

Cutting Speed Chart

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

Torch Model	XT™-301					
Production Piercing & Cutting Capacity	1" (25 mm)					
Maximum Piercing & Cutting Capacity	1.5" (40 mm)					
Maximum Edge Start	2" (50 mm)					
Material	Thickness Inch	Speed IPM	Amps	Plasma/Shield	Thickness mm	Speed mm/min.
Mild Steel						
	21 ga.	500	55	Air/Air	1	11500
	10 ga.	190			3	5460
	3/16	130			5	3180
	21 ga.	600	55	O ₂ /Air	1	14040
	10 ga.	180			3	5830
	3/16	120			5	2920
	1/4	150	100	Air/Air	6	4150
	3/8	85			10	2120
	1/2	75			12	1960
	3/4	30			20	720
	1	20			25	520
	1/4	130	100	O ₂ /Air	6	3610
	1/2	57			12	1580
	3/4	25			20	580
	1	10			25	280
	3/8	130	200	Air/Air	10	3190
	1/2	100			12	2710
	3/4	60			20	1430
	1	35			25	920
	3/8	160	200	O ₂ /Air	10	390
	1/2	125			12	340
	3/4	75			20	180
	1	50			25	130
	1 1/4	30			35	80
Stainless Steel						
	16 ga.	350	55	Air/Air	1.5	9750
	10 ga.	100			4	2180
	3/16	60			5	1450
	1/4	100	100	Air/Air	6	3020
	3/8	65			10	1580
	1/2	45			12	1260
	1/4	60	100	N ₂ /H ₂ O	6	1750
	3/8	50			10	1210
	1/2	35			12	970
	3/8	50	100	Ar-H ₂ /N ₂	10	1220
	1/2	37			12	1010
Aluminum						
	16 ga.	400	55	Air/Air	2	8790
	3/16	100			5	2360
	1/4	100	100	Air/Air	6	2650
	1/2	45			12	1310
	3/4	35			20	890
	1/4	60	100	N ₂ /H ₂ O	6	1640
	3/8	50			10	1210
	1/2	35			12	970
	3/8	60	100	Ar-H ₂ /N ₂	10	1450
	1/2	40			12	1130

Note: Take care in comparison. The speeds noted above are best cut speeds. Often, competitors show maximum cutting 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, correct gas and current settings, accurate torch height control and with the torch perpendicular to the workpiece. The operating chart does not list all processes available for the Auto-Cut 200₂. Please contact Thermal Dynamics for more information.