

# PT-24 Precision Plasmarc® Oxygen Cutting Parameters 70-100A

### To achieve maximum SilverLine® Electrode life:

- A fully used electrode will have a pit depth of .090 in. (2.3 mm).
- As the electrode wears, the torch will get closer to the plate.  
To compensate for this, increase arc voltage in 2-volt increments up to 10 volts higher than the initial setting.
- Make sure the torch is purged for at least 30 seconds after each parts change to remove all moisture.
- Leak check the torch after purging to make sure all o-ring and metal-to-metal seals are working as designed.

### To achieve maximum nozzle life:

- Make sure the nozzle retainer is sealed tightly against the nozzle to maintain a metal-to-metal seal.
- Periodically check the nozzle retainer to make sure it remains tight.
- Clean the shield and nozzle periodically to remove slag buildup and prevent double arcing.
- PIERCE HIGH; CUT LOW: Cut height is set by adjusting arc voltage. Pierce height is a separate adjustment. Set the pierce height to at least 2X the cut height. This protects the nozzle from blowback during pierce.

### Recommended Parameters for Mild Steel Cutting With Oxygen.

Metal Thickness		Plasma Start	Plasma Cut	Shield Pre-flow	Shield Cut-flow	Arc Current	Arc Voltage	Cut Speed
In.	mm	Flow %	Flow %	Flow %	Flow %	A	V	in./min
.187	5	90	25	60	30	70	112	130
.250	6	90	25	60	30	70	113	100
.312	8	90	25	60	30	70	115	85
.375	10	90	25	60	30	70	117	72
.500	12	90	25	60	30	70	135	35
.625	16	90	25	60	30	70	137	25
.312	8	100	30	60	30	100	114	90
.375	10	100	30	60	30	100	115	80
.500	12	100	30	60	30	100	117	50
.625	16	100	28	60	30	100	118	30
.750	20	100	28	60	30	100	122	25



**PT-24 Torch**  
L70-530 21530

**Water Baffle**  
L70-725 21725

**SilverLine® Electrode**  
C70-1039 21539

**Swirl Baffle 4-hole**  
L70-692 21692

**Nozzle "E" 100A**  
C70-923 21923  
**Nozzle "D" 70A**  
C70-543 21543

**Nozzle Retainer Diffuser**  
L70-007 22007

**Shield cup insulator**  
L70-010 22010

**Shield retainer insulator w/ o-ring**  
L70-712 21712

**Cup Shield w/ Retainer**  
C70-531 22531

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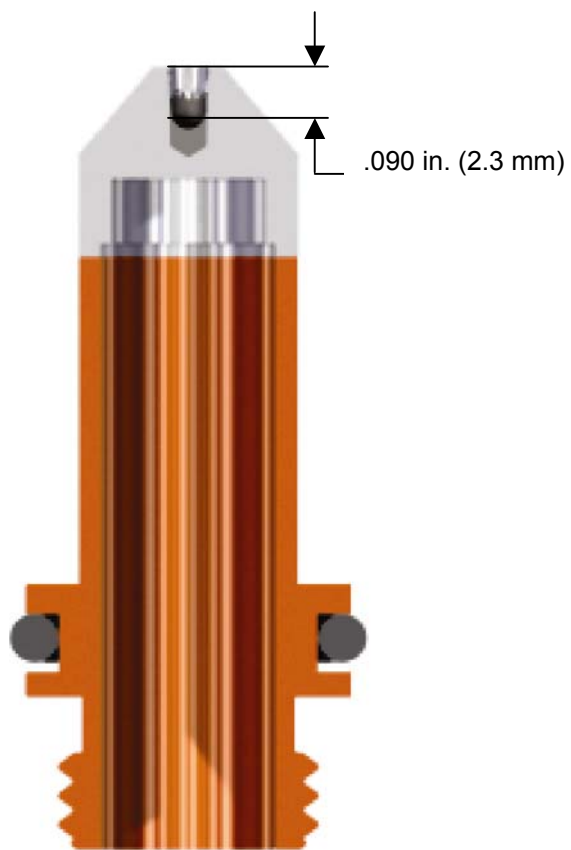
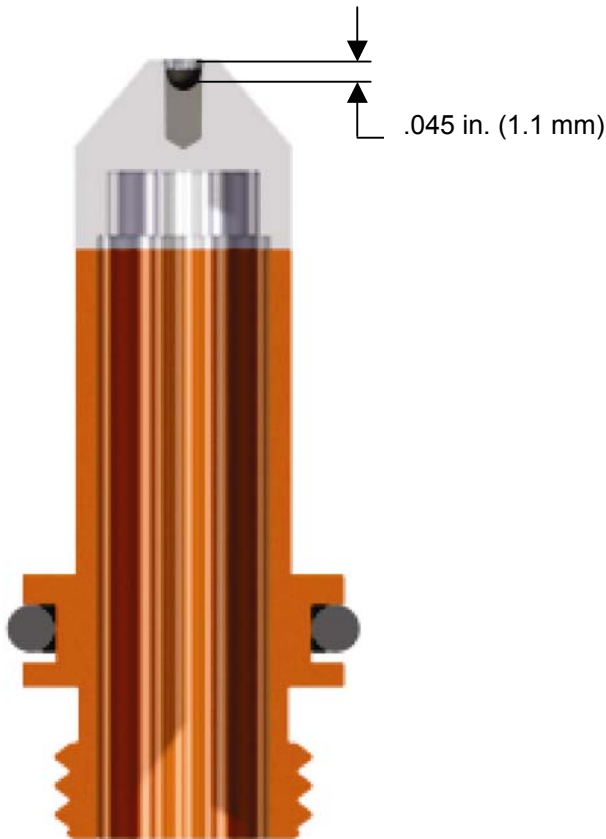
## Precision Plasmarc® PT-24 SilverLine® Oxygen Electrode Life

### Half Used Electrode

This SilverLine® electrode is only half consumed. The pit in the center of the part is .045 in. (1.1 mm). Electrodes are often removed prematurely due to cut quality deterioration related to nozzle failure. Additional life can be achieved by replacing the nozzle.

### Fully Used Electrode

This SilverLine® electrode has provided full use. The pit depth is .090 in. (2.3 mm). The operator increased the arc voltage by 10 volts from the first cuts made with this electrode to the last. This maintains a constant distance between the torch and the work-piece throughout the life of the electrode.



If you do not achieve **excellent results** using **SilverLine® technology** please call our Technical Support Team. Our engineers are available 8-5 EST to help you optimize your system.

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