EXTREME BEVEL CUTTING

Extreme 18” bevel cutting using Gas Innovations PROPYLENE

WORKING with the BEST

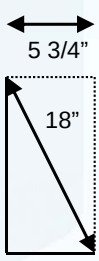
Gas Innovations achieves exceptional results bevel cutting with propylene and their new torch and tips.

Company: Fabrication Company.
Gas of choice “ Propylene”
Why Propylene: Excellent Cost Reduction
Cut Quality: Excellent!, Faster, Safer.
80% production improvement.
$352,000 cost savings.
Customer said “ if they had not had the Gas Innovations team demo their torch with Propylene to cut this 18” bevel they would had to manually remove metal by some type of thermal process or do it on a milling machine. The cost for that labor would have been $10,000 for one unit. With this torch and Propylene, the labor cost was $2,000 for each unit X 44 units
= $ 352,000 in savings”.

MAKING THE IMPOSSIBLE POSSIBLE WITH PROPYLENE

PROPYLENE the Innovative Fuel Keeping our Fabrication Customers Competitive with Substantial reduction in Cost.

98” Dia. VESSEL
176 ¼” Long
5 ¾” Thick 516 grade steel
75 ^{O} BEVEL



ASME Code:
Requirements:
Section VIII Division 1.

GAS INNOVATIONS

Learn how we can help reduce your fabrication costs with Propylene and our Innovative Tips and Torches.

18005 E. Hwy 225 La Porte, Texas 77571 Tel: 281-471-2200

www.gasinnovations.com

GAS INNOVATIONS

PROPYLENE CUTTING

EXTREME BEVELING:

CUT A 75 DEGREE BEVEL ON A 5 ¾" PRESSURE VESSSEL

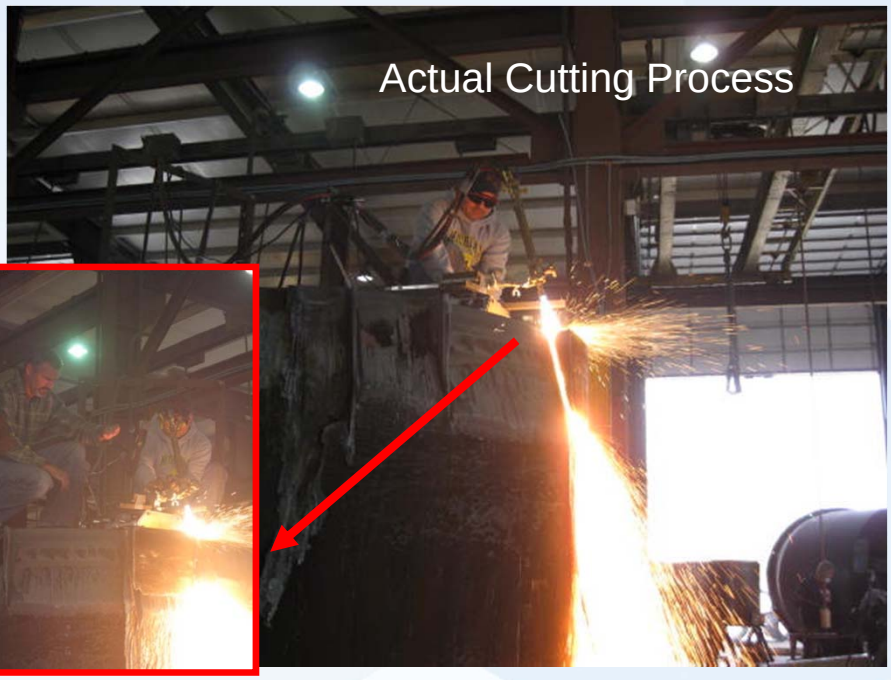
Temporary set-up for test

Operator monitoring cut

18" , 75 degree bevel

Before using Oxweld torch and two heating heads. could only cut 8" with Propane. With the Gas Innovations torch set at 30 PSI Propylene, 25 Preheat Oxygen and 150 PSI cutting Oxygen. This equals approximately 110 lbs fuel gas/hr and 5,000 cuft of Oxygen / hour.

Full 18" bevel with Propylene On 516 steel ASME code Requirements Section VIII Division 1 no grinding or finishing required, ready to weld.



Actual Cutting Process

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PROPYLENE CUTTING

32” straight cut on 516 grade steel using Propylene

Hand Torch test set-up for 32” cut. Could only cut 22” because of 90 degree head looses cutting oxygen velocity.

Hand torch will be used for emergency cuts or difficult flanges to cut.

Torch set up for 32” straight cut:
Propylene 35 PSI
Preheat Oxygen 28 psi
Cutting Oxygen 180 psi

Below Torch was set at a 10 degree angle to get a clean start. Stopped cut prior to completion show length of cut.

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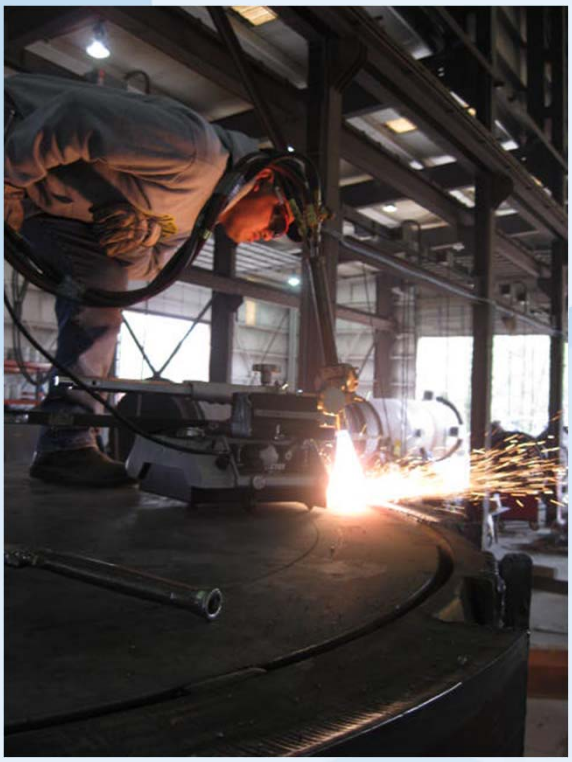
PROPYLENE CUTTING

Additional Extreme Bevel Pictures



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Additional Extreme Bevel Pictures

Standing Platform during cutting process

Insulating material to keep the reflected heat away from the standing platform

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