

# JIS

JAPANESE  
INDUSTRIAL  
STANDARD

Translated and Published by  
Japanese Standards Association

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**JIS B 6801** : 2003

(JWES)

**Manual blowpipes for welding,  
cutting and heating**

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ICS 25.160.30

Reference number : JIS B 6801 : 2003 (E)

## Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee, as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Welding Engineering Society (JWES) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14. Consequently **JIS B 6801 : 1991** and **JIS B 6802 : 1991** are replaced with this Standard.

This revision has been made based on **ISO 5172 : 1995 *Manual blowpipes for welding, cutting and heating—Specifications and tests*** for the purposes of making it easier to compare this Standard with International Standard; to prepare Japanese Industrial Standard conforming with International Standard; and to propose a draft of an International Standard which is based on Japanese Industrial Standard.

Date of Establishment: 1951-02-23

Date of Revision: 2003-08-20

Date of Public Notice in Official Gazette: 2003-08-20

Investigated by: Japanese Industrial Standards Committee  
Standards Board  
Technical Committee on Welding

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JIS B 6801 : 2003, First English edition published in 2004-03

Translated and published by: Japanese Standards Association  
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

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In the event of any doubts arising as to the contents,  
the original JIS is to be the final authority.

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Printed in Japan

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## Manual blowpipes for welding, cutting and heating

**Introduction** This Japanese Industrial Standard has been prepared based on the first edition of **ISO 5172** *Manual blowpipes for welding, cutting and heating—Specifications and tests*, published in 1995 by modifying the technical contents. In this revision, specifications from **JIS B 6802** *Manual gas cutting torches* are integrated, and those for manual blowpipes for heating are added.

The portions underlined with dots in this Standard are the matters modified from the International Standard. Annex C (informative) shows a list of modifications with the explanations thereof.

**1 Scope** This Standard applies to manual blowpipes for welding, cutting and heating (hereafter referred to as “welding blowpipes, cutting blowpipes, and heating blowpipes”) used for welding, cutting and heating metals by mixing oxygen with fuel gas such as acetylene gas, or liquefied petroleum gas (hereafter referred to as “LPG”) of the maximum working flow-rate shown in Table 1 [for fuel gas not described in Table 1, the fuel gas of heat generation of 134 400 kJ/h (32 000 kcal/h) or under shall apply], or gases of the heating effect equivalent thereto.

**Table 1 Maximum working flowrate**

Fuel gas	Symbol	Maximum working flowrate (l/h)
Acetylene	A	2 500
Propane	P	1 500
Butane		1 200
Natural gas, methane	M	4 000
Hydrogen	H	13 000
Ethylene	E	2 200

Remarks : The International Standard corresponding to this Standard is as follows.

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21**.

ISO 5172 : 1995 *Manual blowpipes for welding, cutting and heating—Specifications and tests* (MOD)

**2 Normative references** The following standards contain provisions which, through reference in this Standard, constitute provisions of this Standard. If the indication of the year of publication is given to these referred standards, only the edition of the indicated year constitutes the provision of this Standard but the revision and amendment made thereafter do not apply. The normative references without the indication