Q 1500 (plus) / 3000 (plus) *#1*

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

mild steel - 1.0330 DC01

Contour Cut ***PG (O2)***

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
0,5 - 1,5	20	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2007K .11.858.401.407K	E3014 .11.858.401.1614	E4020 .11.858.401.1520	E501 .11.858.401.131
1 - 3	35							

Q 1500 (plus) / 3000 (plus) #2

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

mild steel - 1.0037 S235

Silent Cut

PG (O2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
4 - 10	60	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2008SK .11.858.401.408SK	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501 .11.858.401.131
								
4 - 15	100	E902 .11.858.401.142	E015 .11.858.411.350	E1034C .11.858.401.1434C	E2011SK .11.858.401.411SK	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501 .11.858.401.131
20 - 25	150				E2013SK .11.858.401.413SK		E4035 .11.858.401.1535	
30						E3004 .11.858.401.1604	E4040 .11.858.401.1540	
12 - 15						E3014 .11.858.401.1614	E4035 .11.858.401.1535	

Contour Cut

PG (O2)

								
4 - 6	35	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2007K .11.858.401.407K	E3014 .11.858.401.1614	E4020 .11.858.401.1520	E501 .11.858.401.131
4 - 10	60				E2008K .11.858.401.408K			
4 - 15	100				E2011K .11.858.401.411K		E4025 .11.858.401.1525	
								
20 - 25	150	E902 .11.858.401.142	E015 .11.858.411.350	E1034C .11.858.401.1434C	E2013K .11.858.401.413K	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501 .11.858.401.131
30						E3004 .11.858.401.1604	E4035 .11.858.401.1535	
12 - 15						E3014 .11.858.401.1614	E4030 .11.858.401.1530	

Q 1500 (plus) / 3000 (plus) #2

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

mild steel - 1.0037 S235

Contour Cut

PG (O2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
20 - 30 12 - 15	200	E902 .11.858.401.142	E016 .11.858.411.360	E1034C .11.858.401.1434C	E2017K .11.858.401.417K	E3014 .11.858.401.1614	E4035 .11.858.401.1535	E501 .11.858.401.131
								
20 - 30 35 - 40	300	E922 .11.858.421.142	E023 .11.858.421.330	E1264C .11.858.421.1464C	E2228K .11.858.421.428K	E3228 .11.858.421.1628 E3218 .11.858.421.1618	E4250 .11.858.421.1550	E501 .11.858.401.131

Contour Cut Speed

PG (O2)

								
3 - 8	60	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2008K .11.858.401.408K	E3014 .11.858.401.1614	E4020 .11.858.401.1520	E501 .11.858.401.131
3 - 15	100				E2011K .11.858.401.411K		E4025 .11.858.401.1525	
								
20 - 25	150	E902 .11.858.401.142	E015 .11.858.411.350	E1034C .11.858.401.1434C	E2013K .11.858.401.413K	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501 .11.858.401.131
30 - 60						E3004 .11.858.401.1604	E4035 .11.858.401.1535	
6 - 15						E3014 .11.858.401.1614	E4030 .11.858.401.1530	
								
20 - 30 10 - 15	200	E902 .11.858.401.142	E016 .11.858.411.360	E1034C .11.858.401.1434C	E2017K .11.858.401.417K	E3014 .11.858.401.1614	E4035 .11.858.401.1535	E501 .11.858.401.131

Q 1500 (plus) / 3000 (plus) #2

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

mild steel - 1.0037 S235

Contour Cut Speed

PG (O2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
20 - 30	300	E922 .11.858.421.142	E023 .11.858.421.330	E1264C .11.858.421.1464C	E2228K .11.858.421.428K	E3228 .11.858.421.1628	E4250 .11.858.421.1550	E501 .11.858.401.131
35 - 40						E3218 .11.858.421.1618		
50 - 60						E3208 .11.858.421.1608		
70 - 80							E4260 .11.858.421.1560	
8 - 15						E3248 .11.858.421.1648	E4240 .11.858.421.1540	

Q-Hole 0,75 : 1

PG (O2)

								
8 - 10	60	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2008K .11.858.401.408K	E3014 .11.858.401.1614	E4020 .11.858.401.1520	E501 .11.858.401.131
8 - 15	100				E2011K .11.858.401.411K		E4025 .11.858.401.1525	
								
20 - 25	150	E902 .11.858.401.142	E015 .11.858.411.350	E1034C .11.858.401.1434C	E2013K .11.858.401.413K	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501 .11.858.401.131
15								
								
20 - 30	200	E902 .11.858.401.142	E016 .11.858.411.360	E1034C .11.858.401.1434C	E2017K .11.858.401.417K	E3014 .11.858.401.1614	E4035 .11.858.401.1535	E501 .11.858.401.131
15								

Q 1500 (plus) / 3000 (plus) #2

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

mild steel - 1.0037 S235

Q-Hole 1 : 1

PG (O2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
4 - 6	35	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2007K .11.858.401.407K	E3014 .11.858.401.1614	E4020 .11.858.401.1520	E501 .11.858.401.131
6 - 10	60				E2008K .11.858.401.408K			
					E2008SK .11.858.401.408SK		E4030 .11.858.401.1530	
6 - 15	100				E2011K .11.858.401.411K		E4025 .11.858.401.1525	
								
6 - 15	100	E902 .11.858.401.142	E015 .11.858.411.350	E1034C .11.858.401.1434C	E2011SK .11.858.401.411SK	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501 .11.858.401.131
20 - 25	150				E2013K .11.858.401.413K		E4035 .11.858.401.1535	
					E2013SK .11.858.401.413SK			
30					E2013K .11.858.401.413K	E3004 .11.858.401.1604		
					E2013SK .11.858.401.413SK		E4040 .11.858.401.1540	
12 - 15					E2013K .11.858.401.413K	E3014 .11.858.401.1614	E4030 .11.858.401.1530	
					E2013SK .11.858.401.413SK		E4035 .11.858.401.1535	
								
20 - 30	200	E902 .11.858.401.142	E016 .11.858.411.360	E1034C .11.858.401.1434C	E2017K .11.858.401.417K	E3014 .11.858.401.1614	E4035 .11.858.401.1535	E501 .11.858.401.131
12 - 15								

UWP

PG (O2)

								
3 - 6	60	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2008K .11.858.401.408K	E3028 .11.858.401.1628	E4020 .11.858.401.1520	E501P .11.858.401.131P
5 - 6	100				E2011K .11.858.401.411K	E3014 .11.858.401.1614	E4025 .11.858.401.1525	
8							E4030 .11.858.401.1530	
10						E3028 .11.858.401.1628		

Q 1500 (plus) / 3000 (plus) #2

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

mild steel - 1.0037 S235

UWP ***PG (O2)***

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
6 - 8	150	E902 .11.858.401.142	E015 .11.858.411.350	E1034C .11.858.401.1434C	E2013K .11.858.401.413K	E3014 .11.858.401.1614	E4030 .11.858.401.1530	E501P .11.858.401.131P
10							E4035 .11.858.401.1535	
12 - 20						E3018 .11.858.401.1618		
								
10 - 12	200	E902 .11.858.401.142	E016 .11.858.411.360	E1034C .11.858.401.1434C	E2017K .11.858.401.417K	E3028 .11.858.401.1628	E4035 .11.858.401.1535	E501P .11.858.401.131P
15 - 30						E3018 .11.858.401.1618		
								
10	300	E922 .11.858.421.142	E023 .11.858.421.330	E1264C .11.858.421.1464C	E2228K .11.858.421.428K	E3228 .11.858.421.1628	E4245 .11.858.421.1545	E501P .11.858.401.131P
12							E4250 .11.858.421.1550	
15							E4255 .11.858.421.1555	
20 - 30						E3218 .11.858.421.1618		
35 - 40							E4260 .11.858.421.1560	

Q 1500 (plus) / 3000 (plus) #3

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

stainless steel - 1.4301 CrNi

HiFinox — PG (N2/H2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
1 - 6	60 - 80	E941 .11.858.441.141	E042 .11.858.441.520	E1034C .11.858.401.1434C	E2011K .11.858.401.411K	E3004 .11.858.401.1604	E4022 .11.858.401.1522	E501 .11.858.401.131

N2 — PG (N2)

								
1 - 8	60	E942 .11.858.441.142	E044 .11.858.441.540	E1034C .11.858.401.1434C	E2011K .11.858.401.411K	E3008 .11.858.401.1608	E4022 .11.858.401.1522	E501 .11.858.401.131
6	80				E2013K .11.858.401.413K		E4025 .11.858.401.1525	
8 - 10							E4030 .11.858.401.1530	

Ar/H2 Mix — PG (Ar, H2)

								
5 - 15	130	E941 .11.858.441.141	E052 .11.858.451.520	E1464 .11.858.441.1464	E2514K .11.858.451.614K	E3028 .11.858.401.1628	E4030 .11.858.401.1530	E501 .11.858.401.131

N2 — PG (N2)

								
5 - 8	150	E902 .11.858.401.142	E005 .11.858.401.350	E1699 .11.858.461.1499	E2017K .11.858.401.417K	E3008 .11.858.401.1608	E4035 .11.858.401.1535	E501 .11.858.401.131
10 - 40							E4040 .11.858.401.1540	

Q 1500 (plus) / 3000 (plus) #3

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

stainless steel - 1.4301 CrNi

Ar/H2 Mix — PG (Ar, H2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
10 - 30	150	E941 .11.858.441.141	E052 .11.858.451.520	E1464 .11.858.441.1464	E2515K .11.858.451.615K	E3028 .11.858.401.1628	E4030 .11.858.401.1530	E501 .11.858.401.131
40 - 60							E4040 .11.858.401.1540	

N2 — PG (N2)

								
8 - 10	300	E922 .11.858.421.142	E022 .11.858.421.320	E1264C .11.858.421.1464C	E2228K .11.858.421.428K	E3208 .11.858.421.1608	E4235 .11.858.421.1535	E501 .11.858.401.131
12 - 60							E4240 .11.858.421.1540	

Ar/H2 Mix — PG (Ar, H2)

								
12 - 30	300	E963 .11.858.461.143	E065 .11.858.461.550	E1699 .11.858.461.1499	E2625K .11.858.461.625K	E3218 .11.858.421.1618	E4235 .11.858.421.1535	E501 .11.858.401.131
40 - 80						E3208 .11.858.421.1608	E4245 .11.858.421.1545	

UWP — PG (N2/H2)

								
3 - 5	60	E941 .11.858.441.141	E042 .11.858.441.520	E1034C .11.858.401.1434C	E2011K .11.858.401.411K	E3004 .11.858.401.1604	E4022 .11.858.401.1522	E501P .11.858.401.131P

Q 1500 (plus) / 3000 (plus) #3

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

stainless steel - 1.4301 CrNi

UWP ***PG (Ar, H2)***

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
6 - 20	130	E941 .11.858.441.141	E052 .11.858.451.520	E1464 .11.858.441.1464	E2514K .11.858.451.614K	E3028 .11.858.401.1628	E4030 .11.858.401.1530	E501P .11.858.401.131P
6 - 25	150				E2515K .11.858.451.615K			
30						E3018 .11.858.401.1618		
								
15 - 30	300	E963 .11.858.461.143	E065 .11.858.461.550	E1699 .11.858.461.1499	E2625K .11.858.461.625K	E3218 .11.858.421.1618	E4235 .11.858.421.1535	E501P .11.858.401.131P
40						E3208 .11.858.421.1608	E4240 .11.858.421.1540	

Q 1500 (plus) / 3000 (plus) #4

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

aluminium - 3.3535 AlMg3

HiFinox — PG (Air)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
1 - 6	35	E902 .11.858.401.142	E012 .11.858.411.320	E1034C .11.858.401.1434C	E2007K .11.858.401.407K	E3014 .11.858.401.1614	E4020 .11.858.401.1520	E501 .11.858.401.131

N2 — PG (N2)

								
3 - 8	60	E942 .11.858.441.142	E044 .11.858.441.540	E1034C .11.858.401.1434C	E2008K .11.858.401.408K	E3018 .11.858.401.1618	E4020 .11.858.401.1520	E501 .11.858.401.131

Ar/H2 Mix — PG (Ar, H2)

								
6 - 25	100	E941 .11.858.441.141	E052 .11.858.451.520	E1464 .11.858.441.1464	E2013K .11.858.401.413K	E3008 .11.858.401.1608	E4035 .11.858.401.1535	E501 .11.858.401.131

N2 — PG (N2)

								
6 - 15	150	E902 .11.858.401.142	E005 .11.858.401.350	E1699 .11.858.461.1499	E2017K .11.858.401.417K	E3018 .11.858.401.1618	E4040 .11.858.401.1540	E501 .11.858.401.131
20 - 40						E3008 .11.858.401.1608		

Ar/H2 Mix — PG (Ar, H2)

								
6 - 60	150	E941 .11.858.441.141	E052 .11.858.451.520	E1464 .11.858.441.1464	E2015K .11.858.401.415K	E3008 .11.858.401.1608	E4040 .11.858.401.1540	E501 .11.858.401.131

Q 1500 (plus) / 3000 (plus) #4

Q-Gas (O2) 4500 - Q-Torch 45xx - Configuration K

data version: 4 - valid from: 02.09.2021 - Base Edition

aluminium - 3.3535 AlMg3

N2 PG (N2)

thickness [mm]	cutting current [A]	cooling tube	cathode	gas guide	nozzle	nozzle cap	swirl gas cap	protection cap
								
10 - 12	300	E922 .11.858.421.142	E022 .11.858.421.320	E1264C .11.858.421.1464C	E2228K .11.858.421.428K	E3208 .11.858.421.1608	E4240 .11.858.421.1540	E501 .11.858.401.131
15							E4250 .11.858.421.1550	
20 - 60							E4260 .11.858.421.1560	

Ar/H2 Mix PG (Ar, H2)

								
10 - 80	300	E963 .11.858.461.143	E065 .11.858.461.550	E1699 .11.858.461.1499	E2625K .11.858.461.625K	E3208 .11.858.421.1608	E4260 .11.858.421.1560	E501 .11.858.401.131