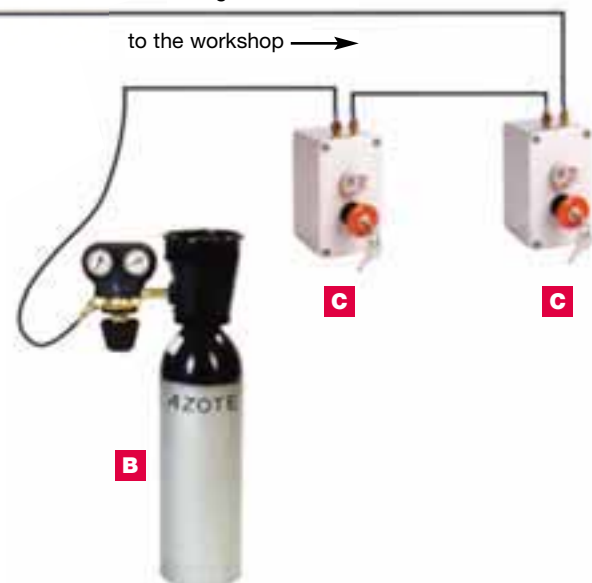
*** nitrogen cylinder to be ordered separately.

• Racks

| Description | Part numbers |
|-----------------|--------------|
| 2 cylinder rack | 0140-1800 |
| 3 cylinder rack | 0140-1801 |

Pneumatic safety device (Nitrogen safety device)

Nitrogen circuit



First stage regulation equipment



Oxygen

Simplified installations

Cylinders

| Description | DI Max. flow in m ³ /k | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|---------------|
| 1 x 1 cylinder | 30 | 10 | W 000 257 943 |
| 1 x 2 cylinders | 30 | 20 | W 000 257 944 |
| 1 x 3 cylinders | 30 | 30 | W 000 257 945 |

Frames

| Description | DI Max. flow in m ³ /k | AI Autonomy in m ³ | Part numbers |
|----------------|-----------------------------------|-------------------------------|-------------------|
| 1 x 1 frame | 30 | 90 | W 000 257 958 |
| 1 x 2 frames | 30 | 180 | Please contact us |
| 1 x 1 GD frame | 100 | 90 | W 000 257 961 |
| 1 x 1 GD frame | 100 | 90 | Wall mounted |

Composition:

- GD/GX regulator W 000 100 660
- Frame connection 0725-0008
- LP hoses W 000 261 274

Semi-automatic installations

1 Cylinders

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part number |
|-----------------|-----------------------------------|-------------------------------|---------------|
| 2 x 1 cylinder | 38 | 20 | W 000 257 964 |
| 2 x 2 cylinders | 38 | 40 | W 000 257 965 |
| 2 x 3 cylinders | 38 | 60 | W 000 257 966 |
| 2 x 4 cylinders | 38 | 80 | W 000 257 967 |
| 2 x 5 cylinders | 38 | 100 | W 000 257 968 |
| 2 x 6 cylinders | 38 | 120 | W 000 257 969 |

2 Frames

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|-------------------|
| 2 x 1 frame | 38 | 180 | W 000 257 987 |
| 2 x 2 frames | 38 | 360 | W 000 257 988 |
| 2 x 1 GD frame | 100 | 180 | Please contact us |
| 2 x 2 GD frames | 100 | 360 | Please contact us |

Oxygen and inert gas options

1 Reversal warning (24v supply needed)

| Description | Comments | Part numbers |
|----------------------------|--|-------------------|
| OC - AD reversal warning* | 24V supply - triggering threshold 7 bars | 0141-9067 |
| Inert gas reversal warning | 24V supply - triggering threshold 7 bars | 0141-9130 |
| 24V supply board** | Comprises 1 box + 1 transformer | Please contact us |
| Audible alarm | - | Please contact us |

* Combines oxygen warning + acetylene warning
 ** A single board feeds the acetylene + oxygen warning devices.

3 Racks

| Description | Part numbers |
|-----------------|--------------|
| 2 cylinder rack | 0140-1800 |
| 3 cylinder rack | 0140-1801 |

Mandatory notices

| Description | Part numbers |
|--|---------------|
| Set of boards for oxygen room | W 000 260 558 |
| Set of marking labels for oxygen pipes | W 000 260 511 |
| Set of marking labels for nitrogen pipes | W 000 260 514 |
| Lot d'étiquettes pour repérage des canalisations Argon | W 000 260 513 |

Spare parts - oxygen and inert gasses

High pressure hoses

| Description | Length | Inlet | Female outlet | Part numbers |
|-------------|--------|---------------|---------------|---------------|
| OX cylinder | 1.5 m | Male F type | 20 x 1.5 | 0142-0100 |
| OX frame | 2.5 m | Female 32 x 2 | 20 x 1.5 | W 000 242 474 |
| GN cylinder | 1.5 m | Female C type | 20 x 1.5 | 0142-0102 |
| GN frame | 2.5 m | Female 38 x 2 | 20 x 1.5 | W 000 242 476 |

Extension pipe set

| Description | Part numbers |
|--|---------------|
| Extension pipe set Oxygen Inert gas Hydrogen LPG | W 000 260 518 |

Frame connections

| Inlet | Outlet | Part numbers |
|---------------|-------------------------|--------------|
| Female 35 x 2 | Female F type (oxygen) | 0725-0008 |
| Female 38 x 2 | Male C type (inert gas) | 0766-0001 |

Connector for adapting a cylinder regulator onto an oxygen or inert gas frame.



5



■ Inert gasses (argon, nitrogen, CO₂ and mixtures)

Simplified installations

• Cylinders

| Description | DI Max. flow in m ³ /k | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|---------------|
| 1 x 1 cylinder | 30 | 12 | W 000 257 949 |
| 1 x 2 cylinders | 30 | 24 | W 000 257 950 |
| 1 x 3 cylinders | 30 | 36 | W 000 257 951 |

• Frames

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|---------------------------------------|-----------------------------------|-------------------------------|---------------|
| 1 x 1 frame | 30 | 90 | W 000 257 960 |
| 1 x 1 GD frame | 100 | 90 | W 000 257 963 |
| 1 x 1 GD frame <i>composition:</i> | 100 | 90 | Wall mounting |
| • 1 GD/inert gas regulator | | W 000 100 788 | |
| • 2 frame connection | | | 0766-0001 |
| • 3 LP hose | | | W 000 261 274 |

Semi-automatic installations

1 Cylinders

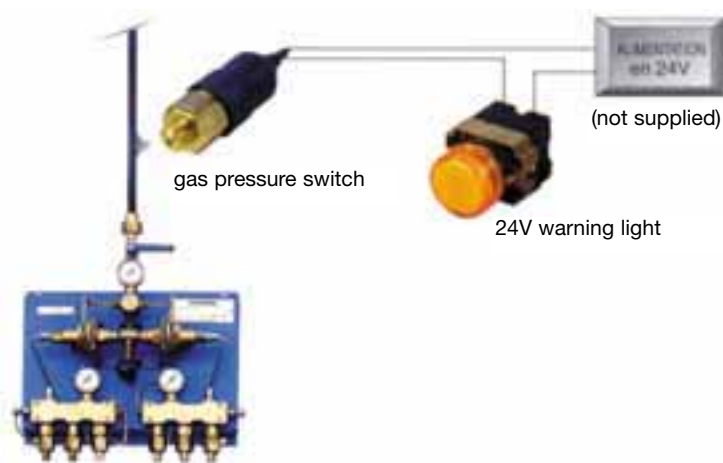
| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|-----------------|-----------------------------------|-------------------------------|---------------|
| 2 x 1 cylinder | 38 | 24 | W 000 257 976 |
| 2 x 2 cylinders | 38 | 48 | W 000 257 977 |
| 2 x 3 cylinders | 38 | 72 | W 000 257 978 |
| 2 x 4 cylinders | 38 | 96 | W 000 257 979 |
| 2 x 5 cylinders | 38 | 120 | W 000 257 980 |
| 2 x 6 cylinders | 38 | 144 | W 000 257 981 |

2 Frames

| Description | DI Max. flow in m ³ /h | AI Autonomy in m ³ | Part numbers |
|--------------|-----------------------------------|-------------------------------|---------------|
| 2 x 1 frame | 38 | 216 | W 000 257 991 |
| 2 x 2 frames | 38 | 432 | W 000 257 992 |

Installations for Helium gas; please contact us.

4 Reversal signal block diagram



5 Heaters

| Description | Max. flow | Power | Inlet | Outlet | Part number |
|--------------------|----------------------|-------|---------------|-----------|---------------|
| Cylinder heater | 3 m ³ /h | 100 W | Female C type | Male type | 0604-0537 |
| 500 W heater unit* | 10 m ³ /h | 500 W | - | - | W 000 261 270 |
| | | | - | - | W 000 261 269 |

* The two part numbers make up a complete unit

Second stage regulation equipment

This equipment enables every workstation to be fed with gas according to the welding tool used. The range can be broken down into 2 families:

- The Normal Flow (DN) family for supplying gas to all welding tools in our range except for VARIAL G2, SPEEDFIRE H and PYROCOPT G2,
- The High Flow (GD) family for supplying gas to VARIAL G2, VARIAL H3, FIXAL G2, FIXAL G3R, SPEEDFIRE H, PYROCOPT G2 and to your special applications.

■ Normal flow

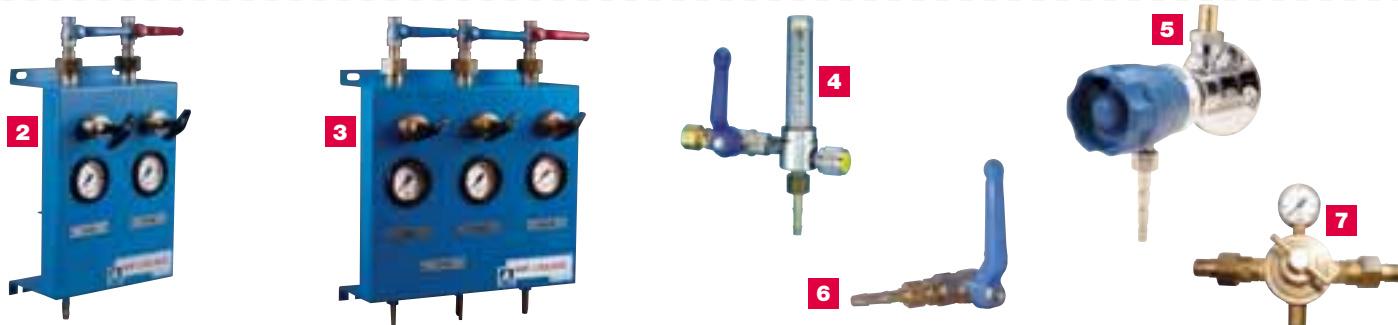


1 Table - 1, 2, 3, 4 or more workstations

| Description | Max. inlet pressure | Max. outlet pressure | Max. flow | Inlet connection | Outlet connection | Suitable pipe Ø | Part numbers |
|--------------------------------------|---------------------|----------------------|-------------|------------------|-------------------|-----------------|---------------|
| Oxygen | 15 | 10 | 35 | Female 3/8 G | 16 x 150 D | 6.3 / 10 | W 000 260 623 |
| Acetylene | 1.2 | 1 | 3.5 | Female 3/8 G | 16 x 150 G | 6.3 / 10 | W 000 260 624 |
| Combustible gasses LPG | 5 | 4 | 11 | Female 3/8 G | 16 x 150 G | 6.3 / 10 | W 000 260 625 |
| Inert gasses | 15 | 10 | 35 | Female 3/8 G | 16 x 150 D | 6.3 / 10 | W 000 260 626 |
| Ar/CO ₂ column flow meter | 15 | - | 0/28 l/min. | Female 3/8 G | 12 x 100 D | 6.3 | W 000 260 628 |
| Oxygen | 15 | - | 0/25 l/min. | Female 3/8 G | 12 x 100 D | 6.3 | W 000 260 627 |

Accessories - Spare parts

| Description | Connections | Part numbers |
|--|---|---------------|
| 3/8 tap Oxygen Inert gasses | Female 3/8 G | |
| 3/8 tap Acetylene Combustible gasses | Female 3/8 G | |
| SECURTOP Flame-check Oxygen | Inlet - Female 16 x 150 D Outlet - Male 16 x 150 D | W 000 236 165 |
| SECURTOP Flame-check Combustible gas | Inlet - Female 16 x 150 G Outlet - Male 16 x 150 G | W 000 236 164 |



■ High Flow

• Characteristics of the range

| Pressure in bars | Oxygen | Acetylene | Propane | Natural gas | Tetrene |
|--------------------------------|---------------------------------|-----------|---------|-------------|---------|
| Inlet pressure | 7 | 1.4 | 6 | 1.4 | 6 |
| Outlet pressure | 6 | 0.7 | 4 | 0.7 | 4 |
| Max. flow in m ³ /h | with ARPF 24 - without ARPF 120 | 5* | 12 | 5 | 12 |

Inlet - female 3/8 G by a _ turn tap
 Outlet - ferrule for Ø10 pipe by check valve on Oxygen and Combustible gasses
 Outlet - ferrule for Ø6 pipe on flow meter.

* VARIAL H3: Please contact us

2 Table - 2 workstations

| Description | Part numbers |
|--------------------|-------------------|
| Acetylene + Oxygen | 0691-0001 |
| Propane + Oxygen | Please contact us |

Combustible gas + OX or supply to 2 workstations (TIG or MIG)

3 Table - 3 stations

| Description | Part numbers |
|-----------------------------|--------------|
| Oxygen + Acetylene + Oxygen | 0691-0002 |

4 Column flow meter

| Description | Part numbers |
|-----------------------|--------------|
| Flow meter - 16 l/min | 0111-3101 |
| Flow meter - 32 l/min | 0111-3102 |

Inlet via an olive connection for a Ø10 rigid pipe followed by a _ G _ turn tap.
 Outlet by a ferrule for Ø6 pipe

5 QUICKFLOW - vane flow meter

| Max. flow l/min | Pressure bars | Application | Part numbers |
|---|---------------|-------------|--------------|
| 15 | 3 | TIG | 0961-1015 |
| 30 | 3 | MIG | 0961-1025 |
| Vane bracket for welding to 8 x 10 tube | | | 0998-0001 |

6 Calibrated tap

| Description | Part numbers |
|--------------------------|---------------|
| Calibrated tap 10 l/min. | W 000 261 399 |
| Calibrated tap 15 l/min. | W 000 261 400 |
| Calibrated tap 20 l/min. | W 000 261 401 |

Inlet - female _ G via a _ turn tap.
 Outlet - ferrule for Ø6 pipe

7 Accessory

| Description | Part numbers |
|---------------------------------|--------------|
| NM86 regulator preset to 3 bars | 0141-1754 |

For DYNAVAL column flow meter and calibrated tap
 Installed on the pipe after the 1st stage regulator board, upstream from the workstation.
 Inlet and outlet - by _ G male union



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