Part#C96-CutChart

CUT CHART FOR PT-600 SilverLine® Oxygen

Electrode: Centricut #C96-1024, 250 Amp and Centricut #C96-1016, 360 Amp

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

Oxygen Cutting Parameters – Mild Steel
Results will vary based on gas selection, process parameters and operation of equipment. Please refer to your operating manual for safety precautions, process and set up parameters for arc voltage, stand off, start, cut and shield gas settings, or call Centricut's Technical Support toll free at 1-800-752-7623 8AM – 5PM EST for assistance.

Electrode/ Part Number	Nozzle Base/ Part Number	Nozzle Orifice/ Part Number	Recommended Current (Amps)	Plate Thickness	Cut Speed (IPM)
100-250 A / C96-1024	100-250 A / C47-028	.071 Tip / C47-029	100	1/4"	120
				3/8"	80
				1/2"	60
				5/8"	38
				3/4"	20
100-250 A / C96-1024	100-250 A / C47-028	.082 Tip / C47-030	150	1/4"	150
				3/8"	90
				1/2"	75
				5/8"	55
				3/4"	45
100-250 A / C96-1024	100-250 A / C47-028	.091 Tip / C47-031	200	1/4"	170
				3/8"	110
				1/2"	90
				5/8"	65
				3/4"	55
100-250 A / C96-1024	100-250 A / C47-028	.099 Tip / C47-922	250	1/4"	170
		or		3/8"	125
	N/A	One Piece Design		1/2"	115
		.099 Orifice/ C47-822		3/4"	65
				1"	50
300-360 A / C96-1016	N/A	One Piece Design	325	1/2"	125
		0.120/C47-885		3/4"	90
				1"	60
				1 1/4"	37
300-360 A / C96-1016	N/A	One Piece Design	360	1/2"	135
		0.120/C47-885		3/4"	100
				1"	65
				1 1/4"	45
				1 1/2"	32

Swirl Baffle
C10-142, 100-200 Amp
C10-660, 250-360 Amp

Electrode Holder
C96-621

SilverLine®
Electrode
(see cut chart)

Nozzle Base
C47-028, 100-250 Amp

Nozzle
(see cut chart)

Retaining Cap
L47-082
L47-431 (Air curtain)

Diffuser
C47-944, 100-360 Amp

Shield
C47-802, 100-250 Amp
C47-945, 300-260 Amp

Shield Retainer
L47-081

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-600® is a registered trademark of ESAB/L-Tec™

1-800-752-7623 ■ 1-603-298-7849 ■ FAX 1-603-298-5938 ■ www.centricut.com
Centricut, Two Technology Drive, West Lebanon, NH USA 03784

Troubleshooting Tips for PT-600 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:
Water-damaged electrode	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.
½-used electrode	This electrode is only ½ 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.
Low gas or no gas (Nozzle snuffing)	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.

The parts shown are for the PT-15XL. The PT-600 will exhibit the same failure mode

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