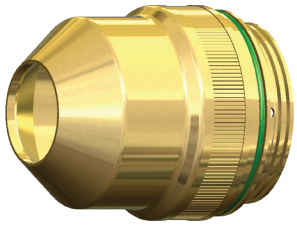


For Lincoln® (Kaliburn®) Systems

## 50A 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**  
90-0555



**Nozzle Retaining Cap**  
90-0754



**Nozzle**  
90-0554



**Swirl Ring**  
90-0553



**Electrode**  
90-0552



**Water Tube**  
90-0340

ENGLISH

Material Thickness		Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width	
ga	in	psi	psi	psi	psi	volts	ipm	in	in	msec	in	
14	.075	25	74	19	72	115	200	.100	.135	100	0.050	
12	.105					118	190					
	.125					118	180					
10	.135					120	170	.110		200		
	3/16					121	105	.140		300		0.053
	1/4					125	75	.225		400		0.060

† 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.

For Lincoln®  
(Kaliburn®) Systems  
#90-50-L  
#90-50-R

For Lincoln® (Kaliburn®) Systems

**METRIC**

Thickness mm	Prewlow		Cutflow		Arc Voltage AV	Torch-to-Work mm	Cutting Speed mm/Minute	Initial Pierce Height mm		Pierce Delay Sec	
	O2 Plasma	Air Shield	O2 Plasma	Air Shield				mm	Factor	Sec	
0.8	70	30	81	14	110	1.0	6500	2.0	200	0	
1					111		5000				
1.2					112		4150				
1.5					114	1.3	3200	2.6			
2					115		2700				
2.5					117		2200				
3					119	1.5	1800	3.0			0.1
4					121		1400				0.2
5					122		1200				0.3
6					126	2	950	4.0			0.4
7					128		780				0.5
8					130		630				

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#90-50-L  
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