

## 30A MILD STEEL - O<sub>2</sub> PLASMA / AIR SHIELD

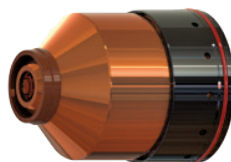
Plasma gas inlet:  
120psi/8.4bar  
Shield gas inlet:  
120PSI/8.4bar



**Shield Cap**  
90-0747



**Shield**  
60-0194



**Retaining Cap**  
90-0754



**Nozzle**  
60-0193



**Swirl Ring**  
90-0180



**Electrode**  
60-0192



**Water Tube**  
90-0340

ENGLISH

Thickness	Preflow		Cutflow		Arc Voltage	Torch-to-Work	Cutting Speed	Initial Pierce Height		Pierce Delay
Inches	O2 Plasma	O2Shield	O2 Plasma	O2 Shield	AV	Inches	Inches/Minute	In	Factor	Sec
0.018	78	17	94	17	114	0.05	215	0.09	180	0.1
0.024					200		0.2			
0.030					170					
0.036					155		0.3			
0.048					110					
0.060					85					
0.075		35		7	120	1.06	60	0.11		0.4
0.105					122		50			
0.135*		75			123		40			
3/16*					128		30			0.7
1/4*							25			1.0

† 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.

90-7956

METRIC

Thickness	Preflow		Cutflow		Arc Voltage	Torch-to-Work	Cutting Speed	Initial Pierce Height		Pierce Delay
mm	O2 Plasma	O2Shield	O2 Plasma	O2 Shield	AV	mm	mm/Minute	mm	Factor	Sec
0.5	78	17	94	17	114	1.3	5355	0.09	180	0.1
0.8					4225		0.2			
1					3615		0.3			
1.2					2865					
1.5					2210					
2		35		7	120	1.5	1490	2.7		0.4
2.5					122		1325			
3*		75			123		1160			0.5
4*					125		905			0.7
6*					128		665			1.0

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