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**Gas welding equipment — Blowpipes  
for gas welding, heating and cutting —  
Specifications and tests**

**AMENDMENT 1**

*Matériel de soudage aux gaz — Chalumeaux pour soudage aux gaz,  
chauffage et coupage — Spécifications et essais*

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## Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

Amendment 1 to ISO 5172:2006 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 8, *Equipment for gas welding, cutting and allied processes*.

Requests for official interpretations of any aspect of this Amendment should be directed to the Secretariat of ISO/TC 44/SC 8 via your national standards body. A complete listing of these bodies can be found at [www.iso.org](http://www.iso.org).

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# Gas welding equipment — Blowpipes for gas welding, heating and cutting — Specifications and tests

## AMENDMENT 1

### Page 7, 6.1

Delete the existing text and insert the following.

The marking shall be legible and durable and shall be in accordance with 6.2 to 6.7.

In the following, the “manufacturer” includes also distributors and suppliers.

### Page 7, 6.4

Delete the existing text and insert the following.

The minimum marking requirements for all nozzles are given in Annex J.

### Page 26, Clause 10

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Delete the existing text and insert the following.

The manufacturer shall supply, with each blowpipe, instructions for use, in the language of the country where it is sold, covering at least:

- permissible types of gas;
- all applicable pressure and flow data;
- explanation of all the marking;
- details of the mixing principle;
- safety devices which are required or recommended;
- safety warnings;
- steps to be taken before operation, including leak testing;
- how to operate, including lighting-up and shutdown;
- service, maintenance and repair.

The instructions shall also include detailed information on nozzles:

- the manufacturer shall provide the torch operator with detailed instructions for proper settings of the heating or brazing nozzles;
- this information shall include the recommended pressure settings in kilopascals and the volume flow rates in litres per minute for the oxygen and fuel gas required — these settings should give the operator acceptable performance under normal operating conditions;
- the manufacturer shall provide safety information for the proper use and operation of the nozzles and related equipment used for oxyfuel cutting, welding, as well as heating or brazing — this information should be in the form of instruction literature or imprinted on the product carton.

*Page 38*

Delete Annex D.

*Page 45*

Before the Bibliography, insert Annex J. See text overleaf.

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**Annex J**  
(normative)

**Uniform designation system for oxyfuel nozzles**

In the oxyfuel welding and cutting industry, every equipment manufacturer has its own system for designating the size of oxyfuel nozzles for cutting, welding, as well as heating or brazing. These systems are based on a variety of different nozzle features and in many cases are completely arbitrary. In any case, it is currently impossible to identify a nozzle by model number for a given manufacturer and cross-reference it to a different manufacturer to obtain like performance and size, i.e. there is no consensus among manufacturers on the designation of nozzles which have similar performance and uses.

The following system of marking provides a common information base that the operator can rely on to identify nozzle performance from one manufacturer to another. The overall intent of this system is to provide a common identification system that results in the safe operation of oxyfuel nozzles, i.e. operators are informed that they are using the correct nozzle for the job being performed.

<b>Cutting or welding</b>
Name, registered trademark or identifying mark of manufacturer
Symbol for fuel gas
Thickness range of the work piece or code to permit easy reference to the operating data
<b>Heating or brazing</b>
Name, registered trademark or identifying mark of manufacturer
Symbol for fuel gas and oxygen or compressed air
Code to permit easy reference to the operating data

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