

## Upgrade to SilverLine® technology!

Patented SilverLine technology improves electrode and nozzle life so you can cut more metal with one set of consumables. To start saving with SilverLine just follow the instructions on our Quick Set-up card: the more you cut the more you save!

Centricut product for ESAB

# PT-19XL®

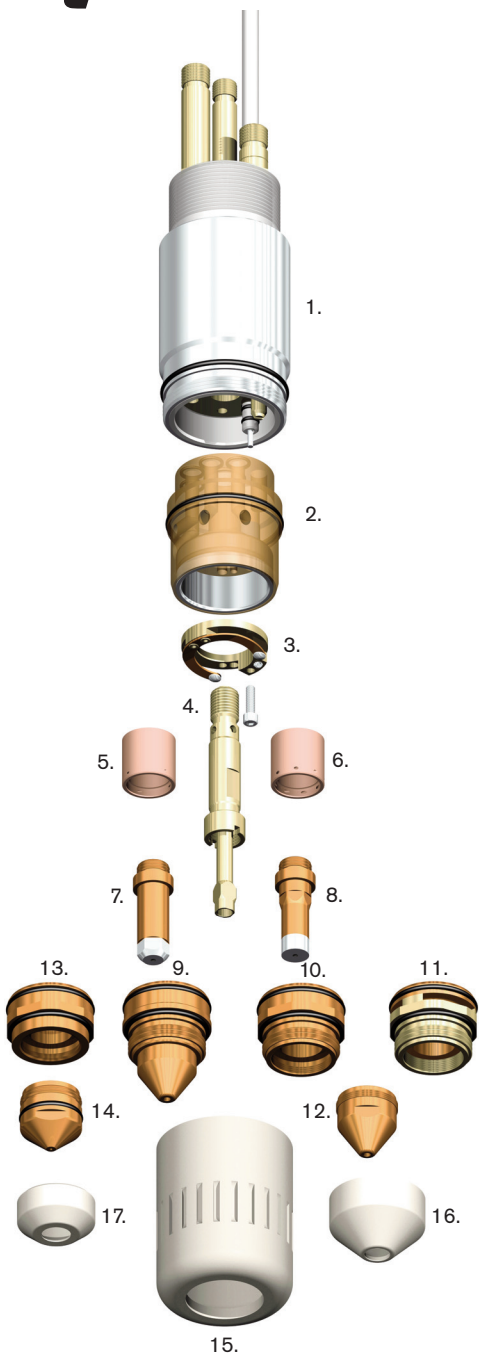
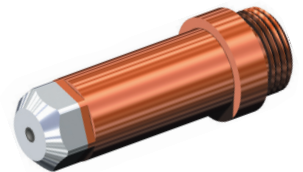
## Quick Set-up



### SilverLine electrodes on average last twice as long as standard electrodes.

The hafnium-silver bond is more effective than hafnium-copper in standard electrodes. This allows the SilverLine electrode to achieve a 33% deeper pit depth.

The robust copper-silver interface, combined with the hafnium-silver bond deliver consistent performance and lower the overall cost of cutting.



Part number	Reference	Description
1. C47-391	20391	PT-19XL torch body
C47-990	N/A	SilverLine®, torch assembly, 150 amp
C47-991	N/A	SilverLine®, torch assembly, 250 amp
C47-992	N/A	SilverLine®, torch assembly, 360 amp
2 C47-434	20434	Insulator body
3 C47-940	21940	Contact ring assembly
4 C47-084	34084	Electrode holder
5 C47-142	948142, 0558002533	Gas swirl baffle, 4 hole, std
L47-143	948143, 0558002534	Gas swirl baffle, 4 hole, rev
C47-586	2075586	Gas swirl baffle, 8 hole, std
6 C10-660	35660, 0558001625	Gas swirl baffle, 8 hole, std
7 C47-1096	34086	SilverLine®, electrode, 50 – 250 amp
8 C47-1086	35886	SilverLine®, electrode, 360 amp
L47-557	34557	Electrode, N <sub>2</sub> /ArH <sub>2</sub> , 150 – 360 amp
9 C47-822	21822, 0558001623	Nozzle, .099, 250 amp
C47-885	35885, 0558001885	Nozzle, .120, 360 amp
C47-195	22195, 0558001886	Nozzle, .130, 400 amp
10 C47-028	22028	Nozzle base, 100 – 360 amp
11 C47-928	N/A	Nozzle base, extended life, 100 – 400 amp
12 C47-029	22029	Nozzle tip, .071, 100 amp
C47-030	22030	Nozzle tip, .082, 150 amp
C47-031	22031	Nozzle tip, .091, 200 amp
C47-922	22032	Nozzle tip, 250 amp
C47-985	22034	Nozzle tip, 360 amp
C47-995	22033	Nozzle tip, 400 amp
13 C47-027	22027	Nozzle base, 50 amp
14 C47-026	22026	Nozzle tip, .041, 50 amp
C47-082	37082	Nozzle retaining cap
15 L47-085	34085	Nozzle retaining cap
L47-982	21982	Nozzle retainer cup
16 C47-186	948186	Heat shield, std, 100 – 360 amp
17 L47-885	34885	Heat shield, 50 amp
L47-506	19506	Heat shield, heavy duty, 100 – 360 amp

## Recommended parameters for mild steel cutting with oxygen

Thickness		Amps	Plasma start gas		Plasma cut gas		Arc voltage	Cut height		Initial height		Speed	
in.	mm	A	psi	bar	psi	bar	V	in.	mm	in.	mm	in/min	mm/min
1/4	6	100	25	1.7	45	3.1	133	.375	10	.500	13	120	3048
3/8	10		25	1.7	45	3.1	149	.375	10	.500	13	80	2032
1/2	13		25	1.7	45	3.1	140	.375	10	.500	13	60	1397
3/8	10	150	25	1.7	45	3.1	134	.375	10	.500	13	90	2286
1/2	13		25	1.7	45	3.1	140	.375	10	.500	13	75	1905
5/8	16		25	1.7	45	3.1	151	.375	10	.500	13	55	1397
1/2	13	200	25	1.7	45	3.1	129	.375	10	.500	13	95	2435
5/8	16		25	1.7	45	3.1	139	.375	10	.500	13	75	1905
3/4	19		25	1.7	45	3.1	142	.375	10	.500	13	55	1397
1/2	13	250	25	1.7	45	3.1	135	.375	10	.500	13	115	2921
3/4	19		25	1.7	45	3.1	142	.375	10	.500	13	90	2286
1	25		25	1.7	45	3.1	150	.375	10	.500	13	65	1651

### Achieve maximum consumable life

**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 cap:** Make sure the nozzle retainer 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.

**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.

**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.

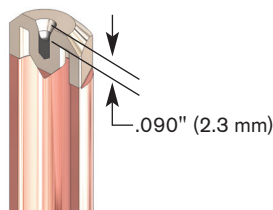
**Avoid arc stretching:** This can occur during rip cutting off the plate or when the lead out is improperly programmed. This shortens consumable life.

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

**Contact your Hypertherm distributor or call 1-800-752-7623 for the location nearest to you.**

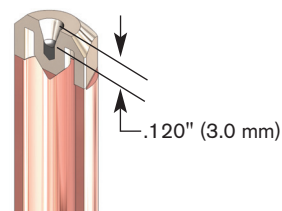
#### Partially-used electrode

This SilverLine electrode is only partially consumed. The pit in the center of the part measures .090" (2.3 mm). Electrodes are often removed prematurely due to cut quality deterioration related to nozzle failure. Additional life can be achieved by replacing the nozzle and leaving the electrode in place.



#### Fully-used electrode

This SilverLine electrode has provided full use. The pit depth is .120" (3.0 mm). The operator increased the arc voltage in 5-volt increments, up to 20 volts from the first cuts made with this electrode to the last. This maintains a constant distance between the torch and the work-piece through the life of the electrode.



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