

Firepower[®]



Cutting

Heating

Welding

Gas Equipment Range Brochure

Firepower® Products

Victor Technologies™, a leader in metal cutting, gas control and specialty welding solutions, is meeting the needs of people who demand professional-quality results, through a refined portfolio of Firepower branded products. These products represent the leading edge in design, performance, quality and safety, backed by 100 years of proven innovation.

Performance, Value and Ease of Use

The latest Firepower OxyFuel range offers superior performance, excellent value and ease-of-use that helps the craftsman get the job done right the first time. The torch and regulator range is the heart of this new family, with system solutions and components designed for individual needs.

This product range will perform a wide spectrum of tasks, from brazing sheet metal to cutting up to six inch thick steel. Professionals from auto repair, construction, farm/ranch, skilled trades and serious do-it-yourselfers will find the superior solutions they need.

Firepower draws on the heritage and quality of Victor® gas equipment, and has the advantage of utilizing that excellence in product support, service, and application know-how.

CUTTING

ACETYLENE CUTTING TIPS



OxyFuel 350
SERIES 1
or
OxyFuel 250
SERIES 3

NATURAL GAS CUTTING TIPS



OxyFuel 350
SERIES 1
or
OxyFuel 250
SERIES 3

HEATING

#4 - 0323-0270

#6 - 0323-0271

WELDING

#0 - 0323-0360

#1 - 0323-0361

#3 - 0323-0363

#4 - 0323-0364

OxyFuel Regulators

OXYGEN



0781-9829

ACETYLENE



0781-9830

Full range of Cutting, Heating and Welding products for multiple gas types.

A flexible and versatile platform catered to applications from brazing thin sheet metal to cutting six inch thick steel we have the solution...

PROPYLENE CUTTING TIPS



OxyFuel 350 SERIES 1
or
OxyFuel 250 SERIES 3



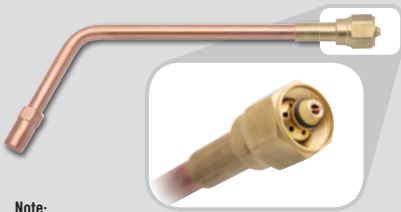
0381-0760



0381-0759



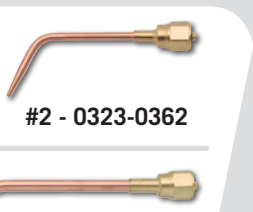
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#2 - 0323-0362

Note:

1. "W" Nozzles Fits 7/8" Thread OxyFuel 250-350 Handles
2. "W-1" 5/8" Thread OxyFuel 150 Nozzles Also Available



#5 - 0323-0365

Note:

1. "W" Nozzles Fits 7/8" Thread OxyFuel 250-350 Handles
2. "W-1" 5/8" Thread OxyFuel 150 Nozzles Also Available



0382-0358
OXYFUEL 250/350 HANDLE

0656-0008
FLASHBACK
ARRESTORS

OxyFuel Outfits

250 MEDIUM DUTY



0384-2571 BOX
0384-2572 CLAMSHELL

350 HEAVY DUTY



0384-2682 BOX
0384-2684 CLAMSHELL

OxyFuel 350 Heavy Duty Outfit

Specifications

Part No.	Description	Fuel Gas Type
0384-2682	OxyFuel 350 Heavy Duty Outfit (Box)	Acetylene
0384-2684	OxyFuel 350 Heavy Duty Outfit (Clamshell)	Acetylene



FEATURES

- High performance, complete system that meets or exceeds industry standards
- Superior 350 Series high flow color coded regulators
- Complete handle and cutting attachment optimized for multiple gases
- Up to 6" cutting capacity and 1/2" welding
- Flexible versatile platform
- Includes flashback arrestors

APPLICATIONS

The OxyFuel 350 Heavy Duty Outfit contains premium performance components for professional grade use.

Suitable for medium to heavy duty fusion welding, braze welding, brazing, heating and hand cutting applications.

CONTENTS

Oxygen/Acetylene 350 Series Regulators, 350 Series Cutting Attachment and Handle, Flashback Arrestors, Dual R-Grade Hose 12.5 ft., No. 2 Welding Nozzle, No. 2-1 Cutting Tip, Striker, Protective eyewear and Manual.

OxyFuel 250 Medium Duty Outfit

Specifications

Part No.	Description	Fuel Gas Type
0384-2571	OxyFuel 250 Medium Duty Outfit (Box)	Acetylene
0384-2572	OxyFuel 250 Medium Duty Outfit (Clamshell)	Acetylene



FEATURES

- High performance, complete system that meets or exceeds industry standards
- High performance 250 Series color coded regulators
- Complete handle and cutting attachment optimized for multiple gases
- Up to 5" cutting capacity and 1/2" welding
- Flexible versatile platform

APPLICATIONS

The OxyFuel 250 Medium Duty Outfit contains premium performance components for the value driven consumer.

Suitable for light to medium duty fusion welding, braze welding, brazing, heating and hand cutting applications.

CONTENTS

Oxygen/Acetylene 250 Series Regulators, 250 Series Cutting Attachment and Handle, Dual R-Grade Hose 12.5 ft., No. 0 Welding Nozzle, No. 0-3 Cutting Tip, Striker, Protective eyewear and Manual.

OxyFuel 250 Tote

Specifications

Part No.	Description	Fuel Gas Type
0384-0995	OxyFuel 250 outfit. Complete with carry tote and empty tanks	Acetylene
0384-0996	OxyFuel 250 outfit. Complete with carry tote, no tanks	Acetylene



FEATURES

- Complete portable system
- Cutting torch and handle are ready for multiple gas options; Oxy-Acetylene, Propane, Butane, Natural & LP Gases, & Propylene
- Simple to use regulator with high contrast gauges
- Meets or exceeds industry safety standards
- Cut 1/8" (3.2 mm) to 3" (76.2 mm) steel
- Heat using multiple heat nozzles
- Weld up to 1/4" (6.4 mm) Steel
- Constructed with high strength alloys, heavy duty stainless steel and durable brass

NOTE: TANKS ARE FOR EXCHANGE ONLY AND ARE EMPTY

APPLICATIONS

This OxyFuel 250 outfit complete with carry tote and empty tanks is the ideal entry level starter package.

Suitable for light duty fusion welding, braze welding, brazing, heating and hand cutting applications.

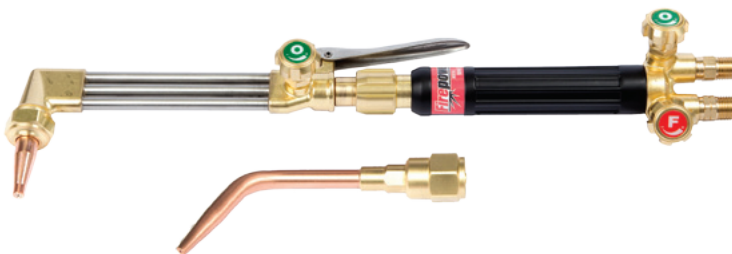
CONTENTS

Oxygen/Acetylene 150 Series Regulators, 250 Series Cutting Attachment and Handle, cylinder wrench with chain, Dual R-Grade Hose 12.5 ft., No. 0 Welding Nozzle, No. 0-3 Cutting Tip, Striker, Protective eyewear, Tote Carry Pak and Manual. (with or without tanks depending on part no.)

OxyFuel 250 Replacement Torch Kit

Specifications

Part No.	Description	Fuel Gas Type
0384-2573	OxyFuel 250 Torch Replacement Kit	All



FEATURES

- Cutting torch and handle are ready for multiple gas options; Oxy-Acetylene, Propane, Butane, Natural & LP Gases, & Propylene
- Ergonomic color coded knobs (Acetylene & Oxygen)
- Meets or exceeds industry safety standards
- Cut 1/8" (3.2 mm) to 5" (127 mm) steel
- Heat using multiple heat nozzles
- Weld up to 1/2" (12.7 mm) steel
- Constructed with high strength alloys, heavy duty stainless steel and durable brass

APPLICATIONS

This OxyFuel 250 replacement torch kit allows upgrades to the latest generation of torch and handle design and operating platform.

CONTENTS

250 Series Cutting Attachment and Handle, No. 0 Welding Nozzle, No. 0-3 Cutting Tip, and Manual.

OxyFuel Acetylene Regulator

Specifications

Part No.	Description	Fuel Gas Type
0781-9827	250 Acetylene Regulator	Acetylene
0781-9830	350 Acetylene Regulator	Acetylene



FEATURES

- High performance single stage regulator with precise pressure and flow control
- Large clear gauges enable both inlet and delivery pressures to be read at a glance
- Clear color coding for the correct gas usage
- Forged brass body and high strength alloy bonnet
- Meets or exceeds industry standards
- 9/16" -18 outlet connection (LH)
- Max flow rated - 2000 SCFH (350)
- Two year warranty

APPLICATIONS

The OxyFuel 250 and 350 Acetylene regulators are suitable for a wide range of cutting, heating and welding applications using Acetylene fuel gas only.

OxyFuel Oxygen Regulator

Specifications

Part No.	Description	Fuel Gas Type
0781-9826	250 Oxygen Regulator	Oxygen
0781-9829	350 Oxygen Regulator	Oxygen



FEATURES

- High performance single stage regulator with precise pressure and flow control
- Large clear gauges enable both inlet and delivery pressures to be read at a glance
- Clear color coding for the correct gas usage
- Forged brass body and high strength alloy bonnet
- Meets or exceeds industry standards
- 9/16" -18 outlet connection (RH)
- Max flow rated - 5000 SCFH (350)
- Two year warranty

APPLICATIONS

The OxyFuel 250 and 350 Oxygen regulators are suitable for a wide range of cutting, heating and welding applications using Oxygen gas only.

Argon/CO₂ Mixes Flowgauge Regulator

Specifications

Part No.	Description	Fuel Gas Type
0382-0358	Argon/CO ₂ Regulator	Argon/CO ₂



FEATURES

- High performance single stage regulator with precise pressure and flow control
- Large clear gauges enable both inlet and delivery pressures to be read at a glance
- Clear color coding for the correct gas usage
- Forged brass body and high strength alloy bonnet
- Meets or exceeds industry standards
- 9/16" -18 outlet connection (RH)
- Max flow rated - 4000 SCFH (250)
- Two year warranty

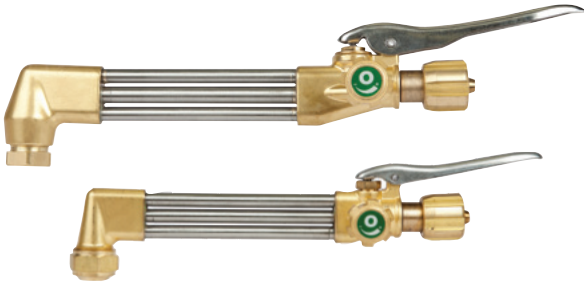
APPLICATIONS

The Argon/CO₂ Flowgauge Regulator is suitable for MIG and TIG welding applications using Argon and Argon/CO₂ gas mixtures.

OxyFuel Cutting Attachments

Specifications

Part No.	Description	Fuel Gas Type
0381-0759	250 OxyFuel Cutting Attachment	All
0381-0760	350 OxyFuel Cutting Attachment	All



FEATURES

- Meets or exceeds Industry Standards
- Attaches quickly and easily to OxyFuel handle (no tools required)
- Cutting oxygen lever securely fitted to the body for ease of operation
- High strength triple stainless steel tube construction with good cutting visibility
- Multi gas operation: Oxy/Acetylene, Propane, Butane, Natural/LP & Propylene
- Cutting capacity up to 6" (350)

APPLICATIONS

Suitable for the following processes: hand cutting.

OxyFuel Cutting/Welding Handle

Specifications

Part No.	Description	Fuel Gas Type
0382-0358	OxyFuel 250-350 Torch Handle	All



NOTE: For use with Fuel Gas other than Acetylene. Proper Tips, Regulators or T-Grade Hoses may be required.



FEATURES

- Meets or exceeds Industry Standards
- High strength durable brass and alloy handle
- High precision valves for sensitive control for delicate welding jobs
- Easy light up for high flow heating applications
- Multi gas operation: Oxy/Acetylene, Propane, Butane, Natural/LP & Propylene
- Left and right hand threads prevent incorrect hose connection
- Color coded control knobs are fitted for maximum safety and ease of use, even when wearing gloves

APPLICATIONS

The OxyFuel Cutting and Welding Handle connects to Oxyfuel Cutting attachments and a complete line of Heating and Welding nozzles. Suitable for the following processes: Fusion welding, braze welding, brazing, soldering, heating, hand cutting.

Inert Flowgauge Regulator

Specifications

Part No.	Description	Fuel Gas Type
0781-9829	250 Inert Flow Regulator	Inert



FEATURES

- High performance single stage regulator with precise pressure and flow control
- Large clear gauges enable both inlet and delivery pressures to be read at a glance
- Clear color coding for the correct gas usage
- Forged brass body and high strength alloy bonnet
- Meets or exceeds industry standards
- 9/16" -18 outlet connection (RH)
- Max flow rated - 4000 SCFH (250)
- Two year warranty

APPLICATIONS

The Inert Flowgauge Regulator is designed specifically for use with Nitrogen and Helium gases.

Additional OxyFuel Regulators

Specifications

Part No.	Description	Gas	CGA Range	Part No.	Description	Gas	CGA Range
0781-8960	150-60-540-FB	Oxygen	540 CGA, 4-60 PSIG	0781-2733	HRF 1480-580FPH clamshell, with hose	Argon/CO ₂	580 CGA, 10-38 (SCFH)
0781-8961	150-15-510-FB	Acetylene	510 CGA, 2-15 PSIG	0386-0849	NFM-TT Nitrogen Flow Meter	Nitrogen	¼" inlet, 0-75 (SCFH)
0781-8965	FPR-160AR-200 (Tote)	Acetylene	200 CGA, 2-15 PSIG				
0781-8966	FPR-150CR-540 (Tote)	Oxygen	540 CGA, 4-60 PSIG				
0781-9800	RF250-15-300	Acetylene	300 CGA, 2-15 PSIG				
0781-9802	RF350-15-300	Acetylene	300 CGA, 2-15 PSIG				



OxyFuel Powder Spray Torch Outfit

Specifications

Part No.	Description	Fuel Gas Type
0384-1266	FPSK-260 Complete Powder Spray Torch Kit	Acetylene
Build-Up Powders		
1440-0040	FPBP-22 1# Bottle: Used for shaft build-up cast iron repair, cracked exhaust manifolds.	
1440-0042	FPBP-40 1# Bottle: Used for bearing surfaces, gear teeth shaft build-up. Machinable.	
1440-0043	FPWP-60 1# Bottle: Used for cam lobes, sealing surfaces. Not machinable.	
1440-0044	FPWP-100 1# Bottle: Used for plow shears, augers, harvesters knives.	
1440-0041	FPWP-600 1# Bottle: Used for construction equipment	

APPLICATIONS

Build-up Applications: Machinable

Great for farm implement and cast iron build-up. A variety of metal powders are offered for various applications.

Build-up Powder Options:

- FPBP-22 (22 Rockwell) - Shaft build-up; cast iron repair, cracked exhaust manifolds, easily machined.
- FPBP-40 - Bearing surfaces, gear teeth, shaft build-up, machinable.

Wear Applications: Non-Machinable

Special hardfacing powder is fused onto part surface with an oxy-acetylene torch for extended part life.

Wear Powder Build-up Options:

- FPWP-60 - Cam lobes, sealing surfaces, not machinable.
- FPWP-100 - Plow shears, cultivator sweeps, disk blades, augers, harvesters knives, excellent for metal to earth wear.
- FPWP-600 - Same as above - for high wear applications.

This amazing torch provides an easy and cost effective method to build-up broken parts, resurface worn parts, and build-up cracks in cast iron parts.

Comes with "How To" Video



HARDFACING A DISC BLADE

OxyFuel Eye Protection

Specifications

Part No.	Description	Part No.	Description
1423-4181	Shade 5 Protective Eyewear	1423-4177	Luxur™ – Fashion Safety Glasses, One-piece Lens, Adjustable Templates
1423-4182	Clear Protective Eyewear	1423-0018	Lift Front, Welder's Goggle Soft Frame
1441-3408	Symetrix™ – Wrap-a-Round Visitor Glasses	1423-0017	Fixed Front, Welder's Goggle Soft Frame

STANDARD

**ANSI
Z87.1**



OxyFuel Hoses

Specifications

Part No.	Description	Fuel Gas Type
1412-0012	3/16" x 12.5 ft. (Dual)	Acetylene
1412-0020	3/16" x 25 ft.	Acetylene
1412-0021	1/4" x 25 ft.	Acetylene
1412-0022	1/4" x 50 ft.	Acetylene



OxyFuel hoses are "Grade R" recommended for Oxygen and Acetylene, available in pre fitted lengths from 12.5 ft. to 50 ft. Compatible with all the OxyFuel range and suitable for light to heavy duty fusion welding, braze welding, brazing, heating and hand cutting applications.



FEATURES

- Premium quality hose that meets or exceeds the requirements of RMA and CGA
- Secure, specifically designed hose fittings ensure operator safety
- Color coded for easy identification
- Precut to length with fitted connections
- 12.5 ft., 25 ft. and 50 ft. lengths in 3/16" and 1/4" bore diameter
- Grade R hose recommended for use with Acetylene

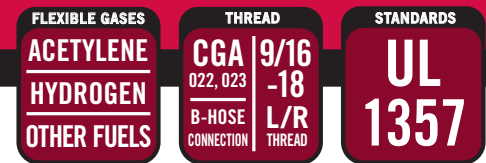
KEY INFORMATION

It is important to use the correct type of hose for the required gas(es) to be used. Any non-standard application should always be checked and approved before being put into operation. Pressure drops will occur through hoses and hose fittings, therefore allowances must be made to compensate for this when setting up equipment and adjusting regulators. Color coding of hoses and different threads for fuel and Oxygen prevents incorrect connections of hoses to the wrong gas type. Dual hoses help to keep the work area tidy, which reduces the risk of hose damage.

OxyFuel Flashback Arrestors

Specifications

Part No.	Description	Fuel Gas Type
0656-0008	OxyFuel 250-350 Flashback arrestors	All
0656-0000	KC-1 Kwik Connect™ Pair Pak (Oxygen and Fuel)	All
0656-0016	FPRA Regulator Flashback arrestor set with check valves	All



FEATURES

- Provide ultimate protection against "Flashback" and premature failure of system components
- High flow capacity
- Non-return valve
- Large cylindrical stainless steel flame arrestor

APPLICATIONS

Designed for connection to the inlet of the torch handle and used for all cutting, heating and welding applications

OxyFuel Tanks & Totes

Specifications

Part No.	Description	Fuel Gas Type
0916-0033	OX-20 Type "R" Oxygen Cylinder, 20 cu. ft. Capacity	All
0916-0032	AC-MC Type "MC" Acetylene Cylinder, 10 cu. ft. Capacity	All
1421-0085	Cylinder Tote Only	All



FEATURES AC-MC

- Type "MC" Acetylene Cylinder, 10 cu. ft. Capacity
- CGA 200 Connection
- DOT, TC Certified

FEATURES NT-40

- 40 cu. ft. Nitrogen Cylinder
- CGA 580 Connection
- DOT, TC Certified

FEATURES OX-20

- Type "R" Oxygen Cylinder, 20 cu. ft. Capacity
- CGA 540 Connection
- DOT, TC Certified

APPLICATIONS

Tote and small tanks designed for smaller cutting, heating and welding jobs allowing easy transport with this highly portable system.

OxyFuel Cutting Tips

Refer to Table on Page 10



ACETYLENE



NATURAL GAS



PROPYLENE



FEATURES

- Longer Nozzle life – high grade copper and advanced manufacturing techniques give the Firepower OxyFuel superior cutting life.
- Better quality cutting – the mirror smooth finish of the gas ports assures stable gas flow and superior cutting oxygen stream. Cuts are clean and smooth with the narrowest kerf.
- Less slag adhesion – copper content conducts heat away from the nozzle face. The nozzle keeps cooler and slag adherence to the nozzle face is reduced.
- Consistent manufacture batch testing ensures OxyFuel nozzles will consistently deliver the highest quality performance

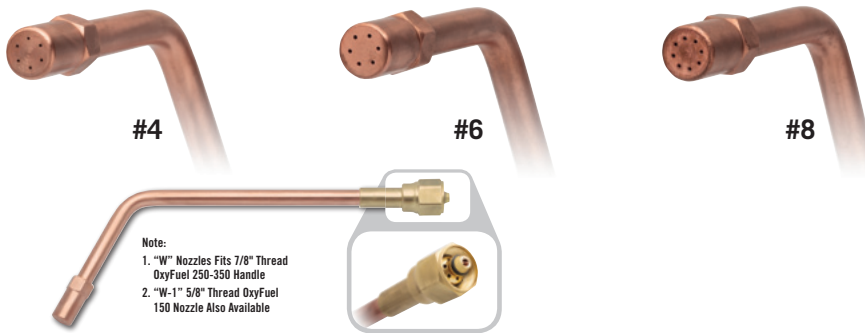
APPLICATIONS

Used for cutting steel 1/8" to 6" thick

OxyFuel Heating Nozzles

Specifications

Part No.	Description	Fuel Gas Type	Size
0387-0060	350 Series Multi-flame Nozzle (Clamshell)	Acetylene	4
0387-0061	350 Series Multi-flame Nozzle (Clamshell)	Acetylene	6
0387-0062	350 Series Multi-flame Nozzle (Clamshell)	Acetylene	8



FEATURES

- Concentrated high temperature flame
- Wide range for different applications
- Connects directly to the OxyFuel torch handle platform

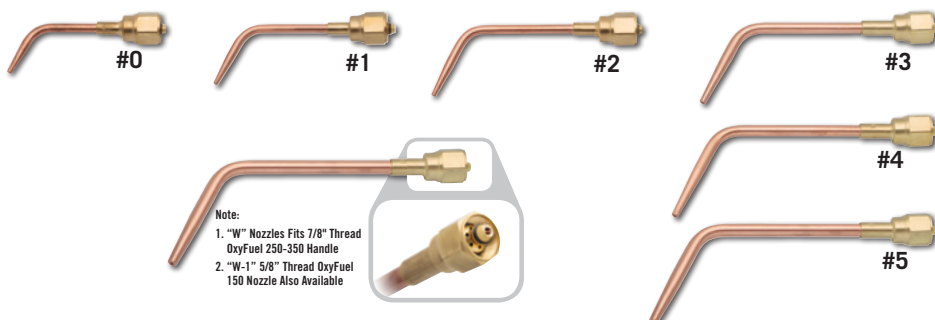
APPLICATIONS

Used for concentrated heating of steel and other materials.

OxyFuel Welding Nozzles

Specifications

Part No.	Description	Fuel Gas Type	Part No.	Description	Fuel Gas Type
0323-0360	#0 Acetylene Welding Nozzle	Acetylene	0323-0363	#3 Acetylene Welding Nozzle	Acetylene
0323-0361	#1 Acetylene Welding Nozzle	Acetylene	0323-0364	#4 Acetylene Welding Nozzle	Acetylene
0323-0362	#2 Acetylene Welding Nozzle	Acetylene	0323-0365	#5 Acetylene Welding Nozzle	Acetylene



FEATURES

- Concentrated high temperature flame
- Wide range for different applications
- Connects directly to the OxyFuel torch handle platform

APPLICATIONS

Used for fusion welding, braze welding, brazing, and soldering of thin steel and other weldable materials.

OxyFuel Welding Rods

Specifications

Part No.	Description	Dimensions	Weight	Part No.	Description	Dimensions	Weight
1440-0442	Oxygen/Acetylene Mild Steel (Copper Coated)	1/16" x 18"	5 lbs	1440-0431	MANGANESE Bronze Flux Coated Gas Rods	3/32" x 36"	1 lb.
1440-0427	MANGANESE Bronze Bare Gas Rods	3/32" x 36"	5 lbs.	1440-0429	MANGANESE Bronze Flux Coated Gas Rods	3/32" x 36"	5 lbs.
1440-0428	MANGANESE Bronze Bare Gas Rods	1/8" x 36"	5 lbs.	1440-0430	MANGANESE Bronze Flux Coated Gas Rods	1/8" x 36"	5 lbs.



- ACETYLENE TYPE CUTTING TIPS (TYPE 101)

TIP SIZE	PLATE THICKNESS	OXYFUEL 250 SERIES 3 - PART NO.	OXYFUEL 350 SERIES 1 - PART NO.	FUEL GAS FLOW (SCFH)	FUEL GAS PRESSURE (PSIG)	OXYGEN FLOW (TOTAL SCFH)	CUTTING OXYGEN PRESSURE (PSIG)
000	1/8" - 3 mm	6700-2438	6700-2408	3/5	3/5	20/25	20/25
00	1/4" - 6 mm	6700-2439	6700-2409	4/6	3/5	30/35	20/25
0	1/2" - 13 mm	6700-2440	6700-2410	6/10	3/5	60/65	30/35
1	3/4" - 19 mm	6700-2441	6700-2411	8/13	3/5	80/85	30/35
2	1" - 25 mm	6700-2442	6700-2412	10/16	3/6	140/150	35/40
3	2" - 51 mm	6700-2443	6700-2413	14/22	4/9	210/225	40/45
4	3" - 76 mm	6700-2444	6700-2414	18/30	5/10	270/320	40/50
5	5" - 127 mm	6700-2445	6700-2415	26/38	5/13	425/450	50/55
6	6" - 152 mm	-	6700-2416	30/44	7/13	500/600	45/40



- NATURAL GAS TYPE CUTTING TIPS (TYPE GPN)

TIP SIZE	PLATE THICKNESS	OXYFUEL 250 SERIES 3 - PART NO.	OXYFUEL 350 SERIES 1 - PART NO.	FUEL GAS FLOW (SCFH)	FUEL GAS PRESSURE (PSIG)	OXYGEN FLOW (TOTAL SCFH)	CUTTING OXYGEN PRESSURE (PSIG)
000	1/8" - 3 mm	6700-2498	6700-2468	5/6	3/5	12/14	20/25
00	1/4" - 6 mm	6700-2499	6700-2469	5/7	3/5	22/26	20/25
0	1/2" - 13 mm	6700-2500	6700-2470	8/10	3/5	50/55	30/35
1	3/4" - 19 mm	6700-2501	6700-2471	10/12	4/6	70/80	30/35
2	1" - 25 mm	6700-2502	6700-2472	12/15	4/8	115/125	35/40
3	2" - 51 mm	6700-2503	6700-2473	14/18	5/9	150/175	40/45
4	3" - 76 mm	6700-2504	6700-2474	16/20	8/12	210/250	45/50
5	5" - 127 mm	6700-2505	6700-2475	20/30	8/12	330-360	50/55
6	6" - 152 mm	-	6700-2476	25/35	10/15	400/500	45/55



- PROPYLENE GAS TYPE CUTTING TIPS (TYPE GPP)

TIP SIZE	PLATE THICKNESS	OXYFUEL 250 SERIES 3 - PART NO.	OXYFUEL 350 SERIES 1 - PART NO.	FUEL GAS FLOW (SCFH)	FUEL GAS PRESSURE (PSIG)	OXYGEN FLOW (TOTAL SCFH)	CUTTING OXYGEN PRESSURE (PSIG)
000	1/8" - 3 mm	6700-2618	6700-2588	5/6	3/5	12/14	20/25
00	1/4" - 6 mm	6700-2619	6700-2589	5/7	3/5	22/26	20/25
0	1/2" - 13 mm	6700-2620	6700-2590	8/10	3/5	50/55	30/35
1	3/4" - 19 mm	6700-2621	6700-2591	10/12	4/6	70/80	30/35
2	1" - 25 mm	6700-2622	6700-2592	12/15	4/8	115/125	35/40
3	2" - 51 mm	6700-2623	6700-2593	14/18	5/9	150/175	40/50
4	3" - 76 mm	6700-2624	6700-2594	16/20	8/12	210/250	45/50
5	5" - 127 mm	-	6700-2595	20/30	8/12	330/360	50/55
6	6" - 152 mm	-	6700-2596	25/35	10/15	400/500	45/55



INNOVATION TO SHAPE THE WORLD™

U.S. Customer Care: 800-858-4232 • Canada Customer Care: 905-827-4515 • International Customer Care: 940-381-1212