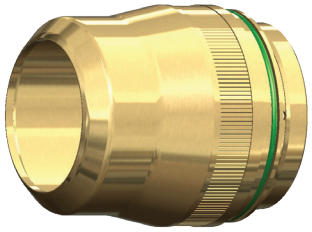
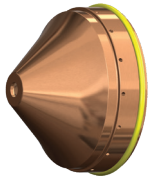
BEVEL
130A MILD STEEL

O_2 PLASMA
AIR SHIELD

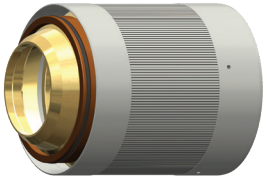
Plasma gas inlet:
120psi/8.4bar
Shield gas inlet:
120psi/8.4bar



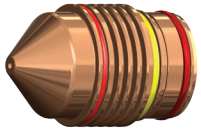
Shield Cap
97-0200



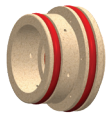
Shield
97-0255



Nozzle Retaining Cap
97-1365



Nozzle
97-0252



Swirl Ring
90-0179

Electrode
97-0249

Water Tube
90-0700

Note: Bevel angle range is 0° to 45°

ENGLISH

Thickness	Preflow		Cutflow		Minimum Clearance	Torch-to-Work	Cutting Speed	Initial Pierce Height		Pierce Delay
Inches	O_2 Plasma	Air Shield	O_2 Plasma	Air Shield	Inches	Inches	Inches/Minute	In	Factor	Sec
0.135	15	23	84	21	0.08	0.10 - 0.34	240	0.20	200	0.1
3/16						0.11 - 0.34	190	0.22		0.2
1/4							150			0.3
5/16				15		0.12 - 0.34	132	0.24		
3/8							110			
1/2						0.13 - 0.34	80	0.26		0.5
5/8						0.15 - 0.34	60	0.30		0.7
3/4							45			1.0
1						0.16 - 0.34	20		190	1.8
1-1/4Δ		33				0.18 - 0.34	15	0.40	220	4.0
1-1/2							10	Edge start		

Δ Suggestions for piercing 1-1/4 in (32mm) mild steel:

1. *Turn preflow on during IHS*
2. *Use ohmic contact during IHS*
3. *Use pierce complete when piercing*

CUT CHARTS

PHDX™

METRIC

Thickness	Preflow		Cutflow		Minimum Clearance	Torch-to-Work	Cutting Speed	Initial Pierce Height		Pierce Delay
mm	O_2 Plasma	Air Shield	O_2 Plasma	Air Shield	mm	mm	mm/Minute	mm	Factor	Sec
3	15	23	84	21	2.0	2.5 - 8.6	6505	5.0	200	0.1
4						2.8 - 8.6	5550	5.6		0.2
5							4795			0.3
6							4035			
8				15		3.0 - 8.6	3360	6.0		
10							2680			
12						3.3 - 8.6	2200	6.6		0.5
15						3.8 - 8.6	1665	7.6		0.7
20							1050			1.0
25						4.0 - 8.6	550		190	1.8
32Δ		33				4.5 - 8.6	375	10.2	220	4.0
38							255	Edge start		

MARKING

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work		Marking Speed		Arc Voltage
						Amps	mm	Inches	mm/Minute	Inches/Minutes	Volts
N_2	N_2	10	10	10	10	15	2.5	0.10	6350	250	130
Air	Air	50	10	50	10	15	3.0	0.12	2540	100	75

Δ Suggestions for piercing 32mm (1-1/4 in) mild steel:

1. *Turn preflow on during IHS*
2. *Use ohmic contact during IHS*
3. *Use pierce complete when piercing*

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