

Cutting Speed Chart

This cutting speed chart includes preliminary data and is subject to change without notice.

Torch Model		XT™-301			
Conventional Plasma Capacity		5/8" (15mm) Piercing / 1" (25mm) Maximum (Edge Start)			
Material	Thickness [inch]	Average Cut Speed [IPM]	Current [Amps]	Thickness [mm]	Average Cut Speed [mm/min]
Mild Steel					
Plasma (Air)	21 ga.	500	55	.8	12700
Shield (Air)	10 ga.	190		3	4826
	3/16	130		5	3302
Plasma (O2)	21 ga.	600	55	.8	15240
Shield (Air)	10 ga.	180		3	4572
	3/16	120		5	3048
Plasma (Air)	1/4	150	100	6	3810
Shield (Air)	3/8	85		10	2159
	1/2	75		12	1905
	3/4	30		20	762
	1	20		25	508
Plasma (O2)	1/4	130	100	6	3302
Shield (Air)	1/2	57		12	1448
	3/4	25		20	635
	1	10		25	254
Stainless Steel					
Plasma (Air)	16 ga.	350	55	1.5	8890
Shield (Air)	10 ga.	100		4	2540
	3/16	60		5	1524
	1/4	100	100	6	2540
	3/8	65		10	1651
	1/2	45		12	1143
Plasma (N2)	1/4	60	100	6	1524
Shield (H2O)	3/8	50		10	1270
	1/2	35		12	889
Plasma (Ar-H2)	3/8	50	100	10	1270
Shield (N2)	1/2	37		12	940
Aluminum					
Plasma (Air)	16 ga.	400	55	1.5	10160
Shield (Air)	3/16	100		5	2540
	1/4	100	100	6	2540
	1/2	45		12	1143
	3/4	35		20	889
Plasma (N2)	1/4	60	100	6	1524
Shield (H2O)	3/8	50		10	1270
	1/2	35		12	889
Plasma (Ar-H2)	3/8	60	100	10	1524
Shield (N2)	1/2	40		12	1016

Note: Take care in comparison. The speeds noted above are best cut speeds. Although much higher speeds can be achieved, edge quality and bevel angle may be compromised. The capabilities shown in this table were obtained by using new consumables, published speeds, gas settings and current, accurate torch height control and with torch perpendicular to the workpiece.