

For Lincoln® (Kaliburn®) Systems

400A MILD STEEL - O₂ PLASMA / AIR SHIELD

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



Shield Cap
97-0200



Shield
97-4002



Nozzle Retaining Cap
97-0365



Nozzle
90-0632



Swirl Ring
220631*



Electrode
90-0530



Water Tube
90-0571

ENGLISH

Material Thickness	Preflow (psi)	Plasma (psi)	Shield (psi)	Postflow (psi)	Arc Voltage	Travel Speed (ipm)	Cutting Height	Pierce Height	Pierce Time (msec)	Kerf Width
1/2	30	79	70	76	140	160	.140	.300	500	0.138
5/8					143	135	.130	.350	600	0.141
3/4					145	110	.160	.400	800	0.145
1					148	85	.175	.500	1000	0.153
1-1/4					151	60	.225	.600	1500	0.162
1-1/2					153	50	.260	.700	2000	0.174
1-3/4					157	40	.270	.800	3000	0.186
2					160	33	.280	1.00	4500	0.201
2-1/4*					168	20	.300	.350	1000	0.217
2-1/2*					171	15	.325	.350	1300	0.234
2-3/4*					175	12	.350	.350	1500	0.253
3*					193	8	.350	.350	2000	0.273

* = Edge start required.

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For Lincoln®
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#90-400-L
#90-400-R