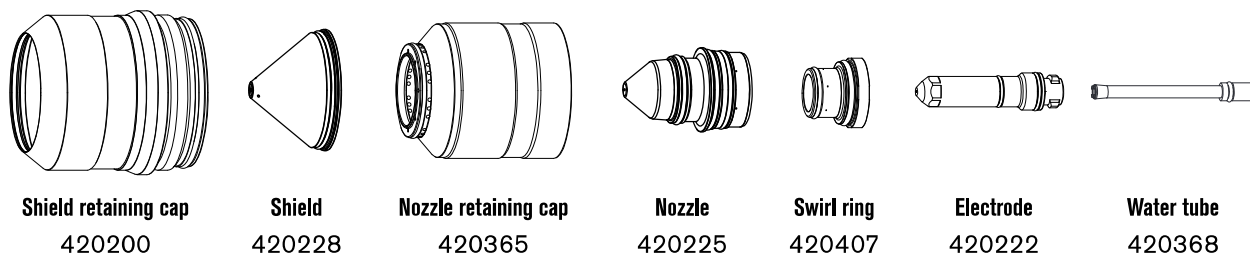


Cut charts for ferrous (mild steel) processes – above water

Mild steel – 30 A – O₂ Plasma / O₂ Shield – above water (Core™, VWI™, OptiMix™)



Flow rate (lpm/scfh)		
	N ₂	O ₂
Pre flow	20/43	19/40
Pierce flow	20/43	19/40
Cut flow	–	27/58

Metric

Material thickness	Cut category	SYSTEM SETTINGS				CNC SETTINGS							
		XPR Process ID	Shield pierce setting	Cutflow		Cut speed	Arc voltage	Transfer height	Pierce height	Pierce delay	Cut height	Kerf compensation	
				Plasma gas	Shield gas								mm/min
0.5	3	1051	28	76	24	5348	106	2.54	2.54	0.1	1.30	1.5	
0.8						4217	107					0.2	1.5
1						3604	108						0.3
1.2						2847	109	3.05	3.05	0.4		1.5	
1.5						2198	111					1.6	
2						1490	116					0.5	1.7
2.5	1325	116	1.52	1.7									
3	1	2		1153	117	0.6	1.8						
4	908		120	3.37	3.37	0.7	1.9						
5	521		123	3.81	3.81	0.7	2.0						