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RIVERWELD C1376 C1371

RIVERWELD Plasma Electrode and Tip User Manual

Models: C1376 Electrodes & C1371 Tips

INTRODUCTION

This manual provides essential information for the proper use, installation, and maintenance of RIVERWELD C1376 Plasma Electrodes and C1371 Plasma Tips. These consumables are designed for use with specific CEBORA plasma cutting systems, including models CP160, HP100, MP100, CB100, and CB150. Adhering to these guidelines will ensure optimal performance and extend the lifespan of your consumables.

PRODUCT OVERVIEW

The RIVERWELD C1376 Plasma Electrodes and C1371 Plasma Tips are critical components for plasma cutting operations. They are manufactured from copper, ensuring good electrical conductivity and heat resistance. This package includes 10 pieces of C1376 electrodes (equivalent to CB100 CB150 PR0034) and 10 pieces of C1371 tips (equivalent to CB100 CB150 PD0026-11), totaling 20 consumables.



An assortment of RIVERWELD C1376 Plasma Electrodes (top row) and C1371 Plasma Tips (bottom rows), showcasing the complete set of 20 consumables included in the package.



A detailed view of multiple RIVERWELD C1376 Plasma Electrodes, highlighting their copper construction and threaded base for secure fitting.



A close-up shot of several RIVERWELD C1371 Plasma Tips, showing their conical shape and precise orifice for plasma arc formation.

SPECIFICATIONS

Attribute	Detail
Product Name	Plasma Electrodes and Tips
Brand	RIVERWELD
Model Numbers	C1376 (Electrodes), C1371 (Tips)
Compatible Plasma Cutters	CEBORA CP160, HP100, MP100, CB100, CB150
Electrode Reference	C1376 (Equivalent to CB100 CB150 PR0034)
Tip Reference	C1371 (Equivalent to CB100 CB150 PD0026-11)
Material	Copper
Quantity	20 pieces (10 electrodes, 10 tips)
Item Weight	300 grams

INSTALLATION AND REPLACEMENT

Proper installation of electrodes and tips is crucial for safe and effective plasma cutting. Always refer to your plasma cutter's specific instruction manual for detailed torch disassembly and reassembly procedures. The following steps provide general guidance:

1. **Safety First:** Ensure the plasma cutter is completely powered off and disconnected from the power source before attempting any maintenance or consumable replacement.
2. **Cool Down:** Allow the torch to cool down completely if it has been recently used. Hot components can cause severe burns.
3. **Disassemble Torch:** Carefully unscrew or unclip the torch head components according to your plasma cutter's manual. This typically involves removing the shield cup, retaining cap, and then the old tip and electrode.
4. **Inspect Components:** Before installing new consumables, inspect the torch body for any damage, debris, or excessive wear. Clean if necessary.
5. **Install New Electrode:** Insert the new RIVERWELD C1376 electrode into its designated slot in the torch. Ensure it is seated firmly and correctly.
6. **Install New Tip:** Place the new RIVERWELD C1371 tip over the electrode. Ensure the tip's orifice is clear and undamaged.
7. **Reassemble Torch:** Reattach the retaining cap and shield cup, ensuring all components are securely tightened but not overtightened. Overtightening can damage threads or components.
8. **Functionality Check:** After reassembly, perform a quick visual check to ensure all parts are correctly aligned.



A single RIVERWELD C1376 Plasma Electrode, showing its precise design for optimal electrical contact and arc initiation.



A single RIVERWELD C1371 Plasma Tip, illustrating its conical shape and the small, precise orifice through which the plasma arc exits.

OPERATING GUIDELINES

Once the new consumables are installed, you can resume plasma cutting operations. Always follow the safety precautions and operating instructions provided with your plasma cutting machine. The performance of these consumables is directly linked to proper machine settings and cutting techniques.

- **Correct Amperage:** Use the recommended amperage settings for the material thickness you are cutting. Using too high an amperage for a given tip size can lead to premature wear.
- **Proper Standoff Distance:** Maintain the correct standoff distance between the torch tip and the workpiece. Too close or too far can affect cut quality and consumable life.
- **Clean Air Supply:** Ensure your plasma cutter has a clean, dry, and oil-free air supply. Contaminants in the air can significantly reduce consumable lifespan and cut quality.
- **Cutting Speed:** Adjust your cutting speed to achieve a clean, dross-free cut. Incorrect speed can cause excessive wear on the tip.
- **Consumable Wear:** Monitor the condition of your electrode and tip regularly. Replace them when the electrode's hafnium insert is significantly pitted or the tip's orifice is enlarged or oval-shaped.

MAINTENANCE AND STORAGE

Proper maintenance and storage of your plasma consumables will help preserve their quality and readiness for use.

- **Regular Inspection:** Before and after each cutting session, visually inspect the electrode and tip for signs of wear, pitting, or damage.
- **Cleaning:** If necessary, gently clean the exterior of the consumables with a soft cloth. Avoid using abrasive materials or tools that could scratch or deform the precision components.
- **Storage:** Store unused electrodes and tips in a dry, clean environment, preferably in their original packaging or a sealed container, to protect them from moisture and dust.
- **Handling:** Handle consumables with clean hands or gloves to prevent contamination from oils or dirt, which can affect performance.

TROUBLESHOOTING COMMON ISSUES

Many common plasma cutting issues can be resolved by checking or replacing consumables. Here are some typical problems and their potential solutions:

Problem	Possible Cause	Solution
Poor Cut Quality / Excessive Dross	Worn tip orifice, incorrect cutting speed, improper amperage.	Replace tip, adjust cutting speed, verify amperage settings.
Short Consumable Life	Contaminated air supply, incorrect standoff distance, excessive piercing.	Check air filter/dryer, maintain proper standoff, reduce piercing frequency or use proper piercing technique.
No Arc / Intermittent Arc	Worn electrode, loose connections, damaged torch components.	Replace electrode, ensure all torch components are securely tightened, inspect torch for damage.
Torch Overheating	Incorrect consumables, insufficient cooling (if applicable to torch model).	Ensure correct consumables are used for your torch model, check cooling system (if liquid-cooled).

If issues persist after checking and replacing consumables, consult your plasma cutter's user manual or contact the manufacturer's support.

WARRANTY AND SUPPORT

As consumables, these electrodes and tips are subject to wear during normal operation and do not typically carry a long-term warranty against wear. However, they are guaranteed to be free from manufacturing defects upon receipt. For any questions regarding product compatibility, installation, or performance, please contact RIVERWELD customer support through the retailer where the product was purchased or visit the official RIVERWELD store online. Please have your product model numbers (C1376, C1371) and purchase information ready when contacting support.

You can find more information about RIVERWELD products and support at the [RIVERWELD Store](#).