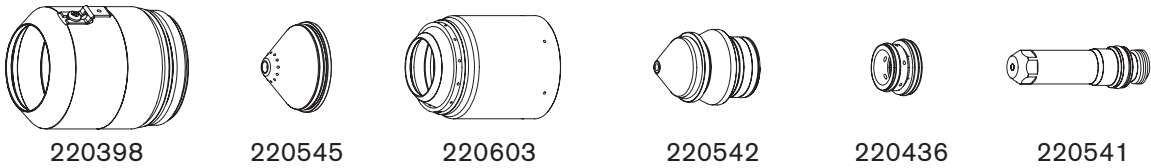
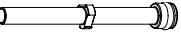


Mild steel bevel cutting
O₂ Plasma / Air Shield
260 A

Flow rates - lpm/scfh @ 3/4" setting		
	O ₂	Air
Preflow	0 / 0	130 / 275
Cutflow	42 / 88	104 / 220



Notes: Bevel angle range is 0° to 45°. Water tube 220571  must be used with these consumables.

Metric

Select Gases		Set Preflow		Set Cutflow		Minimum Clearance	Equivalent Material Thickness	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time			
Plasma	Shield	Plasma	Shield	Plasma	Shield	mm	mm	Range (mm)	mm/m	mm	factor %	seconds			
O ₂	Air	22	49	76	46	2.0	6	2.8 - 7.6	6500	8.5	300	0.3			
							10		4440						
							12		3850						
				80	49		20	2170	3.6 - 7.6	15	3130	9.0	250	0.5	
										22	1930			0.6	
										25	1685			0.7	
				84	49		28	1445	4.8 - 7.6	32	1135	9.5	200	0.8	
										38	895			0.9	
										44	580			1.0	
										50	405			1.2	
										58	290			Edge start	
										64	195			Edge start	

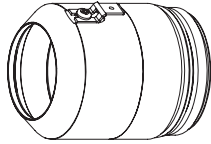
English

Select Gases		Set Preflow		Set Cutflow		Minimum Clearance	Equivalent Material Thickness	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time			
Plasma	Shield	Plasma	Shield	Plasma	Shield	in	in	Range (in)	ipm	in	factor %	seconds			
O ₂	Air	22	49	76	46	0.080	1/4	0.110 - 0.300	245	0.330	300	0.3			
							3/8		180						
							1/2		145				0.4		
				80	49		3/4	90	0.140 - 0.300	5/8	115	0.350	250	0.5	
										7/8	75			0.6	
										1	65			0.7	
				84	49		1-1/8	55	0.190 - 0.300	1-1/4	45	0.380	200	0.8	
										1-1/2	35			0.9	
										1-3/4	22			1.0	
										2	15			1.2	
										2-1/4	12			Edge start	
										2-1/2	8			Edge start	

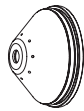
Stainless steel bevel cutting

H35 Plasma / N₂ Shield
260 A

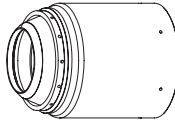
Flow rates - lpm/scfh @ 3/4" setting		
	H35	N ₂
Preflow	0 / 0	127 / 270
Cutflow	40 / 84	122 / 260



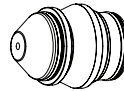
220398



220609



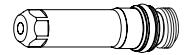
220608



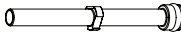
220607



220405



220606

Notes: Bevel angle range is 0° to 45°. Water tube 220571  must be used with these consumables.

Metric

Select Gases		Set Preflow		Set Cutflow		Minimum Clearance	Equivalent Material Thickness	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield	mm	mm	Range (mm)	mm/m	mm	factor %	seconds
H35	N ₂	12	49	85	60	2.0	10	11.0	1870	12.5	100	0.3
							12	9.0 – 10.0	1710			0.4
							15	7.5 – 10.0	1465			0.5
							20		1085	120	0.6	
							25		785		0.7	
							32		630		1.0	
							38		510		Edge start	
							44		390			
							50	270				

English

Select Gases		Set Preflow		Set Cutflow		Minimum Clearance	Equivalent Material Thickness	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield	in	in	Range (in)	ipm	in	factor %	seconds
H35	N ₂	12	49	85	60	0.080	3/8	0.450	75	0.500	100	0.3
							1/2	0.350 – 0.400	65			0.350
							5/8	0.300 – 0.400	55	0.360	120	0.5
							3/4		45			0.6
							1		30			0.7
							1-1/4		25			1.0
							1-1/2		20	Edge start		
							1-3/4		15			
							2	10				