



## Type: iMixclassic

Flow capacity in l/min related to Nitrogen:

Outlet pressure [bar] →	0,5	1	2	3	4	5	6	7	8
Inlet pressure [bar] ↓									
4	300.0	275.0	200.0	-	-	-	-	-	-
5	458.3	425.0	358.3	250.0	-	-	-	-	-
6	558.3	541.7	500.0	416.7	308.3	-	-	-	-
7	700.0	666.7	633.3	566.7	475.0	350.0	-	-	-
8	833.3	800.0	775.0	725.0	641.7	541.7	400.0	-	-
9	950.0	925.0	900.0	866.7	791.7	708.3	575.0	441.7	-
10	1050.0	1033.3	1000.0	983.3	950.0	833.3	783.3	633.3	475.0

The following table shows the correction factors as an example for different gas mixtures.

The correct values of the selected gas mixtures are to be calculated by a correction factor.

### Application table:

Gas mixture		
% CO <sub>2</sub>	% Ar	Correction factor
18	82	0.8812
4	96	0.8336
25	75	0.9050

  

% He	% Ar	Correction factor
20	80	0.866
60	40	0.958

  

% O <sub>2</sub>	% Ar	Correction factor
4	96	0.8224
10	90	0.826

  

% O <sub>2</sub>	% O <sub>2</sub>	Correction factor
50	50	1.02
85	15	0.922

### Application table:

Gas mixture		
% CO <sub>2</sub>	% N <sub>2</sub>	Correction factor
30	70	1.048
5	95	1.008
80	20	1.128

  

% He	% N <sub>2</sub>	Correction factor
10	90	1.005

  

% O <sub>2</sub>	% N <sub>2</sub>	Correction factor
4	96	0.9952
25	75	0.97

### Application example:

Gas mixture setting:	
Gas mixture:	18 % CO <sub>2</sub> in Ar
Correction factor:	0.8812
Consumption:	18 l/min
Flow regulator:	18 : 0.8812 = 20 l/min

### Certification/ Technical Standards/ Rules

TRBS German Technical rules for operation safety, DVS German Association for Welding, Cutting and Allied Processes, DGUV German Employer's liability insurance association rules and regulations.

### Standards/ Approvals

Company certified according to  
 ISO 9001:2015 and ISO 14001:2015,  
 CE-marking according to: Pressure Equipment Directive 2014/68/EU

(Subject to change without notice)