

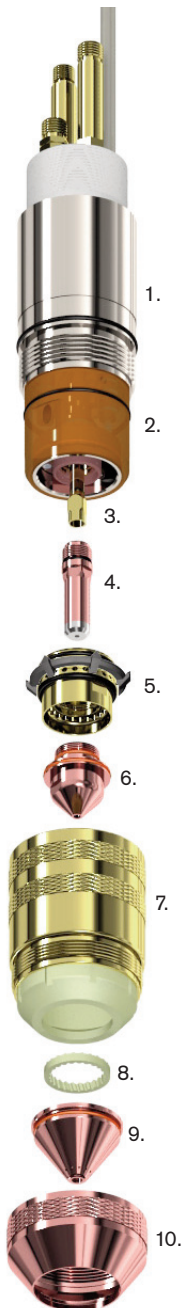
Why choose between speed, cut quality and consumable life?

Upgrade to XP3™ consumables to increase speed and consumable life without sacrificing cut quality. Benefit from 3 advanced technologies – SilverLine™, CoolFlow™ and MultiPort™ – designed to deliver extra value to your cutting process beyond that of the OEM.

Centricut XP3 consumables for ESAB®

PT-600 and PT-19XLS

Quick Set-up



Achieve maximum consumable life

A fully used SilverLine electrode will have a pit depth of .130" (3.3 mm). This is deeper than the recommended pit depth for standard parts of .090" (2.3 mm).

With proper use, the CoolFlow nozzle will last 1:1 with the SilverLine electrode.

Purge torch: After each parts change purge the torch for at least 30 seconds to remove residual moisture.

Leak check: After purging the torch make sure all o-ring seals are working as designed.

Adjust gas flow: Plasma gas flow rate is critical. High flow will cause rapid electrode wear and hard starting. Low flow will cause uncontrolled arcing. (See parameters on back.)

Adjust arc voltage: As the consumables wear, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 2-volt increments, up to 20 volts higher than the initial setting.

Avoid running off work: This occurs when the arc stretches during rip cutting off the plate or when the arc chases a part as it falls. This shortens consumable life.

Properly tighten the nozzle retaining cap: Make sure the nozzle retainer is sealed tightly against the nozzle to prevent leaking.

Pierce at correct height: Refer to the cut chart on the back for optimum pierce height. Piercing too low causes molten metal (spatter) to hit the shield and nozzle – the most common cause of premature nozzle failure. Piercing too high can cause misfires.

Adjust shield gas flow: Refer to the cut chart on the back for optimum shield gas flow. Having the correct start shield flow provides protection to the nozzle and shield during the pilot process.

Clean the nozzle and shield: Periodically clean the nozzle and shield to remove spatter. This will prevent double arcing.

	Part number	Reference	Description
	C96-925	0558001825	Torch body modular
1.	C47-066	37066	Torch body
2.	C47-083	37083	Insulator body
	C47-071	37071	Contact ring assembly
3.	C96-621	0558001621	Electrode holder
	C47-142	0558002533/948142	Gas swirl baffle, 4 hole, std
	C10-660	0558001625, 35660	Gas swirl baffle, 8 hole, std
4.	C120-1010	N/A	SilverLine electrode*
5.	C120-030	N/A	CoolFlow nozzle base assembly**
	C120-010	N/A	CoolFlow nozzle base**
	C120-020	N/A	Baffle, coolant**
6.	C120-200	N/A	CoolFlow nozzle tip, 200 amp**
	C120-260	N/A	CoolFlow nozzle tip, 260 amp**
	C120-360	N/A	CoolFlow nozzle tip, 360 amp**
7.	C47-082	37082	Nozzle retaining cap
8.	C47-944	21944	Diffuser, 100 – 600 amp
9.	C120-920	N/A	MultiPort shield, 200 amp*
	C120-900	N/A	MultiPort shield, 260 amp*
	C120-936	N/A	MultiPort shield, 360 amp*
10.	C47-081	37081	Shield retainer
	C120-013	N/A	Wrench, nozzle base
	C120-012	N/A	Wrench, electrode/nozzle

* patented

** patent pending

Recommended parameters for mild steel cutting with oxygen

Thickness mm	Amps A	Start gas N ₂ bar	Cut gas O ₂		Shield gas		Arc voltage V	Cut height mm	Initial height mm	Above water cutting speed mm/min	Under water cutting speed mm/min	Pierce delay sec	Kerf width mm
			Auto bar	Flow cfh	Start/Cut bar	Start/Cut Flow cfh							
6	EPP or ESP	1.7	3.1	140	5.9	200	132	3.2	9.5	6350	5715	0.0	1.5
10		1.7	3.1	140	5.9	200	138	3.2	9.5	3937	3556	0.2	2.2
12		1.7	3.1	140	5.9	200	140	3.2	9.5	3073	2794	0.2	2.3
15		1.7	3.1	140	5.9	200	147	3.4	12.7	2540	2286	0.3	2.4
18		1.7	3.1	140	5.9	200	151	3.6	12.7	1930	1778	0.4	2.4
25		1.7	3.1	140	5.9	200	154	3.6	12.7	1270	1143	0.5	2.5
6	260	1.7	2.8	120	1.2	250	130	3.4	9.5	6223	5613	0.0	2.4
10		1.7	2.8	120	1.2	250	134	3.4	9.5	4572	4115	0.0	2.7
12		1.7	2.8	120	1.2	250	135	3.6	12.7	3683	3327	0.2	2.9
15		1.7	2.8	120	1.2	250	138	3.8	12.7	2921	2642	0.2	3.2
18		1.7	2.8	120	1.2	250	142	5.6	12.7	2286	2057	0.2	3.4
25		1.7	2.8	120	1.2	250	150	10.6	15.9	1651	1499	0.4	3.8
30		1.7	2.8	120	1.2	250	162	10.6	15.9	1143	1041	0.8	3.9
40		1.7	2.8	120	1.2	250	168	10.6	15.9	889	813	1.2	4.1
12	360	1.7	3.3	140	1.5	250	132	3.4	12.7	4115	3708	0.2	3.4
15		1.7	3.3	140	1.5	250	134	3.4	12.7	3556	3200	0.3	3.6
18		1.7	3.3	140	1.5	250	135	3.4	12.7	3048	2743	0.3	3.7
25		1.7	3.3	140	1.5	250	147	6.4	15.9	2032	1829	0.5	3.9
30		1.7	3.3	140	1.5	250	150	6.4	15.9	1397	1270	0.6	5.1
40		1.7	3.3	140	1.5	250	153	6.4	15.9	965	889	0.7	5.6

Thickness in.	Amps A	Start gas N ₂ psi	Cut gas O ₂		Shield gas		Arc voltage V	Cut height in.	Initial height in.	Above water cutting speed in/min	Under water cutting speed in/min	Pierce delay sec	Kerf width in.
			Auto psi	Flow cfh	Start/Cut psi	Start/Cut Flow cfh							
1/4	EPP or ESP	25	45	140	85	200	132	.125	.375	250	225	0.0	.060
3/8		25	45	140	85	200	138	.125	.375	155	140	0.2	.085
1/2	200	25	45	140	85	200	140	.125	.375	121	110	0.2	.090
5/8		25	45	140	85	200	147	.135	.500	100	90	0.3	.095
3/4		25	45	140	85	200	151	.140	.500	76	70	0.4	.095
1		25	45	140	85	200	154	.140	.500	50	45	0.5	.100
1/4	260	25	40	120	18	250	130	.135	.375	245	221	0.0	.095
3/8		25	40	120	18	250	134	.135	.375	180	162	0.0	.105
1/2		25	40	120	18	250	135	.140	.500	145	131	0.2	.115
5/8		25	40	120	18	250	138	.150	.500	115	104	0.2	.125
3/4		25	40	120	18	250	142	.220	.500	90	81	0.2	.135
1		25	40	120	18	250	150	.416	.625	65	59	0.4	.150
1-1/4		25	40	120	18	250	162	.416	.625	45	41	0.8	.155
1-1/2		25	40	120	18	250	168	.416	.625	35	32	1.2	.160
1/2	360	25	48	140	22	250	132	.135	.500	162	146	0.2	.135
5/8		25	48	140	22	250	134	.135	.500	140	126	0.3	.140
3/4		25	48	140	22	250	135	.135	.500	120	108	0.3	.145
1		25	48	140	22	250	147	.250	.625	80	72	0.5	.153
1-1/4		25	48	140	22	250	150	.250	.625	55	50	0.6	.200
1-1/2		25	48	140	22	250	153	.250	.625	38	35	0.7	.220

Contact your Hypertherm distributor or call 1-800-752-7623 for the location nearest to you.

Hypertherm®

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