

## Cutting Chart

The following conditions are intended to give the operator the best starting point to use when making a cut on a particular material type and thickness and may not reflect optimum conditions. Different metal compositions, consumable parts wear, and air quality will affect the cutting speeds and torch height.

Material Type	Material Thickness		Arc Current (amps)	Torch Height		Travel Speed		Grate Cutting Travel Speed	
	(inches/GA)	(mm)		(inches)	(mm)	(ipm)	(mm/min)	(ipm)	(mm/min)
Galvanized	.019 / 28	.5	35	1/16	1.5	450	11,430	235	5,970
Galvanized	.022 / 26	.6	35	1/16	1.5	400	10,160	210	5,335
Galvanized	.028 / 24	.7	35	1/16	1.5	325	8,255	170	4,320
Galvanized	.034 / 22	.9	40	1/16	1.5	300	7,620	155	3,935
Galvanized	.040 / 20	1.0	45	1/16	1.5	285	7,240	150	3,810
Galvanized	.052 / 18	1.3	45	1/16	1.5	220	5,590	115	2,920
Galvanized	.063 / 16	1.6	45	1/16	1.5	200	5,080	105	2,665
Mild Steel	1/16	1.6	45	1/16	1.5	275	6,985	135	3,430
Mild Steel	1/8	3.2	45	1/16	1.5	130	3,300	65	1,650
Mild Steel	1/4	6.4	45	.075	2.0	45	1,145		
Mild Steel	3/8	9.5	45	.075	2.0	25	635		
Mild Steel	1/2	12.7	45	.075	2.0	15	380		
Stainless	.015 / 28	.4	35	1/16	1.5	425	10,795	220	5,590
Stainless	.018 / 26	.5	35	1/16	1.5	400	10,160	210	5,335
Stainless	.024 / 24	.6	35	1/16	1.5	375	9,525	195	4,955
Stainless	.030 / 22	.8	35	1/16	1.5	350	8,890	180	4,570
Stainless	.036 / 20	.9	35	1/16	1.5	325	8,255	170	4,320
Stainless	.048 / 18	1.2	45	1/16	1.5	300	7,620	155	3,935
Stainless	1/16	1.6	45	1/16	1.5	250	6,350	125	3,175
Stainless	1/8	3.2	45	1/16	1.5	110	2,795	55	1,395
Stainless	1/4	6.4	45	.075	2.0	35	890		
Stainless	3/8	9.5	45	.075	2.0	20	510		
Stainless	1/2	12.7	45	.075	2.0	10	255		
Aluminum	1/32	.8	35	.075	2.0	350	8,890	180	4,570
Aluminum	1/16	1.6	35	.075	2.0	250	6,350	130	3,300
Aluminum	3/32	2.4	45	.075	2.0	150	3,810	75	1,905
Aluminum	1/8	3.2	45	.125	3.2	100	2,540	50	1,270
Aluminum	1/4	6.4	45	.125	3.2	30	760		

1 inch = 25.4 mm; 1 psi = .0689 bar = 6.895 KPa

With the Gas switch in the Set position, adjust the regulator on the rear panel to 65 psi.