



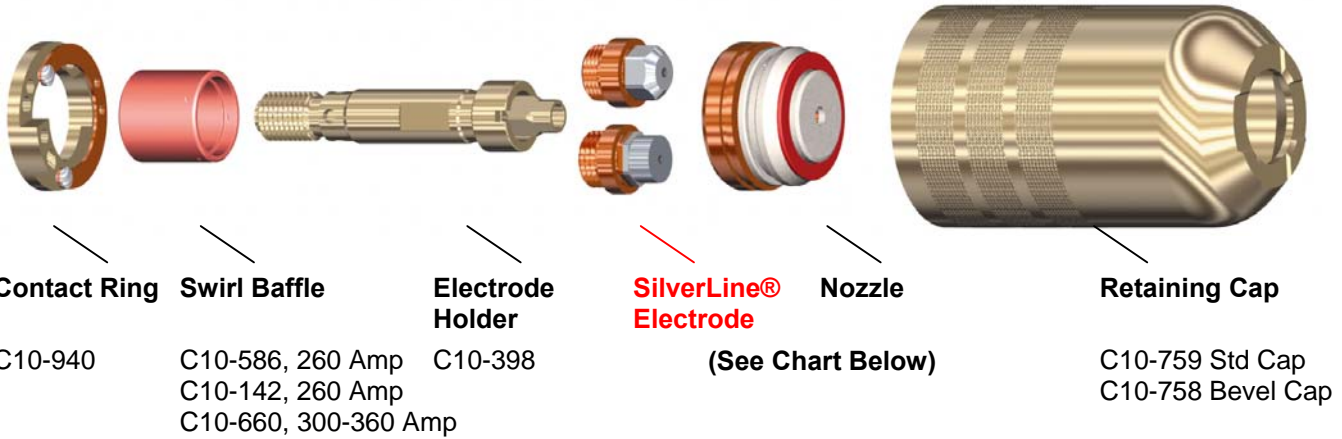
Part#C10-CutChart

# CUT CHART FOR PT-15XL SilverLine® Oxygen

## Electrode

Centricut #C10-1063, 260 Amp  
 Centricut #C10-1066, 300-360 Amp

Achieve up to **2X** the life of standard electrodes with **SilverLine® Technology**



## Oxygen Cutting Parameters Mild Steel

- Cut Water Flow should be set at 0.5 gpm or high 7.
- Torch stand off (tip to work piece) should be 3/8"-1/2" when piercing and 1/8"-1/4" when cutting.

| Electrode/<br>Part Number | Nozzle Orifice/<br>Part Number | Recommended<br>Current (Amps) | Cut Gas<br>Flow (CFM) | Plate<br>Thickness         | Arc Voltage<br>(Volts)                   | Cut Speed<br>(IPM)                  |
|---------------------------|--------------------------------|-------------------------------|-----------------------|----------------------------|--|-------------------------------------|
| <b>260 A / C10-1063</b>   | 0.099" / C10-751               | 200                           | 100                   | 1/8"                       | 120-125                                  | 175-200                             |
| <b>260 A / C10-1063</b>   | 0.099" / C10-751               | 260                           | 120<br>Low 6          | 1/4"<br>1/2"<br>3/4"<br>1" | 120-125<br>125-130<br>130-135<br>135-140 | 150-170<br>90-100<br>60-70<br>40-50 |
| <b>300 A / C10-1066</b>   | 0.116" / C10-962               | 300                           | 180<br>low 6          | 1/2"<br>3/4"<br>1"         | 130-135<br>135-140<br>140-145            | 135-145<br>75-85<br>50-60           |
| <b>340 A / C10-1066</b>   | 0.120" / C10-664               | 340-360                       | 120<br>high 1         | 3/4"<br>1"<br>1-1/4"       | 130-135<br>130-135<br>140                | 85-100<br>60-65<br>40-45            |
| <b>360 A / C10-1066</b>   | 0.120" / C10-664               | 340-360                       | 120<br>high 1         | 1-1/4"                     | 140                                      | 45-50                               |

The hafnium element in the electrode will wear to approximately twice the depth of the standard copper electrode. In most applications this will increase the life expectancy of nozzles and electrodes. The arc voltage may need to be increased by 5-10 volts throughout the electrode life to maintain proper cut height. This information represents expectations using recommended practices and well-maintained systems. Improper operating parameters or operation of equipment, or the presence of moisture in the plasma gas can dramatically affect the life of these products.

If you have additional questions please contact your customer service representative or our Technical Support Team at 1-800-752-7623 (8AM – 5PM EST).

Centricut is in no way affiliated with ESAB®, PT-15XL® is a registered trademark of ESAB®

1-800-752-7623 ■ 1-603-298-7849 ■ FAX 1-603-298-5938 ■ [www.centricut.com](http://www.centricut.com)

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## Troubleshooting Tips for PT-15XL SilverLine® Oxygen

If you do not achieve superior results with SilverLine® Technology – review your consumable parts against the trouble-shooting chart below or call Centricut’s Technical Support for assistance 8 AM to 5 PM EST at 1-800-752-7623.

### Probable Cause:

### Solution:



Moisture in the plasma gas will dramatically reduce Silverline® electrode life. Moisture creates pits and carbon buildup on the surface of the electrode. Worn, dry, cut, or cracked o-ring seals may be the cause.

Inspect o-rings seals in electrode holder, insulator body, torch body, etc. Lubricate, clean, or replace, o-rings as necessary. Replace electrode holder if necessary.



This electrode is only 1/2 used. The pit in the center of the part is approximately .060". It may burn another 100-200 starts before failure. Electrodes may be removed prematurely due to nozzle failure or low torch height.

The electrode should burn to approximately 0.120" before cut quality deterioration or failure. **You may need to increase arc voltage by 5-10 volts to maintain proper stand off.** Some operators use 2 nozzles to get full life from the electrode.



This electrode failed catastrophically due to low gas flow or no gas flow during arc initiation. This can happen when the nozzle “snuffs” against the plate during the pierce, or if the pre-flow gas is insufficient.

Check for proper operation of torch height control. Torch must clear the plate and pierce at 2X cut height. If material is warped, make sure the torch clears the plate before firing. Make sure pre-flow pressure is 25-28 psi.

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