

Cutmaster® 60i

Highest power-to-weight ratio in its class



The Cutmaster® 60i with SL60QD™ 1Torch® is the perfect combination of end-user insight, advanced technology, and intelligent design. Packed with power and offering the highest power-to-weight ratio in its class, the Cutmaster 60i with SL60QD 1Torch also has best in class cutting arc length and the most empowering and engaging user experience no matter the application. Cutmaster MechPak is also available for easy integration into semi-automatic cutting processes.

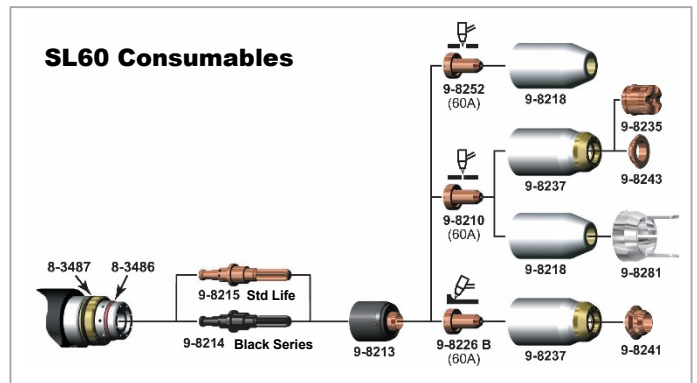
- 50% Duty Cycle at 60A built for portability and durability with the integral multi-handle design
- Industrial SL60QD 1Torch quick disconnect with ATC® (Advanced Torch Connector) allowing selective replacement of either the torch handle assembly or the torch leads, using the patented SureLok® technology
- Up to 20 mm recommended cut capacity with maximum sever of 38 mm and 20 mm pierce capability
- High-visibility, oversized display with gas optimizer technology and consumables end-of-life indicator makes setup and usage simple and productive
- Cutmaster Black Series electrode included for up to 60% longer life of consumable parts
- Industry leading 3-year warranty on power supply and 1-year warranty on torch

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Specifications	
Amperage Output	10 – 60 A, continuously adjustable
Recommended Generator Size	15 kW (full output)
Open Circuit Voltage (OCV)	300 V
Input Voltage	400 VAC +/- 10%, 50/60 Hz, 3ph
Rated Duty Cycle	50% @ 60 A 60% @ 50 A 100% @ 40 A
Amperage Draw	13.2 A @ 400 V
Input Power Cable and Plug	2.7 m
Work Lead with Ground Clamp	6 m #8 work cable with 50 mm connection
Gas Requirements	Compressed air
Operating Temperature Range	0° - 50° C
Operating Input Air Pressure Range	6.2 – 8.6 bar
Air Flow Requirements (cutting & gouging)	142 – 235 l/min
Recommended Cut	20 mm
Maximum Sever	38 mm
Pierce Rating	20 mm
SL60QD Torch Duty Cycle	100% at 60 A @ 190 l/min
Torches – for use with the Cutmaster 60i	SL60QD 1Torch (supplied) SL60/SL100 1Torch SL100 1Torch Mechanized SL100SLV 1Torch Automated
Dimensions L x W x H	536 x 199 x 359 mm
Weight	16.8 kg

Cutting Specifications	
Plate Thickness	Recommended Cut Speed
6 mm	2030 mm/min
13 mm	660 mm/min
16 mm	480 mm/min
19 mm	360 mm/min
25 mm	150 mm/min
32 mm	110 mm/min
38 mm	110 mm/min

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Ordering Information - Systems

ESAB Cutmaster 60i 3ph w. SL60QD 1Torch 6.1 m 75° Head	0559156304
ESAB Cutmaster 60i 3ph w. SL60QD 1Torch 15.2m 75° Head	0559156314
ESAB Cutmaster 60i 3ph Power Supply Only	0559356304
Torches	
SL60QD Torch and Lead 20' (6.1 m) 75° Head	7-5620
SL60QD Torch and Lead 50' (15.2 m) 75° Head	7-5650
SL60QD Torch Handle Assembly 75° Head (no leads)	7-5681
SL60QD Lead 20' (6.1 m)	4-5620
SL60QD Lead 50' (15.2 m)	4-5650
SL100 Mechanized Torch 5' (1.5 m) 180° Body	7-5213
SL100 Mechanized Torch 10' (3.0 m) 180° Body	7-5214
SL100 Mechanized Torch 25' (7.6 m) 180° Body	7-5215
SL100 Mechanized Torch 50' (15.2 m) 180° Body	7-5216

Packages Include: Cutmaster 60i power supply, SL60QD 75° torch with lead, 6.1 m work lead with ground clamp, spare parts kit, operating manual, and filter wrench.

Wear and Spare Parts 1Torch

Cutmaster Black Series Extended Life Electrode	9-8214
Start Cartridge	9-8213
Standoff Guide	9-8281
Shield Cup	9-8218
Shield Cup Max Life	9-8237
Shield Cap Gouging	9-8241
Shield Cap (Drag only)	9-8235
Shield Cap Deflector	9-8243
Tip – Drag (60 A)	9-8252
Tip – Standoff (60 A)	9-8210
Tip – “A” Gouging, (40 A Max), Profile: Shallow/Narrow	9-8225
Tip – “B” Gouging, (50 – 100 A), Profile: Deep/Narrow	9-8226
Tip – “C” Gouging, (60 – 120 A), Profile: Moderate/Moderate	9-8227
Tip – “D” Gouging, (60 – 120 A), Profile: Shallow/Wide	9-8228

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Options & Accessories	
Cutmaster MechPak, 25ft. (7.6 m)	7-7725
Cutmaster MechPak, 50ft. (15.2 m)	7-7750
Cutmaster Black Series Wear Parts Kit	5-0061
Cutting Guide Kit (Deluxe)	7-8910
Circle Cutting Guide Kit	7-3291
Filter Wrench	9-9675
Hand Pendant Extension 25 ft. (7.6 m)	7-7744
Lead Extension, 15 ft. (4.6 m)	7-7544
Lead Extension, 25 ft. (7.6 m)	7-7545
Lead Extension, 50 ft. (15.2 m)	7-7552
Leather Lead Covers 20 ft. (6.1 m)	9-1260
Multi-Purpose Cart	7-8888
Radius/Roller Cutting Guide Kit	7-7501
Remote Pendant Control 20 ft. (6.1 m)	7-3460
Single Stage Air Filter Kit	7-7507
Straight Line Cutting Guide	7-8911
Two Stage Air Filter Kit	9-9387
Work Cable #8 with Ground Clamp and 50 mm Plug	9-9692

1 Torch Consumables Parts Application Guide



Drag Tip Cutting

The preferred method of cutting light gauge metal up to 6 mm thickness. Produces the best cut quality narrowest kerf width, fastest cutting speeds, and with little to no distortion. Traditional drag cutting was limited to 40 A or less; now with Thermal Dynamics TRUE Cut Drag Tip Series™ technology, it is possible to cut up to 60 A. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 A).



Drag Shield Cutting

This is an operator-friendly method of cutting while maintaining a constant standoff distance. For metal thickness greater than 6 mm, simply drag the shield cap in contact with the work piece. Use the shield cup body with the appropriate drag shield cap matching the current level being used. This method is not recommended for cutting light-gauge sheet metal.



Standoff Cutting

The preferred method of cutting metal thicker than 6 mm and at current levels above 60 A. Provides maximum visibility and accessibility. Shield cup for 'standoff' cutting (with the torch tip 3 mm to 6 mm from the work piece). Use the shield cup body together with the deflector for extended parts life and improved resistance to reflect heat. This combination provides cutting results similar to the single piece shield cup, as well as easy changeover to gouging or drag shield cutting.



Gouging

A simple method of metal removal by angling the torch to a lead angle of 35°-45°, and using a gouging tip. While maintaining a constant standoff distance, this allows for only a partial penetration into the work, thus removing metal from the surface. The amount of current, travel speed, standoff distance, lead angle, and tip size will determine the amount of material removed and the profile of the gouge. You can use the shield cup body with either the gouging shield cap or the shield deflector. Also, you can use the single piece shield cup.



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