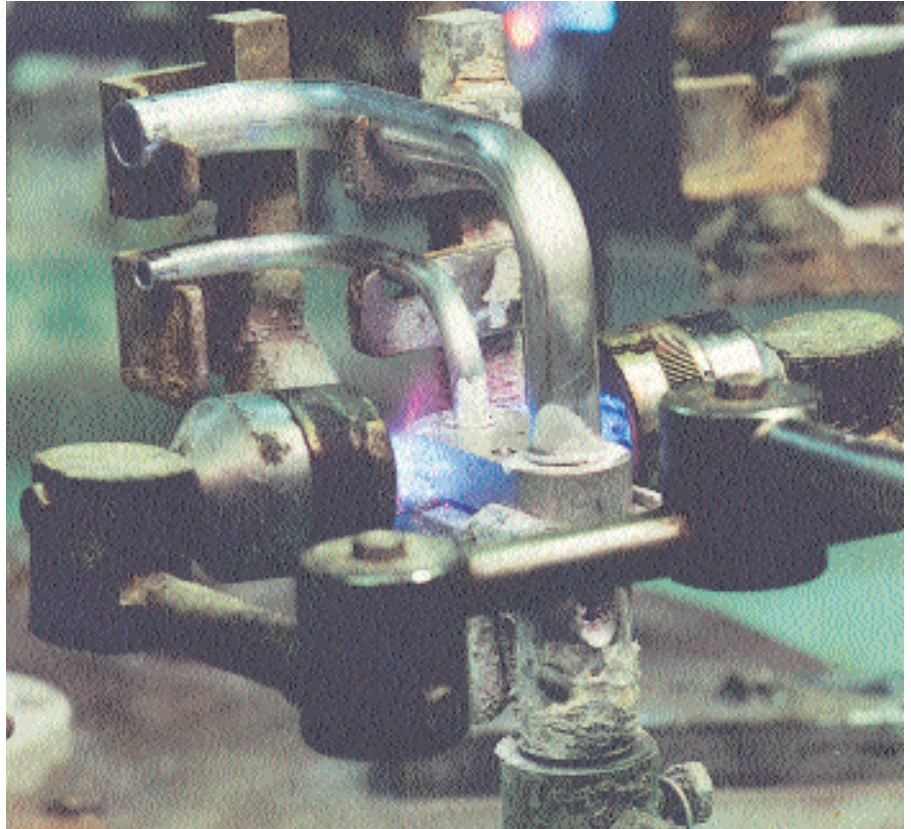


SIAD METAL FABRICATION

In business for almost 80 years now and with over 12,000 clients in the metal working and 350 clients in the high powered Laser cutting sectors, SIAD is a market leader in the field of mechanical manufacturing. SIAD makes an ideal partner for the development of technologically advanced, highly competitive and innovative solutions given the high level of the company's quality, experience, competence and customer service.

SIAD's commitment to quality is based on the realisation that the quality of its gases is a fundamental factor in metal working processes. The company's desire to satisfy the needs and expectations of its clients also underlines this commitment.

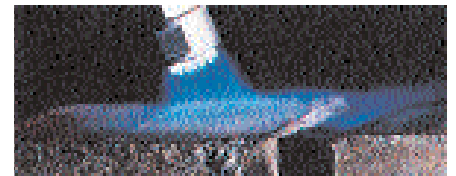
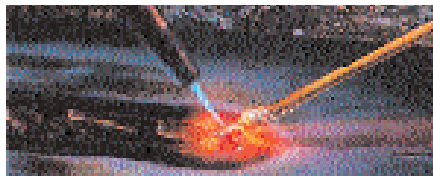


STARFLAME™

STARFLAME™ is a combustible gas which, thanks to the use of the special additive HGX3, guarantees the high productivity levels obtained by using acetylene combined with the savings usually associated with the commercial distribution of GPL. **STARFLAME™** helps to achieve high flame temperature levels and superior calorific potential whilst guaranteeing complete stability, the absence of toxic components and a prolonged life for consumables.

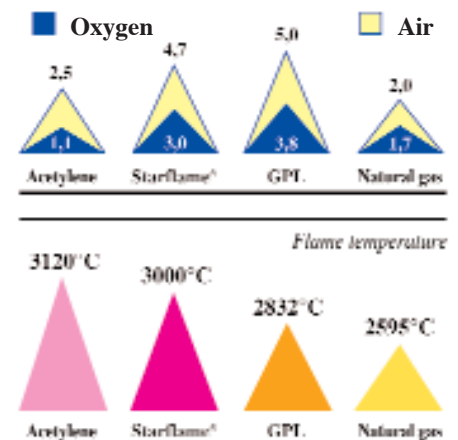
STARFLAME™ is an excellent product for a wide range of industrial applications, guaranteeing top performance in:

- Oxy-Fuel cutting:
 - straight and shaped cuts
 - automated and manual cutting processes
 - industrial demolition
- Brazing processes:
 - manual brazing
 - automated brazing systems
- wire metallization
- heating and superficial hardening
- granite flaming



STARFLAME™ characteristics

- Composition: mixture of liquefied gases comprising of propane with the additive HGX3/2
- Physical state within container: pressurised liquid
- Average molecular weight: 48.3 g/mol.
- Specific weight: liquid at 20°C; 0,52Kg/lit; gaseous at 15°C; 2,10 Kg/mc
- Limit of flammability in O₂: 2,4 ÷ 57%
- Limit of flammability in air: 2,3 ÷ 9,5%
- Tendency to backward reignite: rare
- Reaction with materials: none



Consumption: volume of oxygen by volume of combustible (m³/m³)

Combustion properties

- Flame temperature with O₂: 3,000°C
- Total calorific potential: 23.246 Kcal/Nmc
- Total calorific potential: 12.016 Kcal/ Kg
- Speed of combustion with O₂: 4,1mt/sec
- Type of combustion reaction: exothermic
- Calorific potential of primary combustion: 4.165 Kcal/Nmc
- Calorific potential of secondary combustion: 19.081 Kcal/Nmc

	STARFLAME	ACETYLENE	GPL	NATURAL GAS
■ good ■ excellent ■ unsuitable ■ average				
CUT < 9.5 mm				
CUT BETWEEN 9.5 AND 127 mm				
CUT > 127 mm				
WIRE METALLIZATION				
POWDER METALIZATION				
HEATING				
STRIP PREPARATION				
DEEP LEVEL HARDENING				
SUPERFICIAL HARDENING				
IRON WELDING				
BRAZING				
CARBONISING				



Fixed storage tanks	Geometric capacity	Pressure	STARFLAME™ content	Dimensions mm
Tank	990 litres	5 Bar at 15°C	792 lt (142 kg)	1.2.160 - h 1.310 - ø 800
Tank	1.750 litres	5 Bar at 15°C	1.400 lt (728 kg)	1.2.550 - h 1.350 - ø 1.000
Tank	3.000 litres	5 Bar at 15°C	2.400 lt (1.248 kg)	1.2.950 - h 1.560 - ø 1.200
Tank	5.000 litres	5 Bar at 15°C	4.000 lt (2.080 kg)	14.750 - h 1.560 - ø 1.200

All tanks are equipped with safety and control instruments in compliance with the law and supplied complete with level indicator. Installation must be carried out in accordance with current regulations for the storage of combustible gases.

Equipment and plants for the use of STARFLAME™

Centralised plants

Whilst ensuring compliance with most recent regulations regarding the safety and use of combustible gases, SIAD designs and installs "turn key" centralised distribution plants, guaranteeing the Client safety and thorough planning for the storage of gas products.

Pressure reducers for gas cylinders

SIAD, recommends the use of its own pressure reducers, accessories and materials, which form part of its industrial range, in connection with gas cylinders under the UNI regulations, all of which conform to the EN526 standards.



Mobile containers	Geometric capacity	Pressure	STARFLAME™ content	Connection Valve	Dimensions mm
Bins	60 litres	5 Bar at 15°C	(25 kg)	UNI 4405 gr. 1	h 860 - ø 370
Bins	84 litres	5 Bar at 15°C	(35 kg)	UNI 4405 gr. 1	h 1.320 - ø 315
Mobile Tanks	500 litres	5 Bar at 15°C	400 lt (208 kg)	UNI 4405 gr. 1	h 1.450 - ø 800

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