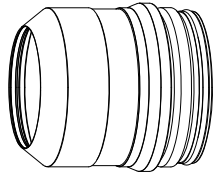
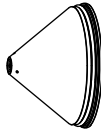


Cut charts for ferrous (mild steel) processes – above water

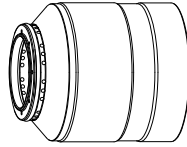
Mild steel – 50 A – O₂ Plasma / Air Shield – above water (Core™, VWI™, OptiMix™)



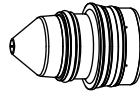
Shield retaining cap
420200



Shield
420237



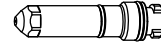
Nozzle retaining cap
420365



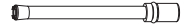
Nozzle
420234



Swirl ring
420233



Electrode
420231



Water tube
420368

	Flow rate (lpm/scfh)		
	N ₂	O ₂	Air
Pre flow	20 / 42	–	35 / 74
Pierce flow	20 / 42	–	35 / 74
Cut flow	–	24 / 52	31 / 67

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										
2.4	3	1060	50	72	44	4354	113	3.05	3.05	0.4	1.52	1.5			
2.5						4262	113					1.5			
3						3820	113					1.5			
3.5	1					72	30					3616	112	0.5	1.5
4												3144	113		1.6
5												2322	115		1.7
6	2	1061	30	30	1919	117	4.06	4.06	0.6	2.03	1.7				
7					1622	119					1.8				
8					1369	120					0.7	1.8			

Mild steel – 50 A – O₂ Plasma / Air Shield – above water (Core, VWI, OptiMix) (continued)

English

Material thickness in	Cut category	SYSTEM SETTINGS				CNC SETTINGS						
		XPR process ID	Shield pierce setting	Cutflow		Cut speed in/min	Arc voltage volts	Transfer height in	Pierce height in	Pierce delay seconds	Cut height in	Kerf compensation in
				Plasma gas	Shield gas							
0.105 (12GA)	3	1060	50	72	44	155	113	0.120	0.120	0.4	0.060	0.06
0.135 (10GA)	1					145	112			0.5		0.06
3/16	2	1061	50	72	30	95	114	0.160	0.160	0.6	0.080	0.07
1/4						70	118			0.7		0.07
5/16						55	120			0.7		0.07

Marking

	Plasma gas	Shield gas	Process ID	Mark current	Cutflow		Marking height	Marking speed	Arc voltage	Mark widths
					Plasma gas	Shield gas				
Metric	N ₂	N ₂	8001	15	10	10	2.54 mm	6350 mm/min	118 V	2.0 mm
English	N ₂	N ₂	8001	15	10	10	0.100 in	250 in/min	118 V	0.08 in

	Plasma gas	Shield gas	Process ID	Mark current	Cutflow		Marking height	Marking speed	Arc voltage	Mark widths
					Plasma gas	Shield gas				
Metric	Ar	Air	9018	12	70	10	2.54 mm	2540 mm/min	81 V	1.3 mm
English	Ar	Air	9018	12	70	10	0.100 in	100 in/min	81 V	0.05 in

