

ABSTRACT

GAS CUTTING METHOD, GAS CUTTING MACHINE, AND CUTTING TIP

A gas cutting method is provided which includes: mixing hydrogen gas and hydrocarbon gas to acquire fuel gas; ejecting a preheating flame, which is formed by mixing and igniting the fuel gas and preheating oxygen gas, from an end of a cutting tip to heat a workpiece; and ejecting cutting hydrogen gas to the heated workpiece to cut the workpiece. Here, the content of the hydrocarbon gas in the fuel gas is more than 0 vol% and equal to or less than 4 vol%.

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Figure 1