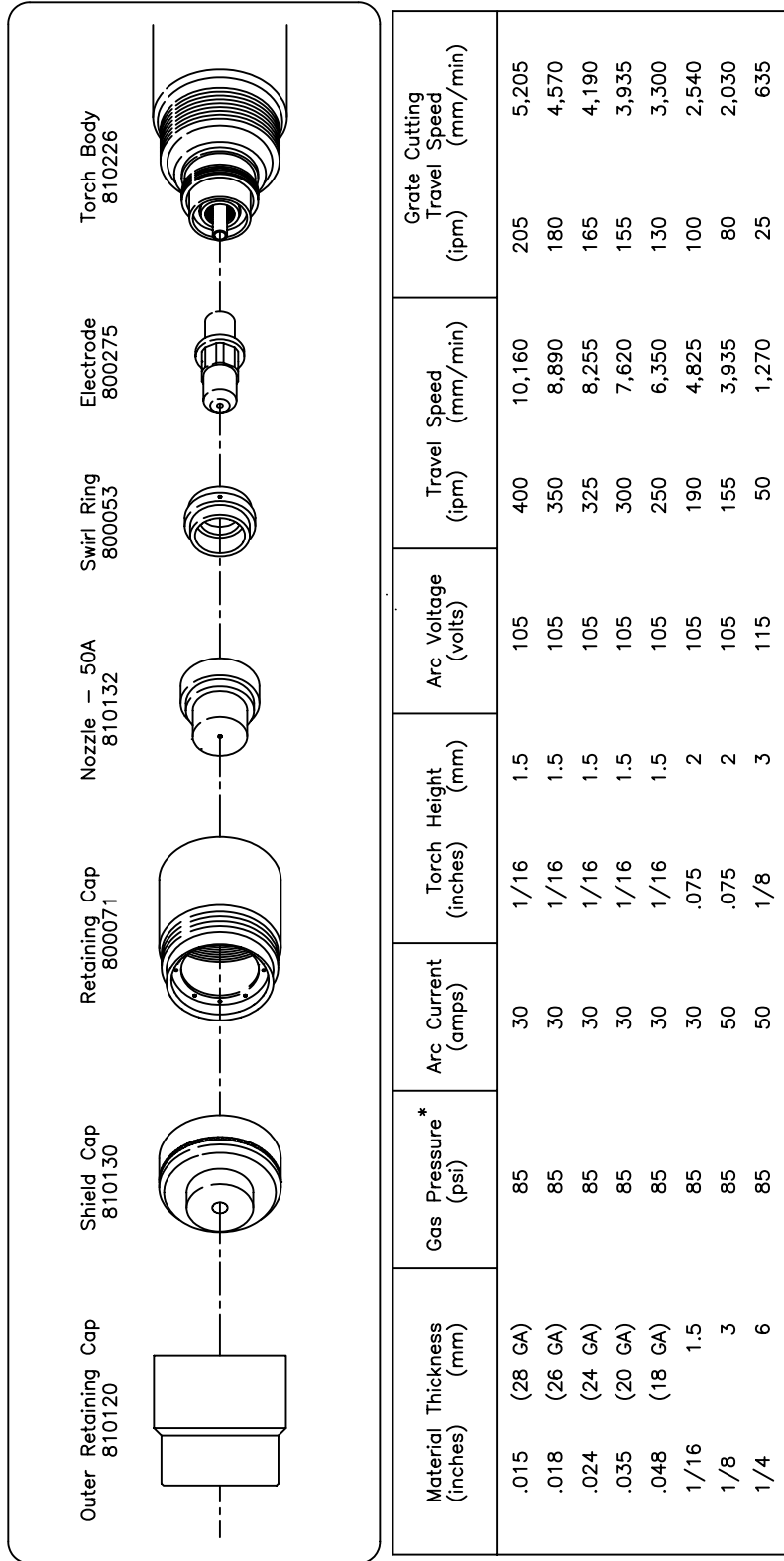


Cutting Charts

The following conditions are intended to give the operator the best starting point to use when making a cut on a particular material type and thickness and may not reflect optimum conditions. Different metal compositions, consumable parts wear, and air quality will affect the cutting speeds and torch height.

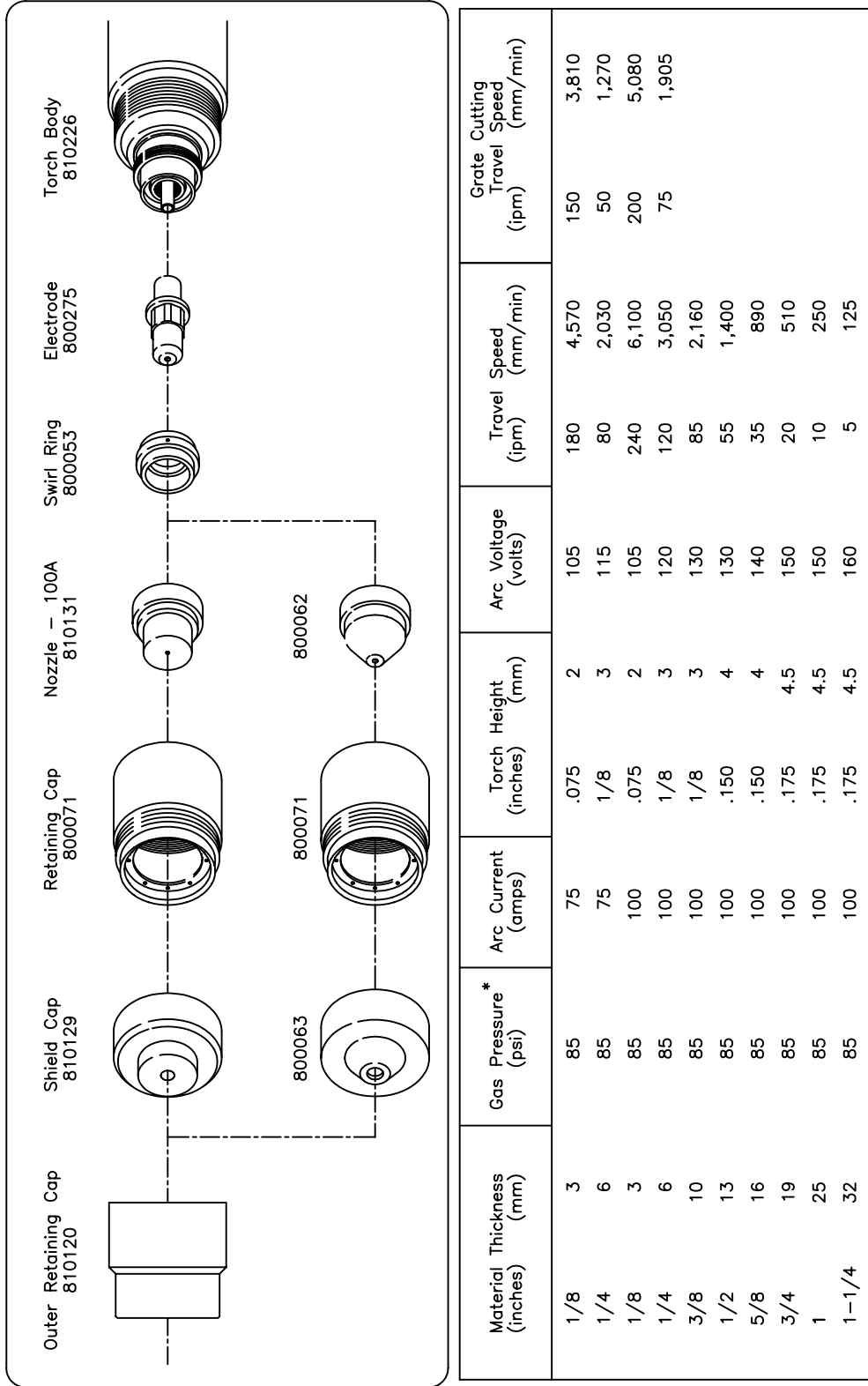
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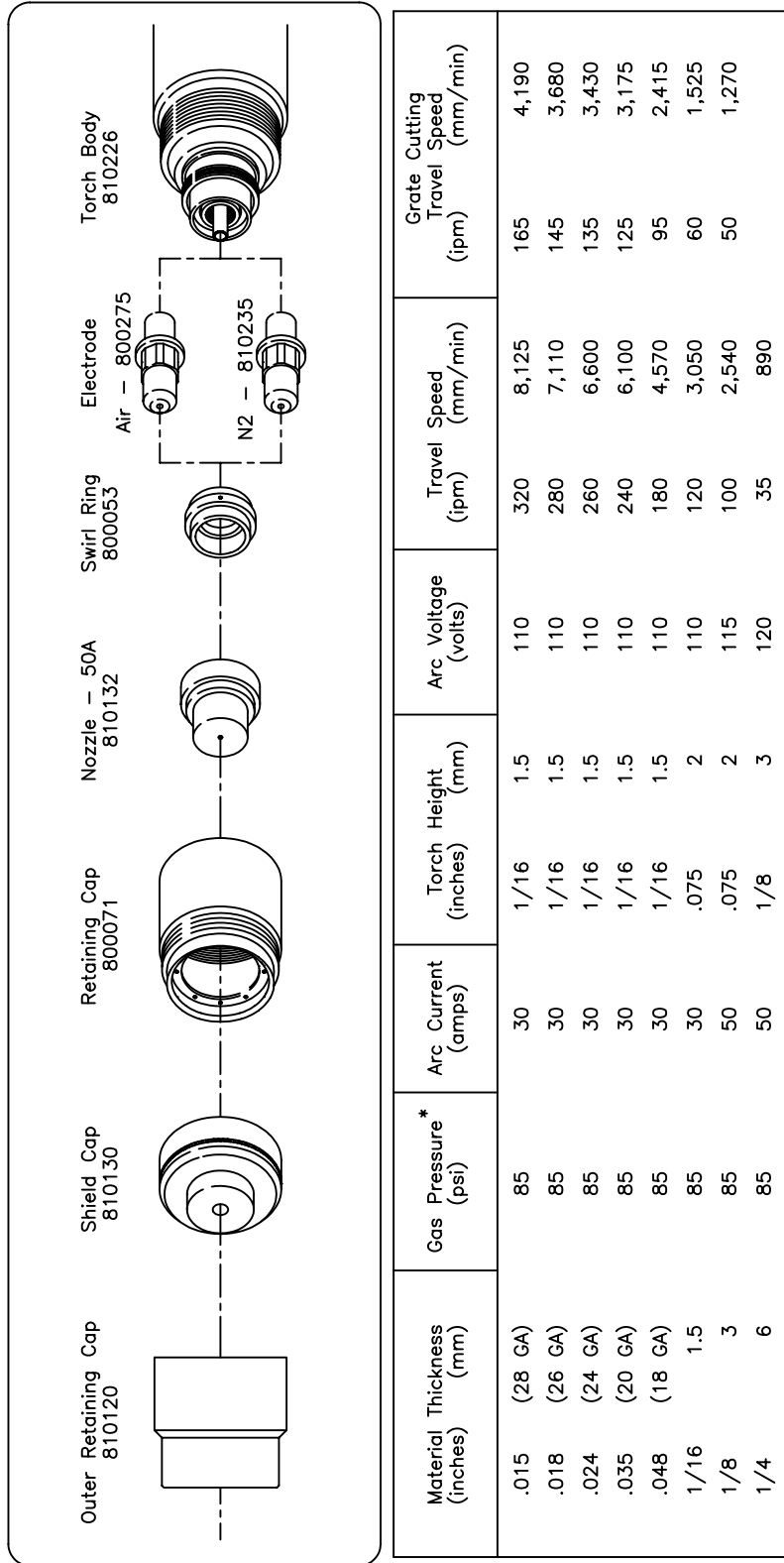
* Gas pressure with set/run switch in the set position
 1 inch = 25.4 mm; 1 psi = .0689 bar = 6.895 KPa

Figure 4-4 Mild Steel Cutting Chart (30-50 amps)



* Gas pressure with set/run switch in the set position
 1 inch = 25.4 mm; 1 psi = .0689 bar = 6.895 KPa

Figure 4-5 Mild Steel Cutting Chart (75-100 amps)



* Gas pressure with set/run switch in the set position

1 inch = 25.4 mm; 1 psi = .0689 bar = 6.895 KPa

Note: When using nitrogen as the cutting gas, the speeds and arc voltages will be slightly different than shown in the chart.

Figure 4-6 Stainless Steel Cutting Chart (30-50 amps)

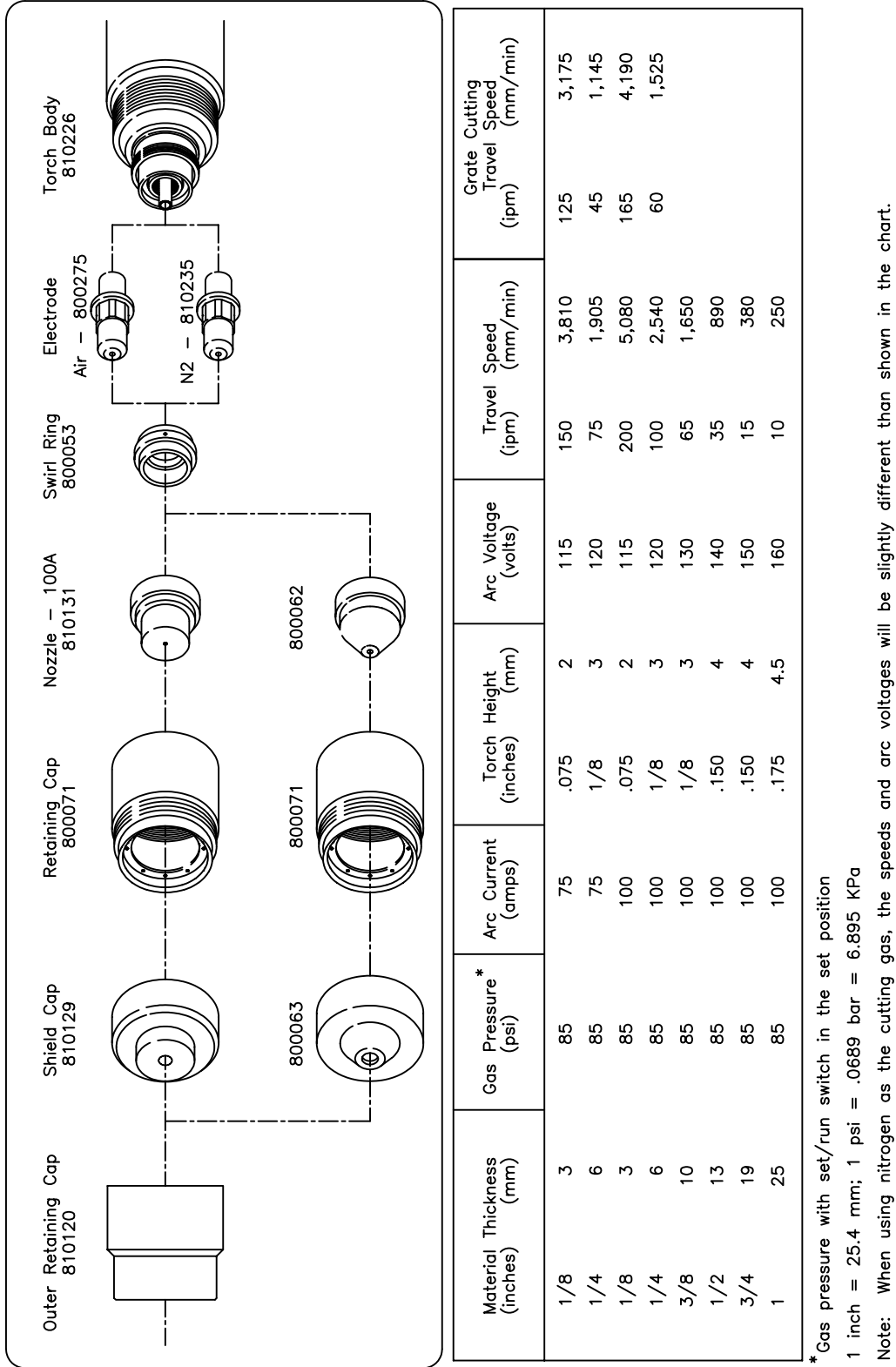
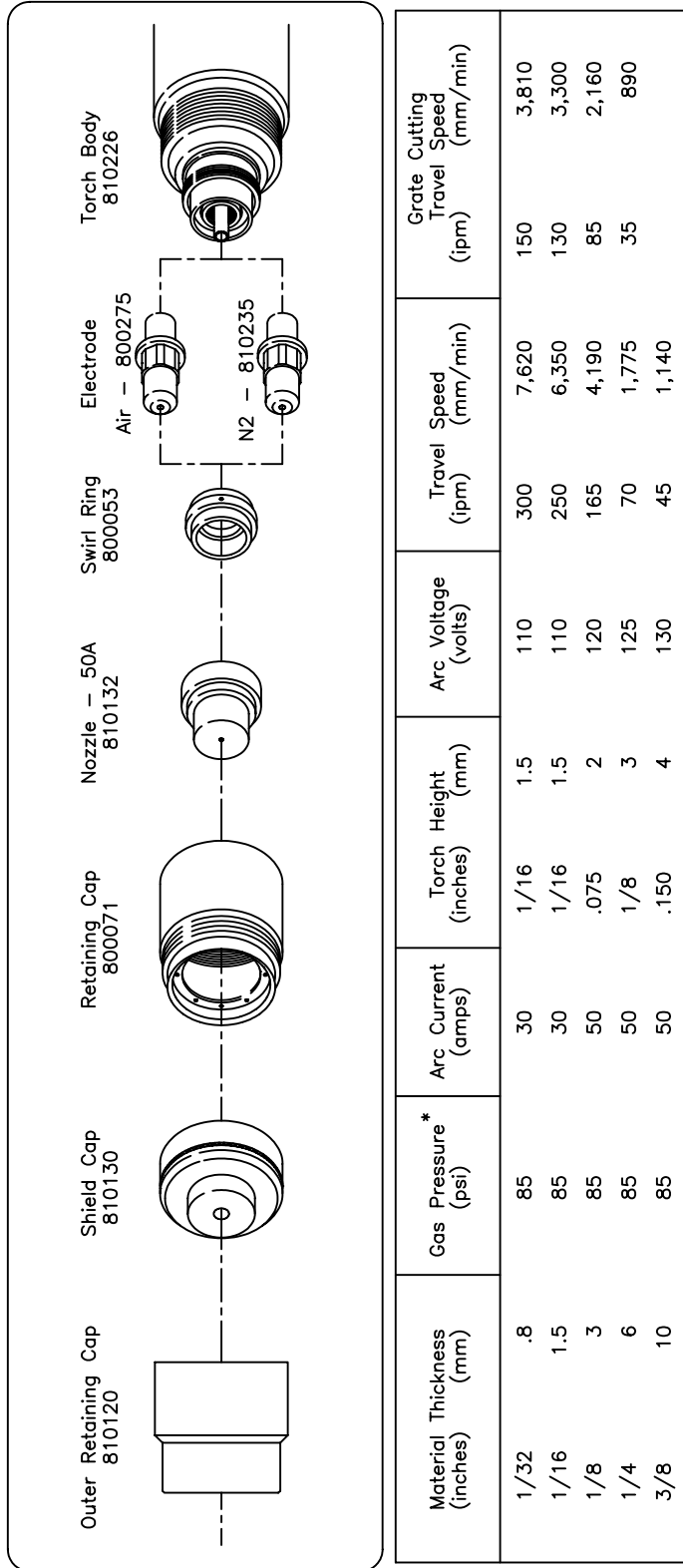


Figure 4-7 Stainless Steel Cutting Chart (75-100 amps)

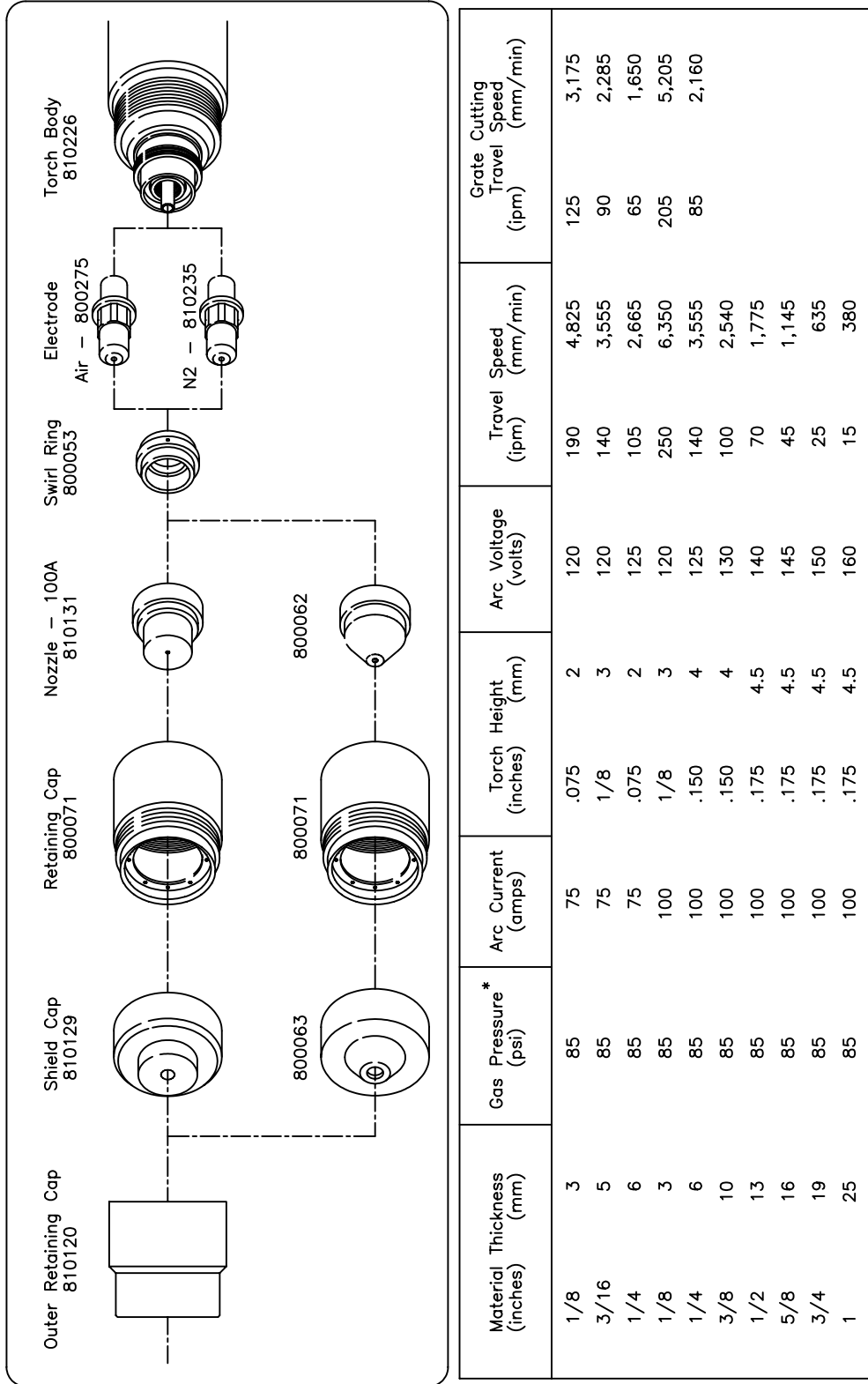


* Gas pressure with set/run switch in the set position

1 inch = 25.4 mm; 1 psi = .0689 bar = 6.895 KPa

Note: When using nitrogen as the cutting gas, the speeds and arc voltages will be slightly different than shown in the chart.

Figure 4-8 Aluminum Cutting Chart (30-50 amps)



* Gas pressure with set/run switch in the set position

1 inch = 25.4 mm; 1 psi = .0689 bar = 6.895 KPa

Note: When using nitrogen as the cutting gas, the speeds and arc voltages will be slightly different than shown in the chart.

Figure 4-9 Aluminum Cutting Chart (75-100 amps)