

cutting and plasma gouging with hand or machine torch

PA-S45W, PA-S70W



The plasma cutting systems of the PA-S series are suitable for manual and mechanised cutting of material thicknesses in the range from 3 to 70 mm. The use of a range of different plasma gases and gas mixtures allows the clean cutting and gouging of electrically conductive materials. As portable systems, they can be used in workshops, training centres and on construction sites. The cost-efficient units of the PA-S series offer good cutting results for simple applications. The liquid-cooled plasma torch allows the use of air, oxygen, argon and hydrogen as plasma gas. Furthermore, these robust plasma cutting units can be operated with hand and machine torches.

Advantages

- Attractive price-performance ratio
- Optional use of hand or machine torch
- Suitable for 2D and 3D guiding systems
- Robust and simple design
- Portable systems for mobile use
- Reliable even under challenging production conditions
- Simple operation and maintenance with a service and diagnostic system
- Cutting current with three settings
- Fluid cooling of plasma torch for long consumable life
- Quick switch from cutting to plasma gouging
- Angled torch heads and special shaft designs for optimised cutting of 3D parts

Application Areas

- Metal construction and engineering
- Plant and tank construction
- Pipeline engineering
- Scrap cutting
- Dismantling

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Technical data

Power source	PA-S45W	PA-S70W
Mains voltage	3x400 V, 50 Hz	3x400 V, 50 Hz
Fuse, slow	63 A	125 A
Connected load max.	38 kVA	76 kVA
Cutting current	45 A (100% d.c.) 85 A (100% d.c.) 130 A (60% d.c.)	80 A (100% d.c.) 160 A (100% d.c.) 240 A (80% d.c.)
Dimension (L x W x H)	1025 x 711 x 970 mm	1380 x 870 x 1080 mm
Weight	240 kg	460 kg

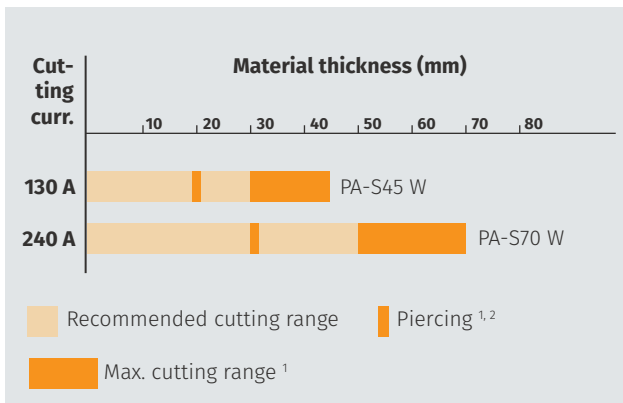
³ Other voltage and frequencies on request. ² Forming gas F5 (95 % N / 5 % H)

Plasma torch	PB-S44W	PB-S45W	PB-S70W
Cutting current (100% d.c.)	130 A	130 A	250 A
Cutting range	40 mm-ig	45 mm-ig	70 mm-ig
Plasma gas	Air, AR/H ₂ mix.	Air, AR, H ₂	Air, AR/H ₂ mix.
Swirl gas	Air, N ₂	-	-
Torch cooling	„Kjellforst“		

PA-S45 W	Mild steel		Stainless steel		Aluminium	
	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)
3	45	2000	-	-	-	-
5	85	2500	85	2500	85	3400
10	130	2000	130	2150	130	3000
15	130	1300	130	1700	130	2100
20	130	800	130	1000	130	1300
25	130	500	130	700	130	900
40	130	200	130	200	130	300
45	130	200	130	200	130	150

PA-S70 W	Mild steel		Stainless steel		Aluminium	
	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)
4	160	3000	160	2630	-	-
6	160	3150	160	2200	160	3500
8	160	2500	160	1750	160	3000
10	240	2600	160	1500	160	2000
15	240	1300	160	1000	160	1700
20	240	1100	240	1050	240	1750
30	240	800	240	530	240	1250
40	240	500	240	500	240	1000
50	240	230	240	350	240	600
60	240	200	240	200	240	350
70	240	125	-	-	240	250

¹ The listed cutting speeds depend on material characteristics, gas parameters, the guiding system as well as the consumables. According to the quality parameters of the respective cutting task, the user can change the cutting speed.



¹ These data are depending on the materials to be cut and their compositions. ³ Observe piercing capability!