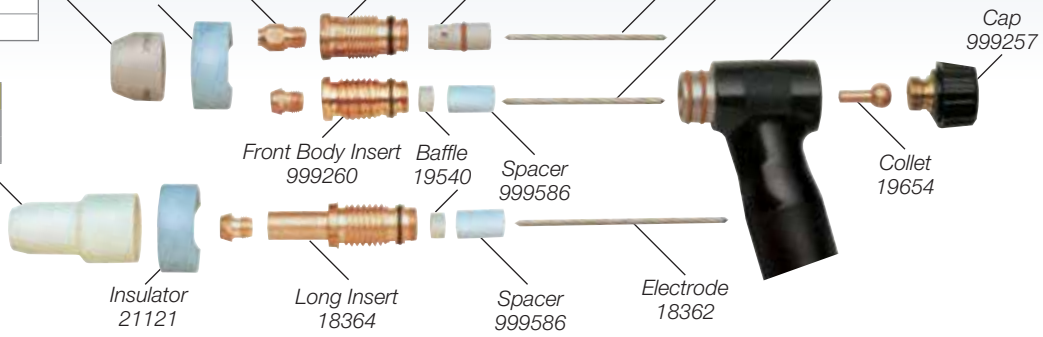
PT-121/PT-121M Manual Torch

Cutting Nozzle	Part Number	Orifice Size, in. (mm)
30A	17184	.032 (0.8)
55A	17119	.047 (1.2)
110A	999263	.055 (1.4)
150A	999264	.063 (1.6)
Gouging Nozzle	**Part Number**	
70A	20386	
100A	20387	
150A	19160	

Torch Body	Part Number
90°	999283
75°	999248
Mechanized	999270

Shield	Part Number
Standard	999261
50A, Drag	999620
120A, Drag	18419

Shield	Part Number
Long	18363
Gouging	31411



Spare Parts Kit

Description	Part Number	19539
Electrode, standard	2075328	5
Electrode, long	18362	2
Nozzle 150A	999264	5
Nozzle 110A	999263	5
Nozzle 55A	17119	5
Nozzle Gouging 150A	19160	2
Collet (copper), heavy-duty	19654	2
Heat shield	999261	2
Heat shield, long	18363	2
Heat shield, gouging	31411	2
Heat shield, drag	18419	2
Front body insert	999260	1
Front body insert, long	18364	1
High current insert	19690	2
High current baffle	19691	2
Baffle	19540	2
Spacer	999586	1
Torch cap	999257	1
Lubricant .25 oz	0558000443	1
O-Ring	994092	5
O-Ring	96W97	2
O-Ring	85W50	2
Wrench	999568	1
Center-adjust tool	999266	2
Tool box	950272	1

PT-25 Manual Torch

- **Excellent cutting capability - cuts up to 1-1⁄2 in. (38.1 m) using air or Nitrogen at 100A; cuts up to 2 in. (50.8 mm) using Nitrogen or Argon-Hydrogen at 150A**
- **Produce clean, high quality cuts**
- **Patent pending safety circuit for enhanced operator safety**
- **Operate with shop or cylinder air at 100A; Nitrogen or Argon-Hydrogen at 150A**
- **Compact, lightweight design for ease of handling**
- **Long-life electrodes lower operating costs**
- **Pilot arc starting - even starts on paint**
- **Gouging nozzle available**
- **Intermittent cutting capability for grate or expanded metal applications**
- **Gouging guard and stand-off guide available for operator convenience**

This versatile, easy-to-use 150 Amp torch provides superior performance for a full range of manual cutting applications.

Consoles

The PT-25 can be used with the following older ESAB consoles:

- **ESP-100i standard**
- **PCM-150 with retrofit kit P/N 21932**
- **PCM-100 with retrofit kit P/N 21932**

Ordering Information

PT-25, 90°

25 ft. (7.6 m) lead..... 21648
50 ft. (15.2 m) lead..... 21649
25 ft. (7.6 m) "CE"[1]..... 21650
50 ft. (15.2 m) "CE"[1]..... 21651

[1]For use in regions that require "CE" such as Europe, Russia, and Australia.

Options & Accessories

Torch Guide Kits

Deluxe: 1-3⁄4 in. (44.5 mm) 42 in. (106 cm) radius. 0558003258
Basic: 1-3⁄4 in. (44.5 mm) 28 in. (71 cm) radius . 0558002675

Plasmit torch head protector 20801
Leather sheath, 10 ft. (3 m) length 20812
Plasma flow measuring kit 0558000739
Retrofit kit for PCM-100/150[1] 21932
"CE" swirl baffle[2] 0558001457

[1]Enables use of PT-25 with PCM-100/150.
[2]For use in regions that require "CE" such as Europe, Russia, and Australia.

Specifications

PT-25	
Current capacity @ 100% duty cycle	100A DCSP (Air Plasma) 150A DCSP (N_2, H-35, N_2/H_2 Plasma)
Approved service gases: Plasma Cooling	 Air, N_2, H-35, N_2/H_2 mixtures Air, N_2, CO_2
Min. gas flow requirements: Plasma Cooling	 200 cfh @ 70 psig 360 cfh @ 70 psig
Length of service leads, ft. (m)	25 (7.6) 50 (15.2)
Weight of service leads, lbs. (kg): 25 ft. (7.6 m) 50 ft. (15.2 m)	 14 (6.4) 25 (11.4)

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