

CUT CHARTS



For Lincoln® (Kaliburn®) Systems

200A MILD STEEL - O2 PLASMA / AIR SHIELD

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















Shield Cap 97-0200

Shield 97-0513

Nozzle Retaining Cap 97-1365

Nozzle 97-0261

Swirl Ring 90-0405

<u>Electrode</u> 97-0258

Water Tube 90-0700

Pierce Time

(msec) 300

400

500

600

800

1000

1500

H	Material Thickness	Preflow (psi)	Plasma (psi)	Shield (psi)	Postflow (psi)	Arc Voltage	Travel Speed (ipm)	Cutting Height	Pierce Height
S	1/4		74	58	72	135	230	.040	.200
	3/8					140	140	.090	.250
_ i_i	1/2	20				143	120	.115	.300
	5/8					147	100	.130	.350
	3/4					150	75	.150	.400
	1					157	50	.175	.450
	1-1/4					165	25	.240	.500
ш	1-1/2					175	17	.300	.350
	1-3/4					185	12	.350	
	2					195	7	.500	.500

† American Torch Tip Company is in no way affiliated with the above-named manufacturer(s). References to the above-named machines, torches and numbers are for your convenience only. American Torch Tip is not necessarily authorized by the above-named manufacturer(s) to provide replacement parts. Most parts advertised for sale are made by, or for, American Torch Tip Company and other parts, as indicated, are original parts manufactured by the above-named OEM and are simply being resold by American Torch Tip Company. Part numbers followed by an * are manufactured by the respective OEM.

For Lincoln® (Kaliburn®) Systems #90-200-L #90-200-R

Kerf Width

0.090

0.094

0.100

0.107

0.116

0.135 0.160 0.189

0.222