

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-15XL®

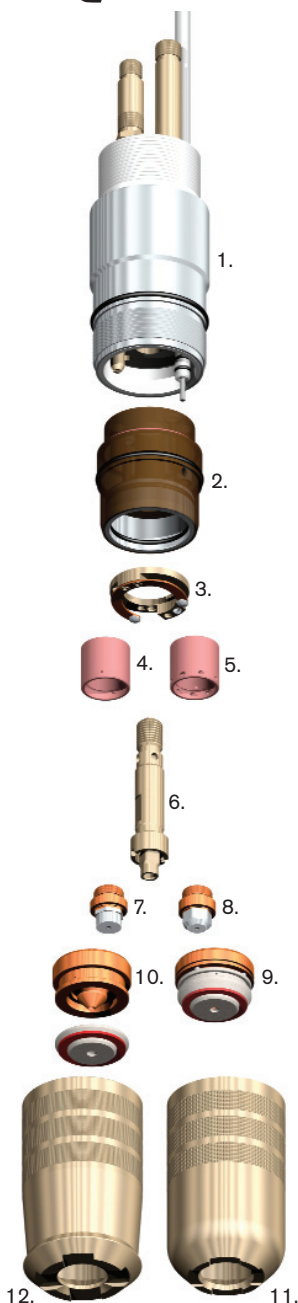
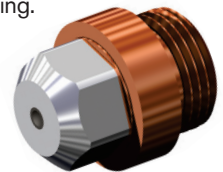


Quick Set-up

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. C10-754	20754	Torch body, PT-15XL
2. C10-755	20755	Insulator body with o-ring, PT-15XL
3. C10-940	21940	Contact ring assembly
4. C10-142	948142	Gas swirl baffle, ceramic, 4 X .032"
5. C10-586	2075586	Gas swirl baffle, ceramic, 8 X .067"
6. C10-660	35660, 0558001625	Gas swirl baffle, ceramic, 8 X .047"
7. C10-398	20398	Electrode holder, O ₂
8. C47-084	34084	Electrode holder (beveling)
9. C47-1096	34086	SilverLine electrode, 50/250 amp (beveling)
10. C10-1066	35666	SilverLine electrode, 300/340 amp (beveling)
11. C10-1063	20763	SilverLine electrode, 260 amp
12. C10-751	20751	Nozzle, O ₂ , 260 amp
13. C10-662	35662	Nozzle, O ₂ , 300 amp (2 piece)
14. C10-962	35662	Nozzle, O ₂ , 300 amp
15. C10-664	35664	Nozzle, O ₂ , 340/360 amp
16. C10-665	35665	Nozzle, O ₂ , 340/360 amp, reverse
17. C10-920	20920	Nozzle, O ₂ , 260 amp, reverse
18. C10-317	37317	Nozzle, 125 amp (2 piece)
19. C10-262	21962	Nozzle, 300 amp (beveling)
20. C10-063	21963	Nozzle, 300 amp (reverse beveling)
21. C10-758	20758	Nozzle retaining cap
22. C10-759	20759	Nozzle retaining cap
23. L10-570	35570	Nozzle retaining cap (beveling)
24. C10-954	16365	SilverLine, torch assembly, 260 amp
25. C10-955	16365	SilverLine, torch assembly, 300 amp
26. C10-NIT	N/A	Torch assembly, N ₂ , 400 amp
27. C10-483	19483, 0558001626	Double threaded mounting tube
28. L10-630	999630	Nozzle/electrode stem tool

Recommended parameters for mild steel cutting with oxygen

Thickness		Amps A	Plasma start gas		Plasma cut gas		Start water		Cut water		Arc voltage V	Initial height		Speed		Pierce delay sec
in.	mm		psi	bar	psi	bar	psi	bar	psi	bar		in.	mm	in/min	mm/min	
1/4	6	90	25	1.7	64	4.4	28	1.9	33	2.2	117	0.156	4	110	2794	0.5
1/4	6	125	25	1.7	64	4.4	28	1.9	37	2.5	110	0.156	4	130	3302	0.5
1/2	13		25	1.7	64	4.4	28	1.9	37	2.5	130	0.156	4	46	1168	0.5
1/4	6	260	25	1.7	42	2.9	83	5.7	83	5.7	118	0.250	6	170	4318	0.5
3/8	10		25	1.7	42	2.9	83	5.7	83	5.7	128	0.250	6	130	3302	0.5
1/2	13		25	1.7	42	2.9	83	5.7	83	5.7	130	0.313	8	95	2413	0.5
5/8	16		25	1.7	42	2.9	83	5.7	83	5.7	135	0.313	8	75	1905	0.5
3/4	19		25	1.7	42	2.9	83	5.7	83	5.7	143	0.375	10	65	1651	0.5
1	25		25	1.7	42	2.9	83	5.7	83	5.7	155	0.375	10	45	1143	1
1/4	6	300	25	1.7	45	3.1	64	4.4	68	4.7	125	0.250	6	250	6350	0.5
3/8	10		25	1.7	45	3.1	64	4.4	68	4.7	137	0.250	6	155	3937	0.5
1/2	13		25	1.7	45	3.1	64	4.4	68	4.7	135	0.313	8	130	3302	0.5
5/8	16		25	1.7	45	3.1	64	4.4	68	4.7	145	0.313	8	85	2159	0.5
3/4	19		25	1.7	45	3.1	64	4.4	68	4.7	150	0.375	10	75	1905	0.5
1	25		25	1.7	45	3.1	64	4.4	68	4.7	150	0.375	10	55	1397	0.5
3/4	19	340	25	1.7	48	3.3	64	4.4	68	4.7	131	0.375	10	95	2413	0.5
1	25		25	1.7	48	3.3	64	4.4	68	4.7	145	0.375	10	63	1600	1.5
1-1/4	32		25	1.7	48	3.3	64	4.4	68	4.7	138	0.500	13	42	1066	2
1-1/4	32	360	25	1.7	48	3.3	64	4.4	68	4.7	144	0.500	13	48	1219	2
1-1/2	38		25	1.7	48	3.3	64	4.4	68	4.7	153	0.500	13	36	914	2

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 working 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.

Adjust injection water pressure: Refer to the cut chart for optimum injection water pressure. Having the correct injection water flow provides protection to the nozzle and ceramic.

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.

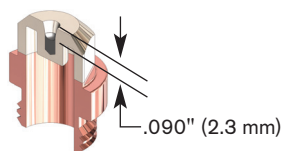
Clean the nozzle and ceramic:

Periodically clean the nozzle and ceramic 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.

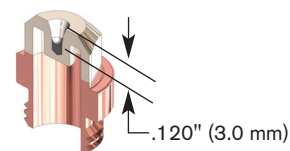
Partially-used electrode

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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