

Title (en)
METHOD FOR PLASMA-OXYACETYLENE CUTTING FERROUS METALS

Title (de)
PLASMA-SAUERSTOFFSCHNEIDVERFAHREN VON EISENMETALLEN

Title (fr)
PROCEDE D OXYCOUPAGE PLASMA DES METAUX FERREUX

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EP 1480776 A1 20041201 (FR)

Application
EP 03712260 A 20030117

Priority
• FR 0300156 W 20030117
• FR 0202140 A 20020220

Abstract (en)
[origin: WO03070413A1] Disclosed is a method for operating an installation used for plasma-oxyacetylene cutting metallic workpieces that contain at least one ferrous material. Said installation comprises a central nozzle (1) delivering an oxygen-containing gas stream for cutting, an intermediate nozzle (2) used as an electrode (9), which is coaxially aligned with the central nozzle (1) and delivers a first annular plasma jet, and a peripheral nozzle (3) which delivers a second annular plasma jet and is coaxially aligned with the intermediate nozzle (2). The workpiece is preheated in an initiation area, pierced across the entire thickness of the workpiece to be cut, and then cut according to a desired cutting kerf. The nozzle (1) is electrically insulated from the electrode (2) and from any other part of the installation having the same potential as the electrode while the inventive method is carried out.

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