

Low Speed FineCut
Mild Steel

Air flow rate – slpm/scfh	
Hot	155 / 330
Cold	215 / 460

Metric

Material Thickness	Current	Torch-to-Work Distance	Initial Pierce Height		Pierce Delay Time	Recommended	
						Cut Speed	Voltage
mm	A	mm	mm	%	seconds	(mm/min)	Volts
0.5	30	1.5	2.25	150	0.0	3800	69
0.6						3800	68
0.8						3800	70
1 *	40				0.2	3800	72
1.5 *						3800	75
2	45					0.4	3700
3					0.5		2750
4						1900	78

English

Material Thickness	Current	Torch-to-Work Distance	Initial Pierce Height		Pierce Delay Time	Recommended	
						Cut Speed	Voltage
	A	inches	inches	%	seconds	ipm	Volts
26GA	30	0.06	0.09	150	0.0	150	70
24GA						150	68
22GA					0.1	150	70
20GA						150	71
18GA	40				0.2	150	73
16GA *					0.4	150	75
14GA *	150					76	
12GA	45				0.5	120	78
10GA						95	78

*Not a dross-free cut.

TORCH SETUP

Low Speed FineCut
Stainless Steel

Air flow rate – slpm/scfh	
Hot	155 / 330
Cold	215 / 460

Metric

Material Thickness	Current	Torch-to-Work Distance	Initial Pierce Height		Pierce Delay Time	Recommended	
						Cut Speed	Voltage
mm	A	mm	mm	%	seconds	(mm/min)	Volts
0.5	30	0.5	2.0	400	0.0	3800	69
0.6						3800	69
0.8					0.1	3800	69
1	40				0.15	3800	69
1.5					0.4	2900	69
2						2750	69
3	45				0.5	2550	80
4					0.6	1050	80

English

Material Thickness	Current	Torch-to-Work Distance	Initial Pierce Height		Pierce Delay Time	Recommended	
						Cut Speed	Voltage
	A	in	in	%	seconds	ipm	Volts
26GA	30	0.02	0.08	400	0.0	150	69
24GA						150	69
22GA					0.1	150	69
20GA						150	69
18GA	40				0.2	145	69
16GA					0.4	115	69
14GA						110	69
12GA	45				0.5	120	80
10GA					0.6	75	80