

## 130A MILD STEEL BEVEL O<sub>2</sub> PLASMA AIR SHIELD

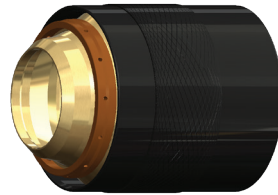
Plasma gas inlet:  
120psi/8.4bar  
Shield gas inlet:  
120psi/8.4bar



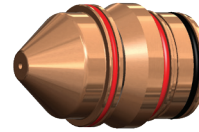
**Shield Cap**  
90-0637



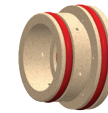
**Shield**  
90-0742



**Nozzle Retaining Cap**  
\*220740



**Nozzle**  
90-0646



**Swirl Ring**  
90-0179



**Electrode**  
90-0649



**Water Tube**  
90-0700

Note: Bevel angle range is 0° to 45°

ENGLISH

Thickness	Prewlow		Cutflow		Minimum Clearance	Torch-to-Work	Cutting Speed	Initial Pierce Height		Pierce Delay		
	O <sub>2</sub> Plasma	Air Shield	O <sub>2</sub> Plasma	Air Shield				Inches	Inches/Minute		In	Factor
0.135	15	23	84	21	0.08	0.10 - 0.34	240	0.20	200	0.1		
3/16						0.11 - 0.34	190				0.22	0.2
1/4						150						
5/16						0.12 - 0.34	132	0.24		0.3		
3/8						110						
1/2						0.13 - 0.34	80	0.26		0.5		
5/8						0.15 - 0.34	60					
3/4						45	0.30	1.0				
1						0.16 - 0.34				20	190	1.8
1-1/4 <sup>Δ</sup>						0.18 - 0.34	15	0.40		220		
1-1/2	33	10	Edge start									

Δ Suggestions for piercing 1-1/4 in (32mm) mild steel:

1. Turn preflow on during IHS
2. Use ohmic contact during IHS
3. Use pierce complete when piercing

† 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.

90-7910

METRIC

Thickness mm	Prewlow		Cutflow		Minimum Clearance mm	Torch-to-Work mm	Cutting Speed mm/Minute	Initial Pierce Height		Pierce Delay Sec	
	O <sub>2</sub> Plasma	Air Shield	O <sub>2</sub> Plasma	Air Shield				mm	Factor		
3	15	23	84	21	2.0	2.5 - 8.6	6505	5.0	200	0.1	
4						5550	5.6			0.2	
5						2.8 - 8.6		4795		0.3	
6							4035				
8						3.0 - 8.6	3360				
10							2680				
12				3.3 - 8.6		2200	6.6	0.5			
15						3.8 - 8.6		1665			
20				1050			7.6	0.7			
25				4.0 - 8.6		550		190		1.0	
32 <sup>Δ</sup>				33		4.5 - 8.6	375			10.2	220
38							255	4.0			Edge start

MARKING

Select Gases		Set Prewlow		Set Cutflow		Amperage	Torch-to-Work		Marking Speed		Arc Voltage
						Amps	mm	Inches	mm/Minute	Inches/Minutes	Volts
N <sub>2</sub>	N <sub>2</sub>	10	10	10	10	15	2.5	0.10	6350	250	130
Air	Air	50	10	50	10	15	3.0	0.12	2540	100	75

**Δ Suggestions for piercing 32mm (1-1/4 in) mild steel:**

1. Turn preflow on during IHS
2. Use ohmic contact during IHS
3. Use pierce complete when piercing

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