

Cut charts

The following *Cut charts* show the consumable parts, cutting speeds and the gas and torch settings required for each process.

The numbers shown in the *Cut charts* are recommended to provide high-quality cuts with minimal dross. Because of differences between installations and material composition, adjustments may be required to obtain desired results.

Bevel cutting

See *Appendix C* in this manual for cut charts and consumables.

Marking

Any of the consumable sets can also be used for marking. Marking parameters are shown at the bottom of each cut chart. The quality of the markings will vary depending on the cut process, material type, and material thickness combination. Marking is not possible for every combination (very thin materials). Poor quality marking or burn-through may occur with material less than 1.5 mm (0.060 in or 16 gauge).

Consumables for mirror-image cutting

See the *Parts List* section in this manual for part numbers.

Estimated kerf-width compensation

The widths in the chart below are for reference. Differences between installations and material composition may cause the specific user results to vary from those shown in the table.

Metric

Process	Thickness (mm)						
	1.5	3	6	10	12	20	25
MS							
130A O ₂ / Air			1.803	2.032	2.108	2.642	3.429
80A O ₂ / Air		1.372	1.727	1.905			
50A O ₂ / O ₂	1.516	1.740	1.854				
30A O ₂ / O ₂	1.346	1.448					
SS							
130A H35 / N ₂				2.718	2.769	2.896	
130A N ₂ / N ₂			1.829	1.879	2.413		
80A F5 / N ₂			1.194				
45A F5 / N ₂	0.584	0.381	0.533				
45A N ₂ / N ₂	0.483	0.229	0.152				
AL							
130A H35 / N ₂				2.718	2.769	2.896	
130A Air / Air			2.083	2.083	2.184		
45A Air / Air	1.067	1.092	1.245				

English

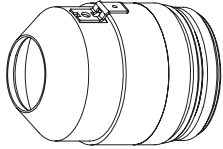
Process	Thickness (in)						
	0.060"	0.135"	1/4"	3/8"	1/2"	3/4"	1"
MS							
130A O ₂ / Air			0.071	0.080	0.083	0.104	0.135
80A O ₂ / Air		0.054	0.068	0.075			
50A O ₂ / O ₂	0.060	0.073	0.073				
30A O ₂ / O ₂	0.053	0.057					
SS							
130A H35 / N ₂				0.107	0.109	0.114	
130A N ₂ / N ₂			0.072	0.074	0.095		
80A F5 / N ₂			0.047				
45A F5 / N ₂	0.023	0.015	0.021				
45A N ₂ / N ₂	0.019	0.009	0.006				
AL							
130A H35 / N ₂				0.107	0.109	0.114	
130A Air / Air			0.082	0.082	0.086		
45A Air / Air	0.042	0.043	0.049				

OPERATION

Mild steel O₂ Plasma / O₂ Shield 30 A Cutting

Flow rates - lpm/scfh		
	O ₂	Air
Preflow	0 / 0	46 / 97
Cutflow	22 / 46	0 / 0

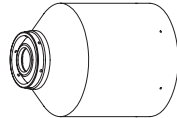
Note: Air must be connected to use this process. It is used as the preflow gas



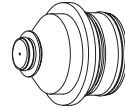
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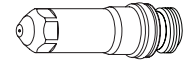
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time			
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts		mm	mm/m	mm
O ₂	O ₂	80	15	92	15	0.5	114	1.3	5355	2.3	180	0.1			
						0.8	115						0.2		
						1	116								
						1.2	117								
						1.5	119								
						2	120								
			35		5	2.5	122	1.5	1490	2.7		0.4			
						3*	123								
						4*	125								
						6*	128								
						75	5						1160	1160	0.5
													905	905	
665	665	1.0													

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time				
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts		in	ipm	in	factor %
O ₂	O ₂	80	15	92	15	.018	114	0.050	215	0.090	180	0.1				
						.024							200			
						.030								170		
						.036									155	
						.048										110
						.060										
			35		5	.075	120	0.060	60	0.110		0.4				
						.105	122									
						.135*	123									
						3/16*	128						40	30	0.5	
						1/4*										25
						25	25						1.0			

Marking

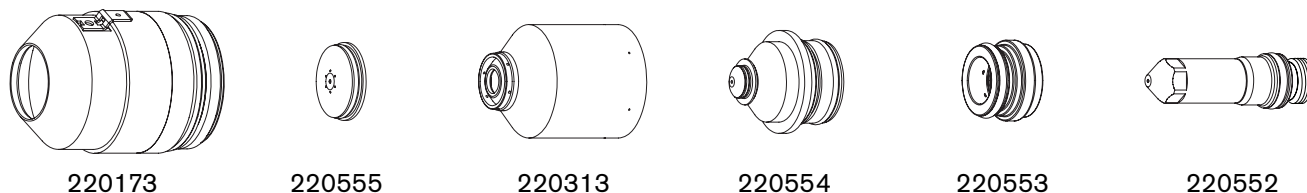
Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield		mm	in	mm/min	ipm	
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	105

*Pierce complete is recommended for these thicknesses

Mild steel
O₂ Plasma / O₂ Shield
50 A Cutting

Flow rates - lpm/scfh		
	O ₂	Air
Preflow	0 / 0	43 / 90
Cutflow	25 / 52	0 / 0

Note: Air must be connected to use this process. It is used as the preflow gas



Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
O ₂	O ₂	70	30	75	15	0.8	110	1.0	6500	2.0	200	0.0
						1	111		5000			
						1.2	112		4150			
						1.5	114	1.3	3200	2.6		0.1
						2	115		2700			
						2.5	117		2200			
						3	119	1.5	1800	3.0		0.2
						4	121		1400			
						5	122		1200			
						6	126	2.0	950	4.0		0.3
						7	128		780			
8	130	630										

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
O ₂	O ₂	70	30	75	15	.030	110	0.04	270	0.08	200	0.0
						.036			210			
						.048			160			
						.060	114	0.05	125	0.10		0.1
						.075	115		110			
						.105	118		80			
						.135	120	0.06	60	0.12		0.2
						3/16	121		50			
						1/4	125	0.08	35	0.16		0.3
						5/16	130		25			

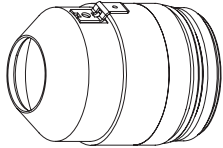
Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
N ₂	N ₂	10	10	10	10		Amps	mm	in	mm/min	
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	118

OPERATION

Mild steel O₂ Plasma / Air Shield 80 A Cutting

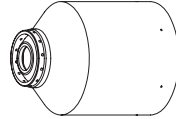
Flow rates - lpm/scfh		
	O ₂	Air
Preflow	0 / 0	76 / 161
Cutflow	23 / 48	41 / 87



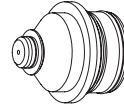
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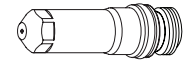
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time			
Plasma	Shield	Plasma	Shield	Plasma	Shield	mm	Volts	mm	mm/m	mm	factor %	seconds			
O ₂	Air	50	30	72	30	2	112	2.5	9810	3.8	150	0.1			
						2.5	115		7980						
						3	117		6145						
						4	120		4300						
						6	123		3045						
						10	127		1810						
					15	12	130	2.0	1410	4.0	200	0.3			
						15	133		1030			0.5			
						20	135		2.5			545	5.0	250	0.7
												6.3			0.8
											0.9				

English

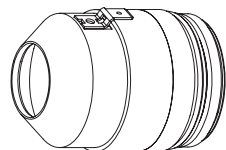
Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time		
Plasma	Shield	Plasma	Shield	Plasma	Shield	in	Volts	in	ipm	in	factor %	seconds		
O ₂	Air	50	30	72	30	.075	112	0.100	400	0.150	150	0.1		
						.105	115		290					
						.135	117		180					
						3/16	120		155					
						1/4	123		110				0.160	200
						3/8	127		75					
					15	1/2	130	0.080	50	0.200	250	0.7		
						5/8	133		37			0.8		
						3/4	135		0.100			25	0.250	0.9

Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
						Amps	mm	in	mm/min	ipm	Volts
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	130

Mild steel
O₂ Plasma / Air Shield
130 A Cutting

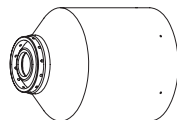
Flow rates - lpm/scfh		
	O ₂	Air
Preflow	0 / 0	102 / 215
Cutflow	33 / 70	45 / 96



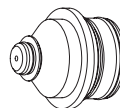
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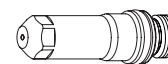
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
O ₂	Air	35	40	80	35	3	124	2.5	6505	5.0	200	0.1
						4	126	2.8	5550	5.6		0.2
						6	127		4035			0.3
					28	10	130	3.0	2680	6.0		0.5
						12	132	3.3	2200	6.6		0.7
						15	135	3.8	1665	7.6		1.0
			20	138	1050	190	1.8					
			65	25	141	4.0	550	Edge start				
				32	160	4.5	375					
				38	167		255					

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
O ₂	Air	35	40	80	35	.135	124	0.100	240	0.200	200	0.1
						3/16	126	0.110	190	0.220		0.2
						1/4	127		150			0.3
					28	3/8	130	0.120	110	0.240		0.5
						1/2	132	0.130	80	0.260		0.7
						5/8	135	0.150	60	0.300		1.0
			3/4	138	45	190	1.8					
			65	1	141	0.160	20	Edge start				
				1-1/4	160	0.180	15					
				1-1/2	167		10					

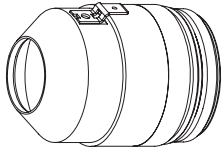
Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
N ₂	N ₂						Amps	mm	in	mm/min	ipm
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	130

OPERATION

Stainless steel N₂ Plasma / N₂ Shield 45 A Cutting

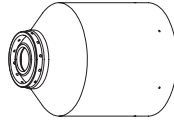
Flow rates - lpm/scfh	
N ₂	
Preflow	24 / 51
Cutflow	75 / 159



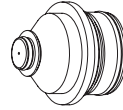
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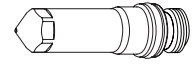
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
N ₂	N ₂	35	5	55	60	0.8	94	2.5	6380	3.8	150	0.0
						1			5880			0.1
						1.2			5380			0.2
						1.5	4630					
						2	3935					
						2.5	3270					
						3	2550					
						4	1580		0.3			

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
N ₂	N ₂	35	5	55	60	.036	94	0.100	240	0.150	150	0.0
						.048			210			0.1
						.060	95		180			0.2
						.075	97		160			
						.105	101		120			
						.135	103		75			

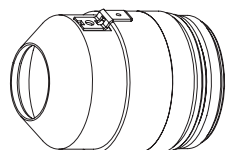
Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield		mm	in	mm/min	ipm	
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	85

Note: This process produces a darker cut edge than the 45 A, F5/N₂ stainless steel process

Stainless steel
F5 Plasma / N₂ Shield
45 A Cutting

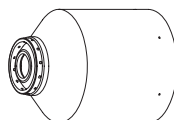
Flow rates - lpm/scfh		
	F5	N ₂
Preflow	0 / 0	43 / 91
Cutflow	8 / 17	65 / 138



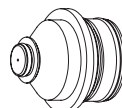
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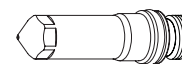
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
F5	N ₂	35	25	55	60	0.8	99	2.5	6570	3.8	150	0.2
						1			5740			
						1.2			4905			
						1.5			3890			
						2	3175					
						2.5	2510					
						3	2010					
					4	1435	0.3					
15	6	110	2.0	845	190	0.5						

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
F5	N ₂	35	25	55	60	.036	99	0.100	240	0.150	150	0.2
						.048			190			
						.060			150			
						.075			130			
						.105	90					
						.135	65					
						3/16	45		0.3			
					1/4	30	0.4					
15	108	110	0.080	45	190	0.5						

Marking

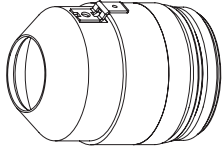
Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield		mm	in	mm/min	ipm	
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	85

Note: This process produces a shinier cut edge than the 45 A, N₂/N₂ stainless steel process

OPERATION

Stainless steel F5 Plasma / N₂ Shield 80 A Cutting

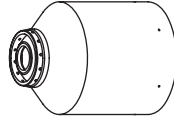
Flow rates - lpm/scfh		
	F5	N ₂
Preflow	0 / 0	67 / 142
Cutflow	31 / 65	55 / 116



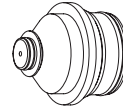
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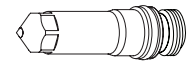
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
F5	N ₂	35	30	60	45	4	108	3.0	2180	4.5	150	0.2
						6	112	2.5	1225	3.8		0.3
						10	120	3.0	560	4.5		0.5

English

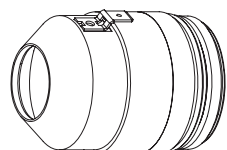
Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
F5	N ₂	35	30	60	45	.135	108	0.120	105	0.180	150	0.2
						3/16	110	0.110	60	0.170		0.3
						1/4	112	0.100	45	0.150		
						3/8	120	0.120	25	0.180		0.5

Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield		mm	in	mm/min	ipm	
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	95

Stainless steel
N₂ Plasma / N₂ Shield
130 A Cutting

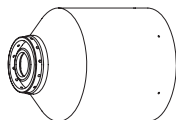
Flow rates - lpm/scfh	
N ₂	
Preflow	97 / 205
Cutflow	79 / 168



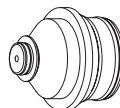
220173



220198



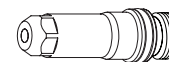
220176



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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
N ₂	N ₂	20	65	70	30	6	153	3.0	1960	6.0	200	0.3
						10	156		1300			0.5
						12	162	3.5	900	7.0	0.8	
						15	167	3.8	670	Edge start		
						20	176	4.3	305			

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
N ₂	N ₂	20	65	70	30	1/4	153	0.120	75	0.240	200	0.3
						3/8	156		55			0.5
						1/2	162	0.140	30	0.280	0.8	
						5/8	167	0.150	25	Edge start		
						3/4	176	0.170	15			

Marking

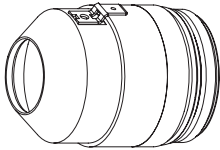
Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield		mm	in	mm/min	ipm	
N ₂	N ₂	10	10	10	10	18	2.5	0.100	6350	250	140

Note: This process produces a rougher, darker cut edge with more dross, and the cut edges are closer to perpendicular than the 130 A, H35/N₂ process

OPERATION

Stainless steel H35 Plasma / N₂ Shield 130 A Cutting

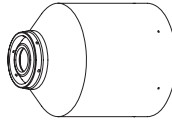
Flow rates - lpm/scfh		
	H35	N ₂
Preflow	0 / 0	76 / 160
Cutflow	26 / 54	68 / 144



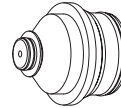
220173



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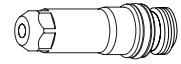
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Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield	mm	Volts	mm	mm/m	mm	factor %	seconds
H35	N ₂	20	40	70	60	10	154	4.5	980	7.7	170	0.3
					45	12	158		820			0.5
					30	15	162		580			0.8
					20	20	165		360			1.3
					20	25	172		260			Edge start

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield	in	Volts	in	ipm	in	factor %	seconds
H35	N ₂	20	40	70	60	3/8	154	0.180	40	0.310	170	0.3
					45	1/2	158		30			0.5
					30	5/8	162		20			0.8
					30	3/4	165		15			1.3
					20	1	172		10			Edge start

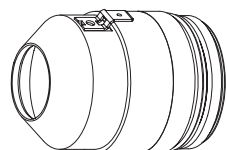
Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield	Amps	mm	in	mm/min	ipm	Volts
N ₂	N ₂	10	10	10	10	18	2.5	0.100	6350	250	130

Note: This process produces a smoother, shinier cut edge with less dross, and the cut edges are less perpendicular than the 130 A, N₂/N₂ process

Aluminum
Air Plasma / Air Shield
45 A Cutting

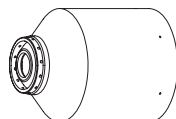
Flow rates - lpm/scfh	
Air	
Preflow	45 / 95
Cutflow	78 / 165



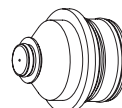
220173



220202



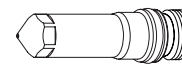
220176



220201



220180



220308

Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
Air	Air	35	25	55	60	1.2	130	2.5	4750	3.8	150	0.2
						1.5	115		4160			
						2	113		3865			
						2.5	110		3675			
						3	107		2850			
					40	4	102	1.8	2660	2.7	0.3	
6	117	3.0	1695	4.5	0.6							

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
Air	Air	35	25	55	60	.040	130	0.100	220	0.150	150	0.2
						.051	115		170			
						.064	113		160			
						.102	110		140			
						.125	102		0.070			
					40	3/16	114	0.120	90	0.180	0.4	
1/4	117	0.120	60	0.180	0.6							

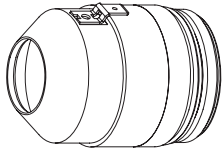
Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
Plasma	Shield	Plasma	Shield	Plasma	Shield		Amps	mm	in	mm/min	
N ₂	N ₂	10	10	10	10	15	2.5	0.100	6350	250	85

OPERATION

Aluminum Air Plasma / Air Shield 130 A Cutting

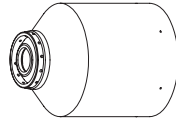
Flow rates - lpm/scfh	
Air	
Preflow	73 / 154
Cutflow	78 / 165



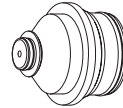
220173



220198



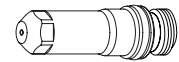
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220179



220181

Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield	mm	Volts	mm	mm/m	mm	factor %	seconds
Air	Air	20	40	70	30	6	153	2.8	2370	5.6	200	0.2
						10	154					3.0
						12	156	1225	0.5			
						15	158	3.3	1050	6.6		0.8
						20	162	3.5	725	7.0		1.3
						25	172	4.0	525	N/A		

English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield	in	Volts	in	ipm	in	factor %	seconds
Air	Air	20	40	70	30	1/4	153	0.110	90	0.220	200	0.2
						3/8	154		0.120			60
						1/2	156	45		0.5		
						5/8	158	0.130	40	0.260		0.8
						3/4	162	0.140	30	0.280		1.3
						1	172	0.160	20	N/A		

Marking

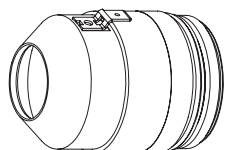
Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
N ₂	N ₂	10	10	10	10	Amps	mm	in	mm/min	ipm	Volts
						18	2.5	0.100	6350	250	120

Note: This process produces a rougher cut edge that is less perpendicular than the 130 A, H35/N₂ process

Aluminum

H35 Plasma / N₂ Shield
130 A Cutting

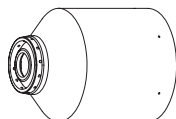
Flow rates - lpm/scfh		
	H35	N ₂
Prewflow	0 / 0	76 / 160
Cutflow	26 / 54	68 / 144



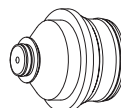
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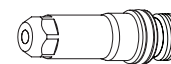
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220307

Metric

Select Gases		Set Prewflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time		
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts		mm	mm/m
H35	N ₂	20	40	70	60	10	158	4.5	1615	6.5	130	0.3		
					45	12	156					1455	0.5	
					30	15						1305	170	0.8
						20						157		940
					20	25						176	540	Edge start

English

Select Gases		Set Prewflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time			
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts		in	ipm	in
H35	N ₂	20	40	70	60	3/8	158	0.180	65	0.260	130	0.3			
					45	1/2	156					55	170	0.5	
					30	5/8						50		0.310	0.8
						3/4						157			40
					20	1						176		20	Edge start

Marking

Select Gases		Set Prewflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
						Amps	mm	in	mm/min	ipm	Volts
N ₂	N ₂	10	10	10	10	18	2.5	0.100	6350	250	130

Note: This process produces a smoother cut edge that is more perpendicular than the 130 A, Air/Air process