Consumable selection

Standard cutting (0°)

Most of the consumables on the following pages are designed for standard (straight) cutting, when the torch is perpendicular to the workpiece.

Bevel cutting (0° to 45°)

Consumables for 130 amp and 260 amp bevel cutting are specifically designed for bevel cutting. 400 amp consumables can be used for standard cutting and bevel cutting, but bevel-specific, 400 amp cut charts are provided for convenience.

Marking

Any of the consumable sets can also be used for marking with argon or nitrogen. Marking parameters are shown at the bottom of each cut chart. The quality of the marks will vary depending on the marking process, cut process, material type, material thickness, and material surface finish. For best mark quality, use the argon marking process settings. For all marking processes the depth of the mark can be increased by reducing the marking speed, or the depth can be decreased by increasing the marking speed. Argon marking currents can be increased by up to 30% to increase the depth of the mark. When marking with an argon process at 25 amps or greater, the process will start with air before changing to argon, and a thicker, darker mark will be seen at the start of the mark. When using the argon marking processes, mark and cut individual parts. Marking the entire nest prior to cutting may lead to reduced consumable life. For better results intersperse cuts and marks. Poor quality marking or burn-through may occur with material less than 1.5 mm (0.06 in. or 16 gauge).

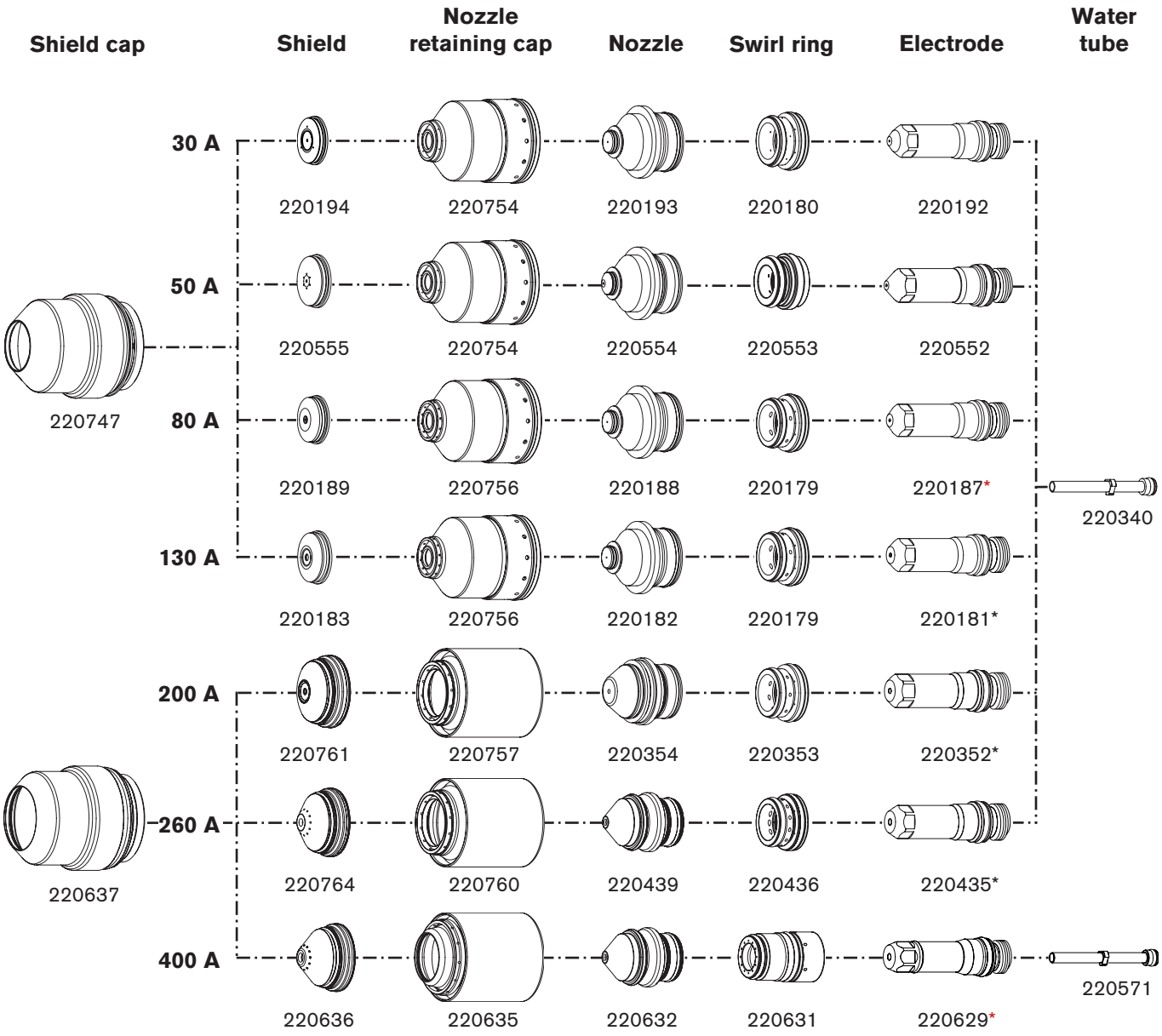
Consumables for mirror-image cutting

See the *Parts List* section in this manual for part numbers.

SilverPlus electrodes

SilverPlus electrodes provide increased life when the average cut duration is short (< 60 seconds), and cut quality is not the most critical requirement. SilverPlus electrodes are available for 80 amp, 130 amp, 200 amp, 260 amp, and 400 amp mild steel O_2 / Air cutting. Part numbers can be found on the following page.

Mild steel



* SilverPlus electrodes are available for these processes.

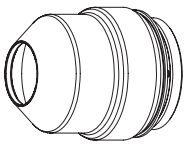
Mild steel, 80 amp, O_2 / Air – 420566
Mild steel, 130 amp, O_2 / Air – 220665
Mild steel, 200 amp, O_2 / Air – 220666
Mild steel, 260 amp, O_2 / Air – 220668
Mild steel, 400 amp, O_2 / Air – 420530

Mild steel

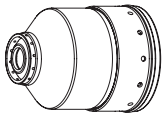
O_2 Plasma / Air Shield

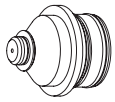
80 A

Flow rates – lpm/scfh		
	O_2	Air
Preflow	0 / 0	76 / 161
Cutflow	23 / 48	41 / 87

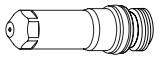

220747

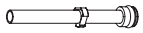

220189


220756


220188


220179


220187
420566 - SilverPlus


220340

Metric

Select Gases		Set Preflow		Set Cutflow		**Material Thickness**	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma gas	Shield gas	Plasma gas	Shield gas	Plasma gas	Shield gas	**mm**	Volts	mm	mm/m	mm	factor %	seconds
O_2	Air	48	23	78	23	**2**	112	2.5	9810	3.8	150	0.1
						2.5	115		7980			
						3	117		6145			0.2
						4	120	2.0	4300	4.0	200	
						5	121		3670			0.3
						6	123		3045			
						8	125		2430			0.4
						10	127		1810			0.5
					10	**12**	130		1410	5.0	250	0.7
						15	133		1030			0.8
						20	135	2.5	545	6.3		0.9

English

Select Gases		Set Preflow		Set Cutflow		**Material Thickness**	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma gas	Shield gas	Plasma gas	Shield gas	Plasma gas	Shield gas	**in**	Volts	in	ipm	in	factor %	seconds
O_2	Air	48	23	78	23	**0.075**	112	0.10	400	0.15	150	0.1
						0.105	115		290			
						0.135	117		180			0.2
						3/16	120	0.08	155	0.16	200	
						1/4	123		110			0.3
						5/16	125		96			0.4
						3/8	127		75			0.5
					10	**1/2**	130		50	0.20	250	0.7
						5/8	133		37			0.8
						3/4	135	0.10	25	0.25		0.9

Marking

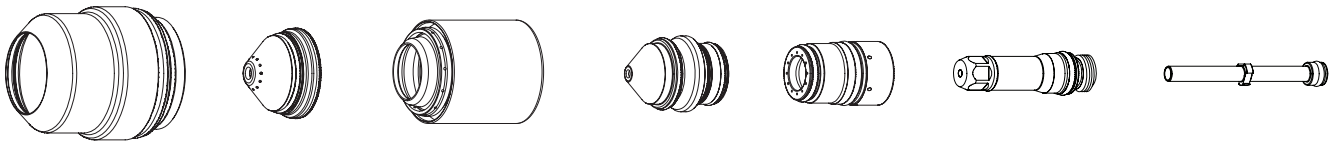
Select Gases		Set Preflow		Set Cutflow		**Amperage**	Torch-to-Work Distance		Marking Speed		Arc Voltage
						Amps	mm	in	mm/m	ipm	Volts
N_2	N_2	10	10	10	10	**15**	2.5	0.10	6350	250	130
Ar	Air	50	10	50	10	**15**	3.0	0.12	2540	100	78

Mild steel

O_2 Plasma / Air Shield

400 A

Flow rates – lpm/scfh		
	O_2	Air
Preflow	0 / 0	190 / 400
Cutflow	66 / 140	137 / 290



220637 220636 220635 220632 220631 220629 220571

420530 - SilverPlus

Metric

Select Gases		Set Preflow		Set Cutflow		**Material Thickness**	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma gas	Shield gas	Plasma gas	Shield gas	Plasma gas	Shield gas	**mm**	Volts	mm	mm/m	mm	Factor %	Seconds
O_2	Air	24	50	60	50	**12**	139	3.6	4430	7.2	200	0.4
						15	142		3950			0.5
						20	146		2805			0.7
						22	148	3.8	2540	7.6		0.8
						25	150	4.0	2210	8.0		0.9
						30	153	4.6	1790	9.2		1.1
						40	158		1160	11.5	250	1.9
						50	167	5.3	795	19.1	360	5.2
						60	173	6.4	580	Edge start		
						70	183		380			
						80	197	7.9	180			

English

Select Gases		Set Preflow		Set Cutflow		**Material Thickness**	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma gas	Shield gas	Plasma gas	Shield gas	Plasma gas	Shield gas	**in**	Volts	in	ipm	in	Factor %	Seconds
O_2	Air	24	50	60	50	**1/2**	140	0.14	170	0.28	200	0.4
						5/8	143		150			0.5
						3/4	145		115			0.6
						7/8	148	0.15	100	0.30		0.8
						1	151	0.16	85	0.32		0.9
						1-1/4	153	0.18	65	0.36		1.2
						1-1/2	157		48	0.45	250	1.6
						1-3/4	160		40			2.5
						2	168	0.21	30	0.75	360	5.5
						2-1/4	171	0.25	25	Edge start		
						2-1/2	175		20			
						3	193	0.31	10			

Marking

Select Gases		Set Preflow		Set Cutflow		**Amperage**	Torch-to-Work Distance		Marking Speed		Arc Voltage
						Amps	mm	in	mm/m	ipm	Volts
N_2	N_2	10	10	10	10	**22**	2.5	0.10	1270	50	123
Ar	Air	20	10	30	10	**25**	3.0	0.12	1270	50	55

Consumable parts kits

Note: See *Consumable selection* or *Cut charts* in section 4 for specific applications

Mild steel parts kit – 228367

Part Number	Description	Qty.
026009	O-ring: 0.208” X 0.070”	5
027055	Lubricant: Silicone 1/4-oz tube	1
044028	O-ring: 1.364” X 0.070”	2
104119	Tool: Consumable removal / replacement	1
104269	Wrench: Spanner	1
220179	Swirl ring: 80 A/130 A	1
220180	Swirl ring: 30 A	1
220181	Electrode: 130 A	2
220182	Nozzle: 130 A	3
220183	Shield: 130 A	2
220187	Electrode: 80 A	2
220188	Nozzle: 130 A	2
220189	Shield: 80 A	1
220192	Electrode: 30 A	2
220193	Nozzle: 30 A	2
220194	Shield: 30 A	1
220340	Water tube with o-ring	1
220352	Electrode: 200 A	2
220353	Swirl ring: 200 A	1
220354	Nozzle: 200 A	3
220435	Electrode: 260 A	2
220436	Swirl ring: 260 A	1
220439	Nozzle: 260 A	3
220552	Electrode: 50 A	2
220553	Swirl ring: 50 A	1
220554	Nozzle: 50 A	2
220555	Shield: 50 A	1
220571	Water tube with o-ring (bevel)	1
220629	Electrode: 400 A	3
220631	Swirl ring: 400 A	1
220632	Nozzle: 400 A	3
220635	Nozzle retaining cap: 400 A	1
220636	Shield: 400 A	2
220637	Shield cap: 400 A	1
420566	SilverPlus Electrode: 80 A	1
220665	SilverPlus electrode: 130 A	1
220666	SilverPlus electrode: 200 A	1
220668	SilverPlus electrode: 260 A	1
420530	SilverPlus Electrode: 400 A	1
220747	Shield cap: 130 A	1
220754	Nozzle retaining cap: 30 A	1
220756	Nozzle retaining cap: 130 A	1
220757	Nozzle retaining cap: 200 A	1
220760	Nozzle retaining cap: 260 A	1
220761	Shield: 200 A	2
220764	Shield: 260 A	2