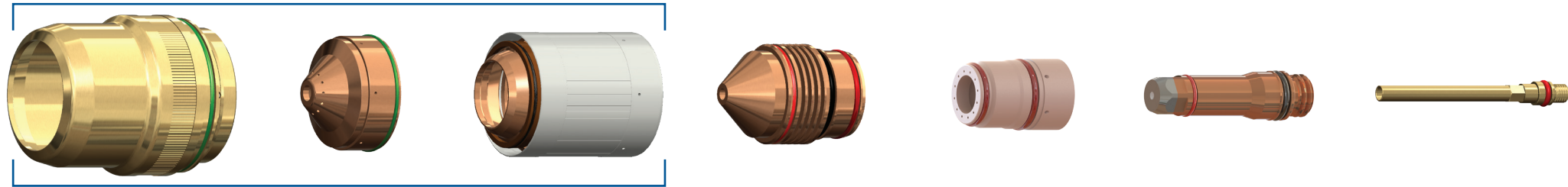


# 400A MILD STEEL - O<sub>2</sub> PLASMA / AIR SHIELD

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



**Shield Cap** 90-4000      **Shield** 90-4002      **Nozzle Retaining Cap** 90-4001      **Nozzle** 90-0632      **Swirl Ring** 220631\*      **Electrode** 90-0530      **Water Tube** 90-0571

† Shield Cap, Shield and Nozzle Retaining Cap must be used in combination for proper operation.

ENGLISH

Thickness	Prewflow		Cutflow		Arc Voltage	Torch-to-Work	Cutting Speed	Initial Pierce Height	Factor	Pierce Delay
	O2 Plasma	Air Shield	O2 Plasma	Air Shield						
1/2	24	50	60	50	140	0.14	170	0.28	200	0.4
5/8					143		150			0.5
3/4					145		115			0.6
7/8					148	100	0.8			
1					151	85	0.9			
1-1/4					153	65	1.2			
1-1/2					157	0.18	48	250	1.6	
1-3/4					160		40		2.5	
2					168	0.21	30	360	5.5	
2-1/4					171	0.25	25		Edge Start Recommended	
2-1/2					175		20			
3					193	0.31	10			

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**METRIC**

Thickness	Prewlow		Cutflow		Arc Voltage	Torch-to-Work	Cutting Speed	Initial Pierce Height	Factor	Pierce Delay
mm	O2 Plasma	Air Shield	O2 Plasma	Air Shield	AV	mm	mm/Minute	mm	%	Sec
12	24	50	60	50	139	3.6	4430	7.2	200	0.4
15					142		3950			0.5
20					146		2805			0.7
22					148	2540	7.6	0.8		
25					150	2210	8.0	0.9		
30					153	1790	9.2	1.1		
40					158	1160	11.5	250		1.9
50					167	795	19.1	360		5.2
60					173	580	Edge Start Recommended			
70					183	380				
80	197	180								

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