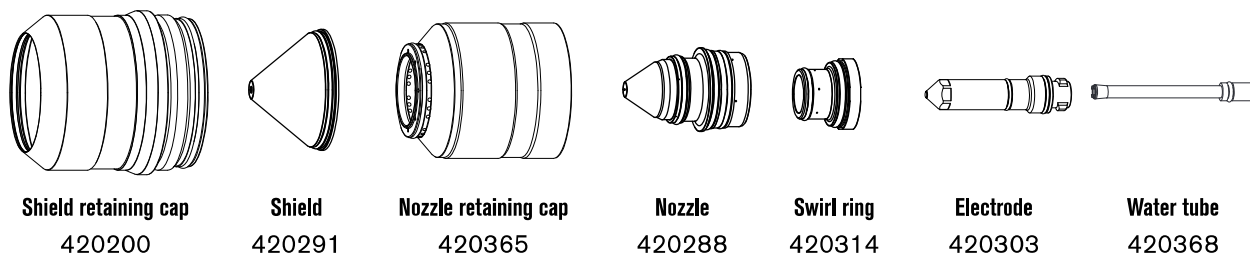


Cut charts for non-ferrous (stainless steel) processes – above water

Stainless steel – 40 A – N₂ Plasma / N₂ Shield – above water (Core, VWI, OptiMix) HDi



Flow rate (lpm/scfh)	
N ₂	
Pre flow	49 / 103
Pierce flow	57 / 120
Cut flow	71 / 152

Metric

Material thickness mm	Cut category	SYSTEM SETTINGS				CNC SETTINGS						
		XPR process ID	Shield pierce setting	Cutflow		Cut speed mm/min	Arc voltage volts	Transfer height mm	Pierce height mm	Pierce delay seconds	Cut height mm	Kerf compensation mm
				Plasma gas	Shield gas							
0.8	3	2015	30	75	85	6100	124	5.08	5.08	0.2	3.60	1.4
1						5715	124				3.50	1.3
1.2						5345	124				3.40	1.3
1.5						4818	122				3.30	1.2
2						4014	127				3.10	1.2
2.5	1	2014		90	68	3302	129			0.3	2.90	1.2
3						2683	130				2.80	1.3
4						1724	129				2.60	1.3
5	2	2013		90	64	1136	129			0.6	2.54	1.3
6		2012				55	918					132