



## **Parts and optimization guide for ESAB PT-19XLS and PT-600 torches**



**Achieve maximum consumable life from your consumables by following these simple instructions:**

**Use electrode to full life:** A fully used SilverLine electrode will have a pit depth of .120" (3.0 mm). This is deeper than the recommended pit depth for standard parts of .090" (2.3 mm).

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

**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 tight and there are no torch coolant leaks.

**Adjust plasma gas pressure:** Plasma gas flow rate is critical. High flow will cause rapid electrode wear and hard starting. Low flow will cause uncontrolled arcing.

**Adjust shield gas pressure:** Refer to the cut chart for optimum shield gas pressure. Having the correct start shield flow provides protection to the nozzle and shield during the piercing process.

**Pierce at correct height:** Refer to the cut chart for optimum pierce (initial) 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 and nozzle damage.

**Adjust arc voltage:** As the consumables wear, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 5-volt increments, up to 20 volts higher than the initial setting.

**Avoid arc stretching:** This can occur during rip cutting off the plate or when the lead out is improperly programmed. This shortens consumable life.

**Clean the nozzle and shield:** Periodically clean the nozzle and shield to remove spatter. This will prevent double arcing which shortens consumable life.

***Cut with confidence. It's Hypertherm.***

***Centricut consumables reduce your cost of cutting without sacrificing consumable life, cut speed or cut quality***

***Centricut consumables utilize Hypertherm's superior plasma technology and manufacturing excellence to deliver set-to-set consistency and the best possible performance***

## Centricut consumables for the ESAB torches deliver value to your plasma cutting process through long life and exceptional quality.

PARTS LIST			
Centricut number	ESAB beference numbers		Description
C47-066	37066	0004470040	Torch body, PT-19XLS
C96-925		0558001825	Torch body, PT-600
C47-071	37071	0558003858	Contact ring assembly
C47-142	948142	0558002533 0004485612	Gas swirl baffle, ceramic, 4 x .032"
L47-143	948143	0558002534 0004485613	Gas swirl baffle, ceramic, 4 x .032", rev
C10-660	35660	0558001625 0004485827	Gas swirl baffle, ceramic, 8 x .047"
C122-530R	35661	0558002530R	Gas swirl baffle, ceramic, 8 x .047", rev
L47-194	22194	0558002532 0004470097	Gas swirl baffle, ceramic, 32 x .023"
C47-068	37068	0004470037	Electrode holder, PT-19XLS
C96-621		0558001621	Electrode holder, PT-600
C96-1024	0558004461	0558001624	SilverLine® electrode, 250 A, PT-600
C96-1016	0558004462	0558002516	SilverLine electrode, 360/400 A, PT-600
C47-1096	34086	0558004458 0004485684	SilverLine electrode, 50-250 A, PT-19XLS
C47-1086	35886	0558004460 0004485829	SilverLine electrode, 360 A, PT-19XLS
C122-6010		0558001881	CoolFlow® nozzle, 1.0 mm – 50A
C122-018		0558001882	CoolFlow nozzle, 1.8 mm – 100A
C122-020		0558001883	CoolFlow nozzle, 2.0 mm – 150-200A
C122-023		0558001884	CoolFlow nozzle, 2.3 mm – 200A
C122-025	21822	0558001623	CoolFlow nozzle, 2.5 mm – 250A
C122-030	35885	0558001885	CoolFlow nozzle, 3.0 mm – 360A
C122-036	22195	0558001886	CoolFlow nozzle, 3.6 mm – 400A
C122-041	22401	0558001887	CoolFlow nozzle, 4.1 mm – 600A
C47-082	37082	0004470045	Nozzle retaining cup
L47-796	21796	0004470030	Diffuser, 50 A
C47-944	21944	0004470031	Diffuser, 100 – 600 A
C47-496	22496	0004470115	Diffuser, 100 – 600 A, rev
C122-130	21795	0004470027	Shield, 3.0 mm – 35 – 50 A
C122-141		0558004678	Shield, 4.1 mm – 200 A (PT-600 EPP Process)
C122-166	21802	0004470028	Shield, 6.6 mm – 100 – 250 A
C122-199	21945	0004470029	Shield, 9.9 mm – 325 – 600 A
C47-081	37081		Shield retainer



**Contact Hypertherm to locate a distributor near you.**

# Hypertherm®

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