



Consumables for ESAB mechanized systems with PT-36 (m3 system) and PT-36(R) torches



Upgrade to Centricut performance consumables to lower operating costs without sacrificing cut quality and productivity.

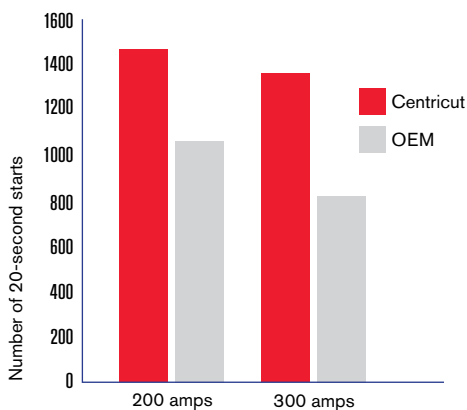
Lower costs

- Centricut consumables last up to twice as long as the OEM.
- Cut consumables usage in half and reduce system downtime.
- Full line of consumables are competitively priced compared to the OEM.

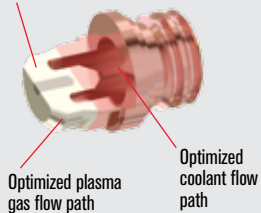
Cut with confidence – it's Hypertherm

- As the recognized global leader in plasma cutting, Hypertherm incorporates the latest engineered and patented technologies into all consumable products.
- Designed with critical-to-function tolerances to deliver the best quality product every time.
- Precision manufacturing of consumables assures consistency of parts set to set.
- World-class plasma-process technical support.
- Easy to use – no special system set up required.
- SilverLine® electrodes and CoolFlow™ nozzles deliver exceptional cut quality and fast cutting speeds over the full life of the consumables.

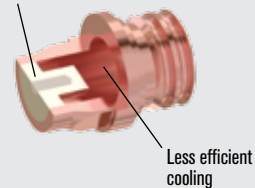
Consumable life



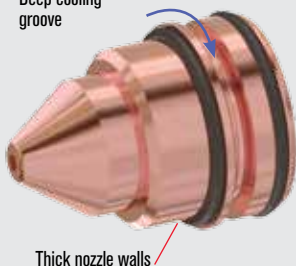
SilverLine electrode
Solid silver front-end



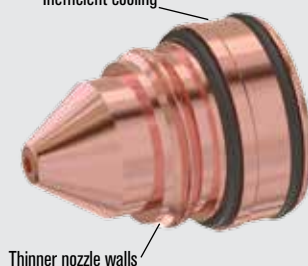
ESAB electrode
Silver insert



CoolFlow nozzle
Deep cooling groove



ESAB nozzle
Inefficient cooling



SilverLine electrode technology

- A solid silver front end maximizes cooling and minimizes hafnium wear.
- Flow ridges improve starting performance and extend life.
- Advanced coolant flow design reduces the temperature of the electrode and maximizes life.
- Robust welded copper/silver interface delivers consistent performance.

CoolFlow nozzle technology

- Computer-designed contours optimize the coolant flow in the nozzle and substantially lower the operating temperature.
- Thicker nozzle walls dissipate heat away from the orifice more efficiently, leading to cooler operation.
- Cooler nozzle operation directly translates into longer life of all consumables.

The Centricut replacement torch for PT-36 uses Hypertherm innovation and reliability.

- A robust torch body that features a unique threaded and glued sleeve-to-shell design
- Improved long-term alignment of torch components
- Reduced risk of leaking
- Extended overall torch service life
- Fully compatible with Centricut and OEM consumables
- Competitively priced



“The cut quality is better than what we get with the OEM and the parts last a lot longer.”

- Construction Machinery Manufacturer



To achieve maximum consumable life

Use electrode to full life: A fully used SilverLine electrode will have a pit depth of 3,0 mm. This is deeper than the recommended pit depth for standard parts of 2,3 mm.

Properly tighten the nozzle retaining cup: Make sure the retaining cup 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 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 shield gas pressure: Refer to the cut chart for optimum shield gas pressure. Having the correct start shield flow provides protection to the nozzle and shield during the piercing process.

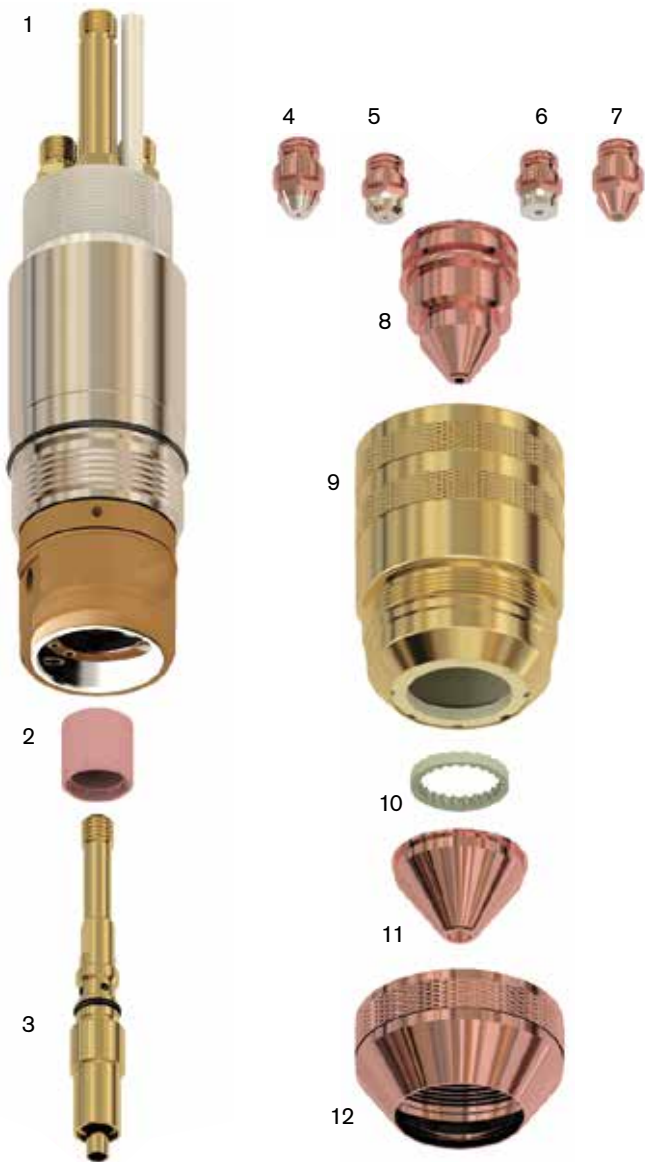
Pierce at correct height: Refer to the cut chart for optimum pierce (initial) height. Piercing too low causes molten metal (spatter) to hit the shield and nozzle – the most common cause of premature nozzle failure. Piercing too high can cause misfires and nozzle damage.

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 shield: Periodically clean the nozzle and shield to remove spatter. This will prevent double arcing which shortens consumable life.

Centricut consumables deliver value to your plasma cutting process through long life and exceptional quality.



Parts list

	Centricut number	Reference number	Description
1	C122-804	0558003804	Torch body
	C10-483	0558001626	Torch sleeve
	C47-071	0558003858	Contact ring
	C47-073	37073	Screw, contact ring
	C122-457	0558005457	Gas swirl baffle, 4X.022, 35-70 A
2	C122-533	0558002533	Gas swirl baffle, 4X.032, 100-280 A
	C10-660	0558001625	Gas swirl baffle, 8X.047, 300-600 A
	C122-530R	0558002530R	Gas swirl baffle, 8X.047, Rev, 360-450 A
3	C122-924	0558003924	Electrode holder
	C122-1059	0558005459, 0558003914	SilverLine® electrode, O ₂ , 45-130 A
6	C122-1091	0558007791, 0558003914	SilverLine electrode, O ₂ , 200-450 A
	C122-1014	0558003914	SilverLine electrode, O ₂ , 200-300 A LongLife®
5	C122-928	0558003928	Electrode, SS/Al, 600 A
8	C122-908	0558006908	CoolFlow™ nozzle, .08 mm, 35 A
	C122-8010	0558008010	CoolFlow nozzle, 1.0 mm, PR, 45-55 A
	C122-6010	0558006010	CoolFlow nozzle, 1.0 mm, 50 A
	C122-014	0558006014	CoolFlow nozzle, 1.4 mm, 100 A
	C122-018	0558006018	CoolFlow nozzle, 1.8 mm, 130 A
	C122-020	0558006020	CoolFlow nozzle, 2.0 mm, 200 A
	C122-023	0558006023	CoolFlow nozzle, 2.3 mm, 280 A
	C122-025	0558006025	CoolFlow nozzle, 2.5 mm, 300 A
	C122-030	0558006030	CoolFlow nozzle, 3.0 mm, 360 A
	C122-036	0558006036	CoolFlow nozzle, 3.6 mm, 450 A
	C122-041	0558006041	CoolFlow nozzle, 4.1 mm, 600 A
	9	C47-082	37082
10	C47-944	21944	Diffuser
	L47-796	21796	Diffuser, 50 A
11	C122-624	0558007624	Shield, 2.4 mm, 45-55 A
	C122-130	0558006130	Shield, 3.0 mm, 35-50 A
	C122-141	0558006141	Shield, 4.1 mm, 70-280 A
	C122-166	0558006166	Shield, 6.6 mm, 290-450 A
	C122-199	0558006199	Shield, 9.9 mm, 360-600 A
12	C47-081	37081	Shield retainer
	L122-616	0558004616	Shield retainer, insulated

Contact Hypertherm to locate a distributor near you.

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One of Hypertherm's long-standing core values is a focus on minimizing our impact on the environment. Doing so is critical to our, and our customers' success. We are always striving to become better environmental stewards; it is a process we care deeply about.

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