



# PT-32EH PLASMARC™ TORCH

## PT-32 EH Torch

Designed for superior cutting performance and ease of handling, the PT-32EH patented torch produces clean, exceptionally high quality cuts. The new ergonomic handle offers dual-switch capability, extra comfort and a non-slip grip.

- Most compact 90 amp torch on the market
- New, durable torch cable prevents snagging on fixtures and materials
- Excellent cutting capacity—cuts up to 1-1/2 in. (38 mm)
- Uses shop air, cylinder air or nitrogen for superior versatility
- Pilot arc starting—even starts through paint
- Choice of 25 ft. (7.6 m) or 50 ft. (15.2 m) line length
- Excellent consumable life
- Parts in place design
- Patented torch and safety circuit
- Exclusive 40 amp Drag Nozzle
- One-year warranty



**PT-32EH CUTTING SPEEDS**  
OUTPUT CURRENT 60, 70 & 90AMPS w/AIR @ 75psi (5.2bar)

## Specifications

Cuts up to 1-1/2 in. (38 mm)	
Current Capacity.....	90 A @ 100% duty cycle
Air Supply .....	350 cfh @ 75-80 psig (165 l/min @ 5.2 - 5.5 bar)
Length of Service Lines.....	25 ft. (7.6 m) or 50 ft. (15.2 m)
Dimensions	
Overall Length.....	8.2 in. (208 mm)
Length of Head.....	3.0 in. (76 mm)

## Consoles

**PowerCut® 875, PowerCut® 1125, PowerCut® 1250, and PowerCut®1500**

## Ordering Information

PT-32EH, 90°, 25 ft. (7.6 m) line .....	0558003548
PT-32EH, 90°, 50 ft. (15.2 m) line .....	0558003549

Torches and torch body assemblies are supplied without electrode, nozzle, heat shield and valve pin. Order individual components shown with PT-32EH parts breakdown following.

## Optional Accessories

50/70 amp Spare Parts Kit (PC-875 "CE") .....	0558004949
50/70 amp Spare Parts Kit (PC-875/1125) .....	0558002822
70 amp Spare Parts Kit (PC-1250) .....	0558003508
70 amp Spare Parts Kit (PC-1250) "CE" .....	0558003560
90 amp Spare Parts Kit (PC-1500) .....	0558003062
90 amp Spare Parts Kit (PC-1500) "CE" .....	0558003557
Plasma Flow Measuring Kit	

This valuable troubleshooting tool allows measurement of the actual plasma gas flow through the torch..... 19765

### Torch Guide Kit

This complete kit, in a rugged plastic carrying case, includes attachments for circle and straight line cutting on ferrous and non-ferrous metals.

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

### Stand-off Guide

For proper stand-off distance when drag cutting ..... 0558002393

40 amp Drag Nozzle .....	0558002908
Gouging Nozzle .....	0558003089
Heat Shield Gouging .....	0558003090
Heat Shield Long "CE" .....	0558003110
Drag Heat Shield	

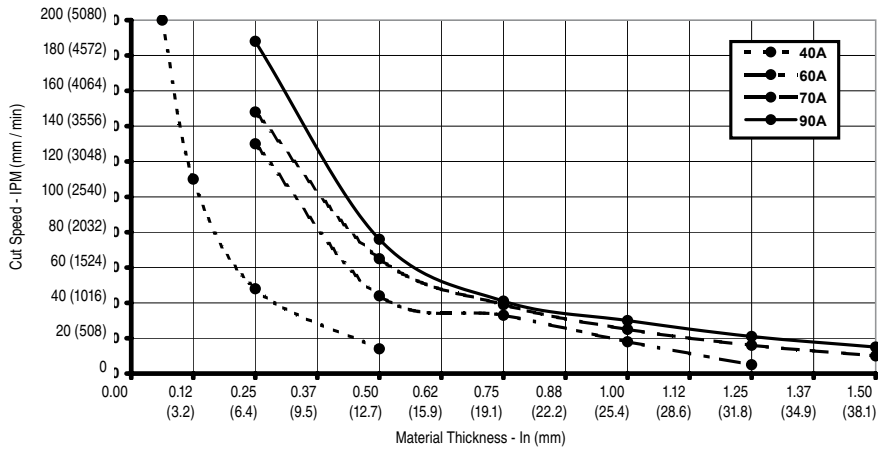
Metal feet built into heat shield allows accurate standoff distance for drag cutting ..... 0558003374

### Heavy Duty Drag Heat Shield

Suitable for piercing and heavy industrial use ..... 0558004206

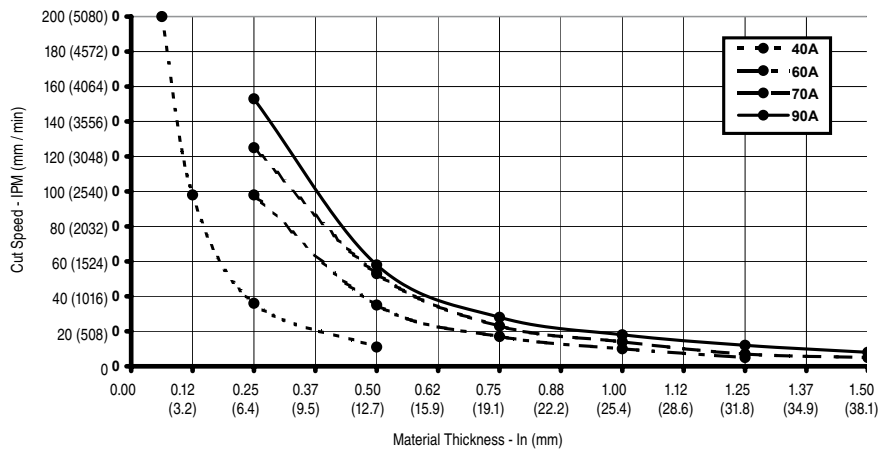
Instruction Literature, PT-32.....	F-15-440
Instruction Literature, PT-32EH.....	F-15-747
Sales Literature, order number (PT-32EH).....	PAC-21091

## PT-32EH Cut Speeds - Aluminum



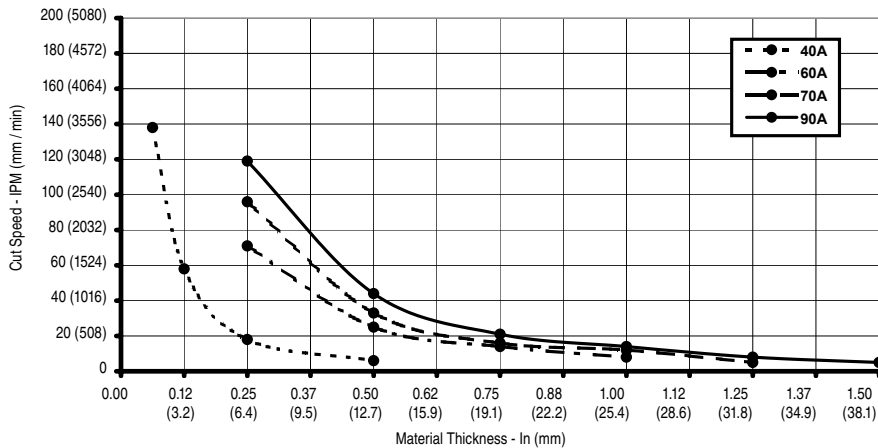
All cut data performed using standard production consumables and 75 psi (5.2 bar) Air

## PT-32EH Cut Speeds - Carbon Steel

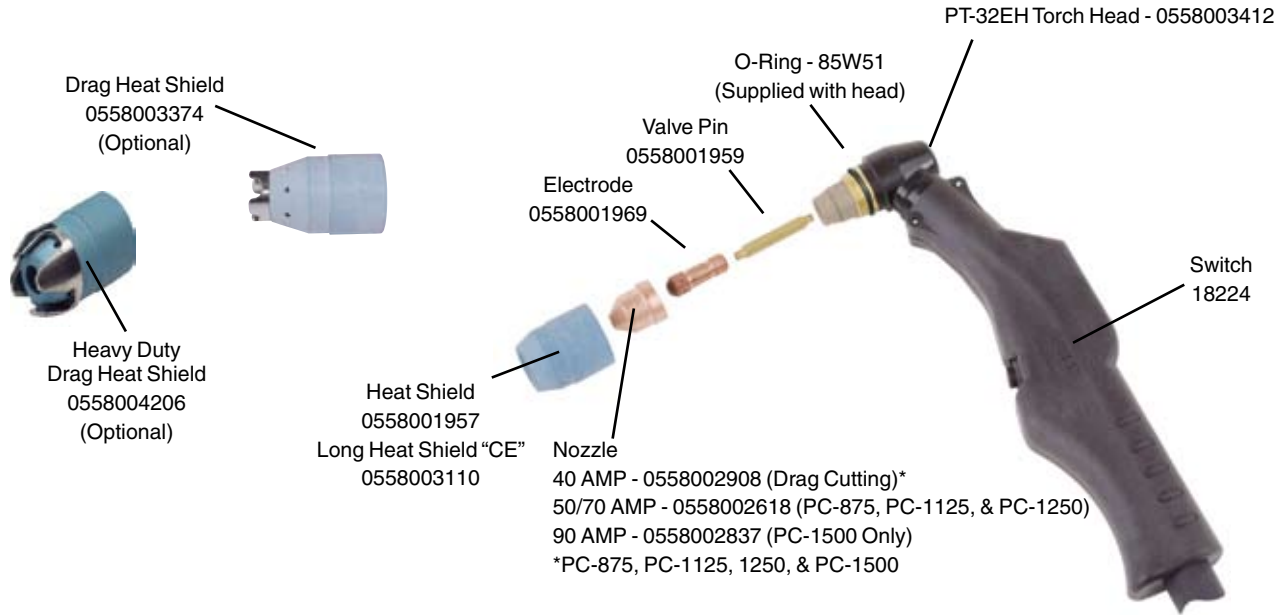


All cut data performed using standard production consumables and 75 psi (5.2 bar) Air

## PT-32EH Cut Speeds - Stainless Steel



All cut data performed using standard production consumables and 75 psi (5.2 bar) Air



### Contents of PT-32EH Spare Parts Kits

Description	P/N	PC-875/1125	PC-875 (CE)	PC-1250	PC-1250 (CE)	PC-1500	PC-1500 (CE)
		P/N 0558002822	P/N 0558004949	P/N 0558003508	P/N 0558003560	P/N 0558003062	P/N 055800355
	50/70 Amp P/N	50/70 Amp	70 Amp	70 Amp	70 Amp 400V	90 Amp	90 Amp 400V
Heat Shield Long	0558003110	-	2	-	2	-	2
Heat Shield	0558001957	2	-	2	-	2	-
50/70 amp Nozzle	0558002618	4	4	4	4	-	-
90 amp Nozzle	0558002837	-	-	-	-	4	4
40 amp drag Nozzle	0558002908	1	1	1	1	1	1
Electrode	0558001969	3	3	3	3	3	3
Valve Pin	0558001959	1	1	1	1	1	1
Fuse 2 amp, 600vdc	0558003075	-	-	1	1	1	1
Stand-off Guide	0558002393	1	1	1	1	1	1
Wrench	19129	1	1	1	1	1	1
Lubricant	17672	1	1	1	1	1	1

Note: "CE" Items are used outside North America



## Plasmarc™ Package Selection Guide

Model	See Page	Output Current	Cycle	Torch Compatibility											Cut Capacity Carbon Steel	
				Duty PT-34	PT-31 XL	PT-31 XLPC	PT-32 EH	PT-37	PT-38	PT-251	PT-26	PT-35	PT-20AMX PT-21AMX	PT-19XLS PT600		
Handy Plasma® 125	8	11 A	30%	●												1/8 inch 3.18 mm
Handy Plasma® 250	9	18 A	20%		●											1/4 inch 6.35 mm
Handy Plasma® 380	10	15-30 A	35%		●											3/8 inch 9.5 mm
Handy Plasma® 550	11	15-35 A	40%		●											1/2 inch 12.7mm
PowerCut® 650	13	22-40 A	100%			●										5/8 inch 15.9 mm
PowerCut® 875	15	10-60 A	60%				●									7/8 inch 22 mm
PowerCut® 1300	17	20-70 A	60%					●	●							1 1/4 inch 32 mm
PowerCut® 1600	19	20-90 A	40%					●	●							1 1/2 inch 38 mm
ESP-50	21	20-50 A	100%									●				1/2 inch 12.7 mm
ESP-101	23	25-100 A	100%					●								1 1/4 inch 32 mm
ESP-150	24	30-150 A	90%								●			●		2 inch 50.8 mm
ESP-200	28	50-200 A	100%									●		●		2 inch 50.8 mm
Deuce Pack 150	26	30-300 A	90%							●	●				Special Order	4 inch 101.6mm

## Plasmarc™ Torch Selection Guide

Torch	See Page	Output	Torch Type	Cutting Gas	Shielding Gas	Cooling Method	Torch Head Angle	Lengths Available	Power Supply Compatibility
PT-34	8	11 A	Man	Air	N/A	Gas	75°	15 ft.	HandyPlasma® 125
PT-31XL	32	50 A	Man	Air	N/A	Gas	75°	25 & 50 ft.	PCM-500i HandyPlasma® 550, HandyPlasma® 380
PT-31XLPC	32	50 A	Man	Air	N/A	Gas	75°	25 & 50 ft.	PowerCut® 650
PT-27	41	80 A	Man	Air	N/A	Gas	75°	25 & 50 ft.	PCM-875, PCM-1125
PT-32EH	34	90 A	Man	Air	N/A	Gas	90°	25 & 50 ft.	PowerCut® 875, PowerCut® 1125, PowerCut® 1250, PowerCut® 1500
PT-37	37	100	Mech	Air	N/A	Gas	In Line	4-1/2, 17, 25, 50 ft.	PowerCut® 1300, PowerCut® 1600, ESP-101
PT-38	39	90	Man	Air	N/A	Gas	90°	25, 50 ft.	PowerCut® 1300, PowerCut® 1600, ESP101
PT-25	45	100 A Air 150 A N <sub>2</sub> ,H-35	Man	Air, N <sub>2</sub> , H-35	Air, N <sub>2</sub> ,CO <sub>2</sub>	Gas	90°	25 & 50 ft.	ESP-100i
PT-251		300 A	Man &	H-35 Mech	N/A	Water	70° & 90°	25 & 50 ft.	Deuce Pack 150
PT-26	47	300 A	Man & Mech	Air, N <sub>2</sub> , H-35	Air, N <sub>2</sub> , CO <sub>2</sub>	Water	70°, 90° & 180°	25 & 50 ft.	Deuce Pack 150, ESP-150, ESP-200
PT-20AMX PT-21AMX	51	100 A	Mech	Air	N/A	Gas	Inline	4-1/2, 17, 50 ft.	ESP-100i, PCM-150, (w/adaptor): PCM-875, PCM-1125, (PC-1250, PC-1500 w/PT-2 AMX only)
PT-35	21	50 A	Mech	Air	N/A	Gas	Inline	25 & 50 ft.	ESP-50

### Recommended Cutting Gases

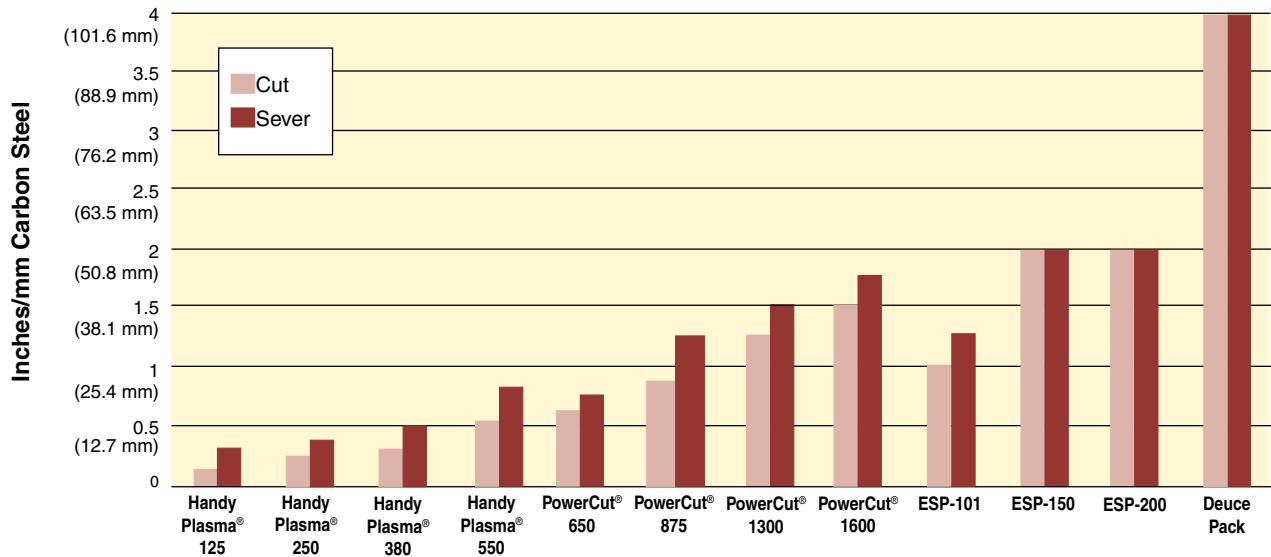
**Compressed Air** is the most commonly used gas for lower current plasma cutting and works well for most metals from gauge thickness to 1 in. (25.4 mm). It leaves an oxidized cut surface. Compressed air can also be used for plasma gouging on carbon steel.

**Nitrogen** is often used for higher current plasma systems and for cutting materials up to 3 in. (76.2 mm) thick. It produces excellent quality cuts on most materials.

**Oxygen** is used when the highest quality mechanized cuts are desired on carbon steel up to 1-1/4 in. (31.75 mm) thick. The cut face is smooth, and dross is easy to remove. Oxygen can also be used on stainless steel and aluminum, but it produces a rougher cut face.

**Argon-Hydrogen Mixtures** are generally used for cutting stainless steel and aluminum. They produce a clean, high quality cut face. Argon-Hydrogen is required for mechanized cutting of any material more than 3 in. (76.2 mm) thick. This mixture also provides an excellent gas for plasma gouging on all materials.

### Plasmarc™ Cutting Package Capabilities



## Torch Guide Kits

- Includes attachments for circle and straight line cutting on ferrous and non-ferrous metals
- For additional information, order literature number EMB-1074 (Deluxe Kit) and/or EMB-1075 (Basic Kit)

## Adaptor for PT-17AM and PT-20AMX Torches

- Adapts PT-17AM torch to PCM-875 and PCM-1125 console for manual cutting
- Adapts PT-17AM/PT-20AM torches to PCM-875 and PCM-1125 consoles for mechanized cutting

## 90° Head Angle Converter Kit for PT-27/23 Torch

- Fits between handle and head of torch
- Gives the effect of a 90° angle torch head

## Plasma Flow Measuring Kit

- Valuable troubleshooting tool
- Allows measurement of actual plasma gas flow through torch

## Remote Hand Switch

- Allows the operator to start and stop the cutting process with a remote switch.
- Used primarily for mechanized cutting and is included in the mechanized Plasmarc packages

## Torch Retrofit Kits

- Allow select ESAB Plasmarc torches to be retrofitted to other brand plasma consoles
- Do not include the torch, which must be purchased separately

## Leather Sheath

- A 10 ft. (3 m) leather sheath to protect torch leads from abrasion and molten metal
- Particularly recommended for plasma gouging

## Plasmits

- Special flexible shields attach around the head of a plasma cutting torch to provide added protection against heat and molten metal
- Recommended for heavy duty plasma gouging applications

## Torch Wrap & Kit Holder

- This enables operator to store spare parts kit, wrap torch and work cable for easy transport and storage

## Wheel Kit

- This enables easy transport of the PCM-500i, PCM-875 and PCM-1125 Series; and PowerCut® 875/1125 and PowerCut® 1250/1500 Series Machines



**Deluxe  
Torch Guide  
Kit**



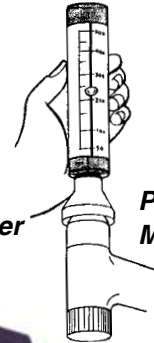
**Plasmit  
w/Torch**



**Basic Torch  
Guide Kit**



**Torch Wrap and Kit Holder  
PowerCut® Machines**



**Plasma Flow  
Measuring Kit**



**Wheel Kit  
PowerCut® Machines**

## Ordering Information

Torch Wrap and Kit Holder, PCM Series.....	33952GY
Torch Wrap and Kit Holder, PowerCut® 875/1125.....	0558003013
Torch Wrap and Kit Holder, PowerCut® 1250/1500.....	0558003059
Torch Wrap & Kit Holder PowerCut® 650.....	0558003398
Wheel Kit PowerCut® 650.....	0558003399
Wheel Kit, PCM Series.....	34324
Wheel Kit, PowerCut® 875/1125.....	0558003014
Wheel Kit, PowerCut® 1250/1500.....	0558003060
Torch Guide Kit for PT-17, 23/27, 25, 31/34 & PT-32EH Torches (Deluxe: 1-3/4 in. (44.45 mm) - 42 in. (106.7 cm) Radius)	0558003255
PT-17 Bushing.....	TJ2226
PT-23/27 Bushing.....	TJ2225
PT-25 Bushing.....	TJ2230
PT-31XL Bushing.....	TJ2228
PT-32 Bushing.....	0558003257
Torch Guide Kit for PT-27/31XL/34/32 Torch (Basic: 1-3/4 in. (44.45 mm) - 28 in. (71 cm) Radius).....	0558002675
90° Angle Converter Kit for PT-27.....	000222
Plasma Flow Measuring Kit.....	19765
Remote Hand Switch PT-20AMX.....	680982
Remote Hand Switch ESP-150 and ESP-200.....	2075600
Remote Hand Switch PT-21AMX.....	0558003612
Retrofit Kit to adapt PT-17A to PAK5XR/PAK10XR.....	31548
Retrofit Kit to adapt PT-31XL/ PT-27 to MAX-40.....	18228
10 Ft. Leather Sheath with Snaps (For use with any ESAB Plasmarc torch).....	20812
Plasmit for PT-17A Manual Torch.....	20803
Plasmit for PT-121, 75° Torch.....	20742
Plasmit for PT-121/PT-25, 90° Torch.....	20801
Plasmit for PT-121, Mechanical Torch.....	20802
Plasmit for PT-251, 75° Torch.....	20805
Plasmit for PT-26 70° Torch.....	0558006717
Plasmit for PT-26 90° Torch.....	0558006718
Plasmit for PT-251 Mechanical Torch.....	20807
Adaptor for PT-17A & PT-20AMX on PCM-875 & PCM-1125.....	19500