



Consumables for Kjellberg® HiFocus systems with PerCut 210M and PerCut 450M torches



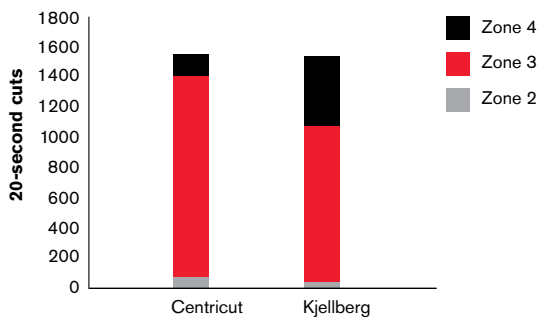
Centricut consumables for the Kjellberg PerCut 210M and PerCut 450M deliver long life, fast cutting speeds and excellent cut quality.

Lower costs

- Centricut consumables provide equal performance to Kjellberg consumables, but at a competitive price.
- At 280 amps, Centricut consumables deliver better cut quality through the life of the consumables compared to Kjellberg.
- Even with a rebate, the Kjellberg solid-silver electrode is no match to the value of the Centricut SilverLine electrode.
- Local stocking and fast delivery reduce your inventory costs.

Consumable life with ISO 9013.2002(E) cut quality ranges noted

280 A cutting of 19 mm mild steel

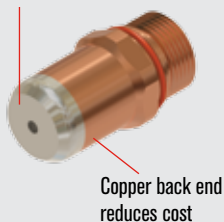


Easy to use

- No special system set up required.
- Centricut consumables fit all versions of the PerCut 210M and PerCut 450M torches.
- Centricut offers consumables for Kjellberg's Contour Cut™ cutting processes.

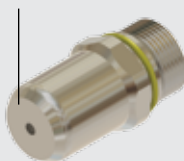
SilverLine electrode

Solid silver front end delivers performance



Kjellberg electrode

Solid silver electrode increases cost

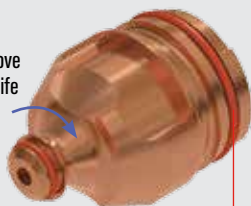


SilverLine® electrode technology

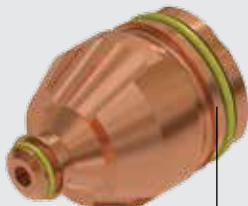
- Robust solid-state copper/silver weld joint insures electrical and thermal conductivity equal to a solid silver electrode at a fraction of the cost.
- Solid silver front end maximizes hafnium pit depth and slows hafnium wear rate.
- Advanced cooling features reduce the operating temperature of the electrode to maximize life.

CoolFlow nozzle

Optimized cooling groove maximizes life



Kjellberg nozzle



CoolFlow® nozzle technology

- Improved cooling maintains the size and shape of the orifice for maximum life.
- Computer-designed contours optimize the coolant flow around the nozzle and substantially lower the operating temperature.
- Nozzle walls and o-ring placement are designed to maximize cooling and extend life.
- Single keying feature allows the Centricut nozzle to be used in all PerCut 210M and 450M torch designs.

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.



To achieve maximum consumable life

A fully used SilverLine electrode will have a pit depth of 2.5 mm (.100").

Properly tighten the nozzle cap: Make sure the nozzle cap is sealed tightly against the nozzle to maintain a proper seal and prevent leaking.

Inspect gas guide: Check the gas guide to ensure the o-ring is free from cuts and nicks and that there are no chips or missing pieces inside the gas guide.

Purge torch and leak check: After each parts change purge the torch for at least 30 seconds to remove residual moisture. Check for leaks.

Adjust gas flows: Plasma gas flow rate is critical. High flow will cause rapid electrode wear and hard starting. Low flow will cause uncontrolled arcing. (See cutting tables in your owner's manual.)

Pierce at correct height: Piercing too low causes molten metal (spatter) to hit the swirl gas cap and nozzle. This is the most common cause of premature nozzle failure. Piercing too high can cause slow arc transfer and misfires.

Adjust arc voltage: As the electrode wears, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 2-volt increments, up to 10 volts higher than the initial setting.

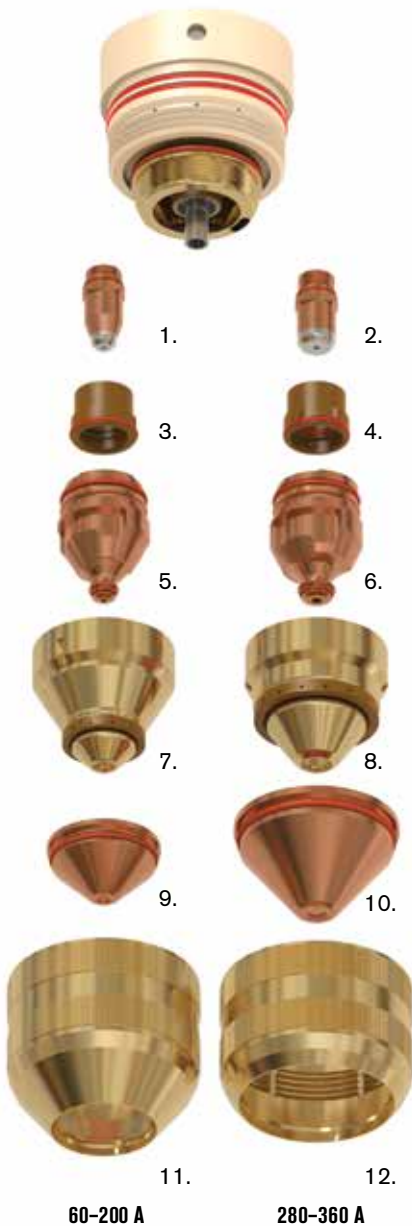
Avoid arc stretching: This can occur during rip cutting off the plate or when the lead out is improperly programmed. This shortens consumable life.

Clean the nozzle and swirl gas cap: Periodically clean the nozzle and swirl gas cap to remove spatter. This will prevent double arcing which shortens consumable life.

Adjust swirl gas flows: Correct swirl gas flows during pre-flow protect the nozzle and swirl gas cap from damage. Make sure pre-flow is adjusted according to the cutting tables in your owner's manual.

Centricut consumables for Kjellberg PerCut 210M and PerCut 450M torches

Parts list



Reference number	Article number	Description	Centricut number
1. G002Y	.11.848.221.300	SilverLine® electrode, 20–200 A	C124-1000
2. G032Y	.11.848.421.310	SilverLine electrode, 280 A	C124-1010
G034Y	.11.848.421.330	SilverLine electrode, 360 A	C124-1030
3. G101	.11.848.221.145	Gas guide – low amperage and Contour Cut™	C124-145
G102	.11.848.221.146	Gas guide, 60–200 A	C124-146
4. G121	.11.848.421.145	Gas guide, 280–400 A	C124-045
5. G2008Y	.11.848.221.408	CoolFlow™ nozzle, 60 A	C124-408
G2010Y	.11.848.221.410	CoolFlow nozzle, 90 A	C124-410
G2012Y	.11.848.221.412	CoolFlow nozzle, 130 A	C124-412
G2014Y	.11.848.221.414	CoolFlow nozzle, 160 A	C124-414
G2017Y	.11.848.221.417	CoolFlow nozzle, 200 A	C124-417
6. G2326Y	.11.848.421.426	CoolFlow nozzle, 280 A	C124-426
G2330Y	.11.848.421.430	CoolFlow nozzle, 360 A	C124-430
7. G3028	.11.848.201.1628	Nozzle cap, 60–200 A	C124-628
8. G3249	.11.848.401.1649	Nozzle cap, 280 A	C124-649
G3219	.11.848.401.1619	Nozzle cap, 280–360 A	C124-619
G3209	.11.848.401.1609	Nozzle cap, 360 A	C124-609
G3229	.11.848.401.1629	Nozzle cap, 360 A	C124-629
9. G4020	.11.848.201.1520	Swirl gas cap, 60 A	C124-520
G4025	.11.848.201.1525	Swirl gas cap, 90–130 A	C124-525
G4030	.11.848.201.1530	Swirl gas cap, 90–200 A	C124-530
G4035	.11.848.201.1535	Swirl gas cap, 200 A, Contour Cut	C124-535
G4040	.11.848.201.1540	Swirl gas cap, 200 A, Contour Cut	C124-540
10. G4350	.11.848.401.1550	Swirl gas cap, 280–360 A	C124-550
G4355	.11.848.401.1555	Swirl gas cap, 360 A	C124-555
11. G501	.11.848.201.081	Protection cap, 20–200 A	C124-081
12. G521	.11.848.401.081	Protection cap, 280–440 A	C124-1081
G901Y	.11.848.201.142	Cooling tube, 20–200 A	C124-142
G931Y	.11.848.401.142	Cooling tube, 280–400 A	C124-042

To arrange for your free trial of Centricut consumables
visit: response.hypertherm.com/CentricutTrial

Hypertherm, Centricut, SilverLine and CoolFlow are trademarks of Hypertherm, Inc., and may be registered in the United States and/or other countries. All other trademarks are the property of their respective owners. Hypertherm is in no way affiliated with Kjellberg.

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.

© 3/2013 Hypertherm, Inc. Revision 0
880870



Hypertherm®
Cut with confidence®

