



Duramax[®] Machine Torch Cut Charts for the Powermax45[®]

Cut Charts Guide

810050

Revision 0

January 2018

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Using the cut charts

Use the cut charts in this document:

- Only for Duramax® machine torches on the Powermax45
- As a starting point

Adjust the variables in the cut charts as needed to achieve optimal results for your cutting equipment and environment.



The cut charts are based on the latest process development from the Powermax45 XP and provide a wider range of material thicknesses than previous 45 A cut charts for Duramax torches.



If you are using a T45m torch with the Powermax45, use the cut charts in the *Powermax45 Operator Manual* (805780). For Powermax45 XP cut charts, refer to the *Powermax45 XP Operator Manual* (809240). Download the manuals at www.hypertherm.com/docs.

Cut charts are provided for each set of mechanized cutting consumables. A consumable diagram with part numbers precedes each cut chart.

Cut charts are included for:

- Cutting mild steel, stainless steel, and aluminum at 45 A with air using shielded consumables
- Cutting mild steel and stainless steel with air using FineCut consumables
- Cutting stainless steel at 45 A with F5 gas using shielded consumables

Each cut chart may contain the following information:

- **Amperage setting** – The amperage setting at the top of the page applies to all the settings given on that page. In FineCut® charts, the amperage setting for each thickness is included in the cut chart.
- **Material Thickness** – Thickness of the workpiece (metal plate being cut).
- **Torch-to-Work Distance** – For shielded consumables, the distance between the shield and the workpiece during cutting. For unshielded consumables, the distance between the nozzle and the workpiece during cutting. This is also known as cut height.
- **Initial Pierce Height** – Distance between the shield (shielded) or the nozzle (unshielded) and the workpiece when the torch is fired, prior to descending to the cut height.
- **Pierce Delay Time** – Length of time the triggered torch remains stationary at the pierce height before the torch starts the cutting motion.
- **Best Quality Settings** (cut speed and voltage) – Settings that provide the starting point for finding the best cut quality (best angle, least dross, best cut-surface finish). Adjust the speed for your application and table to obtain the desired result.

- **Production Settings** (cut speed and voltage) – 70% to 80% of the maximum speed ratings. These speeds result in the greatest number of cut parts, but not necessarily the best possible cut quality.



The arc voltage increases as the consumables wear, so the voltage setting may need to be increased to maintain the correct torch-to-work distance. Some CNCs monitor the arc voltage and adjust the torch lifter automatically.

- **Kerf Width** – Width of material removed by the cutting process. The kerf widths were obtained with the “Best Quality” settings and are for reference only. Differences between installations and material composition may cause actual results to vary from those shown.

Each cut chart lists hot and cold gas flow rates.

- **Hot flow rate** – Plasma is on, the system is operating at running current, and the system is in a steady state at the default system pressure (cutflow, or automatic mode).
- **Cold flow rate** – Plasma is off and the system is in a steady state with gas flowing through the torch at the default system pressure (postflow).



Hypertherm collected the cut chart data under laboratory test conditions using new consumables.

WARNING



EXPLOSION HAZARD – CUTTING WITH ALUMINUM NEAR WATER

Do not cut aluminum alloys underwater or on a water table unless you can prevent the accumulation of hydrogen gas. Never cut aluminum-lithium alloys in the presence of water.

Aluminum can react with water to produce hydrogen, resulting in a potentially explosive condition that can detonate during plasma cutting operations. Refer to the *Safety and Compliance Manual* (80669C) for more information.

WARNING



TOXIC FUMES CAN CAUSE INJURY OR DEATH

Some metals, including stainless steel, may release toxic fumes when cut. Make sure your work site has adequate ventilation to ensure that the air quality level meets all local and national standards and regulations. Refer to the *Safety and Compliance Manual* (80669C) for more information.

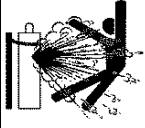
WARNING



EXPLOSION HAZARD – CUTTING WITH FUEL GASES

Do not use combustible fuel gases or oxidizing gases with Powermax systems. These gases can result in explosive conditions during plasma cutting operations.

WARNING

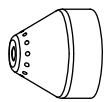


GAS CYLINDERS CAN EXPLODE IF DAMAGED

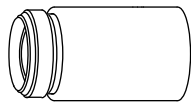
Gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. For high pressure regulators, adhere to the manufacturer's guidelines for safe installation, operation, and maintenance.

Before plasma cutting with compressed gas, read the safety instructions in the *Safety and Compliance Manual* (80669C). Failure to follow safety instructions can result in personal injury or in damage to equipment.

Mild Steel – 45 A – Air – Shielded



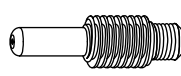
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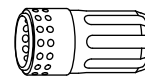
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ohmic sensing)



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Metric

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|---------|---------------------|---------|------------|
| | | | | | Cut Speed | Voltage | Cut Speed | Voltage | |
| mm | mm | mm | % | seconds | mm/min | volts | mm/min | volts | mm |
| 2 | 1.5 | 3.8 | 250 | 0.2 | 5560 | 128 | 7910 | 125 | 1.4 |
| 3 | | | | | 3960 | 128 | 5590 | 128 | |
| 4 | | | | 0.4 | 2800 | 128 | 3960 | 128 | 1.5 |
| 6 | | | | | 1430 | 130 | 2110 | 127 | |
| 8 | | | | 0.6 | 1020 | 133 | 1385 | 130 | 1.7 |
| 10 | | | | | 780 | 136 | 920 | 134 | 1.8 |
| 12 | | | | 1 | 540 | 140 | 690 | 138 | 1.9 |
| 16 | Edge Start | | | | 310 | 146 | 400 | 141 | 2.1 |
| 20 | | | | | 170 | 152 | 240 | 147 | 2.3 |
| 25 | | | | | 110 | 157 | 145 | 154 | 3 |

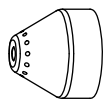
English

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|---------|---------------------|---------|------------|
| | | | | | Cut Speed | Voltage | Cut Speed | Voltage | |
| inches | inches | inches | % | seconds | in/min | volts | in/min | volts | inches |
| 16 GA | 0.06 | 0.15 | 250 | 0.1 | 249 | 128 | 320 | 125 | 0.053 |
| 14 GA | | | | 0.2 | 225 | 128 | 320 | 125 | 0.054 |
| 10 GA | | | | 0.4 | 129 | 128 | 181 | 128 | 0.057 |
| 3/16 | | | | | 85 | 129 | 122 | 127 | 0.059 |
| 1/4 | | | | 0.6 | 48 | 130 | 72 | 127 | 0.061 |
| 3/8 | | | | | 33 | 136 | 38 | 133 | 0.069 |
| 1/2 | | | | 1 | 18 | 141 | 24 | 139 | 0.077 |
| 5/8 | Edge Start | | | | 13 | 146 | 16 | 141 | 0.082 |
| 3/4 | | | | | 7 | 151 | 10 | 145 | 0.086 |
| 7/8 | | | | | 6 | 154 | 7 | 151 | 0.103 |
| 1 | | | | | 4 | 157 | 6 | 154 | 0.119 |

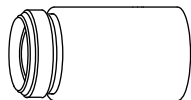
Gas flow rate – slpm / scfh

| | |
|-----------|-----------------|
| 151 / 320 | Hot (cutflow) |
| 184 / 390 | Cold (postflow) |

Stainless Steel – 45 A – Air – Shielded



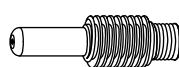
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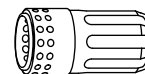
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Metric

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|---------|---------------------|---------|------------|
| | | | | | Cut Speed | Voltage | Cut Speed | Voltage | |
| mm | mm | mm | % | seconds | mm/min | volts | mm/min | volts | mm |
| 2 | 1.5 | 3.8 | 250 | 0.1 | 5620 | 126 | 7830 | 129 | 0.6 |
| 3 | | | | 0.2 | 3285 | 129 | 4725 | 128 | 0.9 |
| 4 | | | | 0.4 | 1995 | 130 | 2960 | 129 | 1.1 |
| 6 | | | | 0.6 | 1145 | 131 | 1695 | 131 | 1.2 |
| 8 | | | | | 830 | 134 | 1100 | 134 | 1.4 |
| 10 | | 0.8 | 605 | 137 | 870 | 137 | 1.6 | | |
| 12 | | 4.6 | 300 | 1.2 | 380 | 141 | 540 | 139 | 1.8 |
| 16 | | Edge Start | | | 240 | 145 | 320 | 142 | 2.4 |
| 20 | Edge Start | | | 160 | 149 | 205 | 146 | 3.1 | |

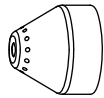
English

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|---------|---------------------|---------|------------|
| | | | | | Cut Speed | Voltage | Cut Speed | Voltage | |
| inches | inches | inches | % | seconds | in/min | volts | in/min | volts | inches |
| 16 GA | 0.06 | 0.15 | 250 | 0.1 | 237 | 125 | 320 | 128 | 0.017 |
| 14 GA | | | | 0.2 | 230 | 126 | 320 | 129 | 0.022 |
| 10 GA | | | | 0.4 | 90 | 130 | 134 | 128 | 0.041 |
| 3/16 | | | | 0.5 | 63 | 131 | 93 | 130 | 0.044 |
| 1/4 | | | | | 40 | 131 | 59 | 131 | 0.047 |
| 3/8 | | 0.8 | 26 | 137 | 29 | 136 | 0.061 | | |
| 1/2 | | 0.18 | 300 | 1.2 | 12 | 142 | 19 | 140 | 0.075 |
| 5/8 | | Edge Start | | | 10 | 145 | 13 | 142 | 0.096 |
| 3/4 | Edge Start | | | 7 | 148 | 9 | 145 | 0.116 | |
| 7/8 | Edge Start | | | 5 | 151 | 6 | 149 | 0.137 | |

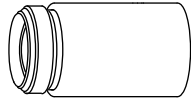
Gas flow rate – slpm / scfh

| | |
|-----------|-----------------|
| 151 / 320 | Hot (cutflow) |
| 184 / 390 | Cold (postflow) |

Aluminum - 45 A - Air - Shielded



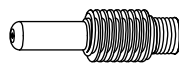
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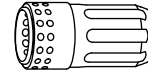
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Metric

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|---------|---------------------|---------|------------|
| | | | | | Cut Speed | Voltage | Cut Speed | Voltage | |
| mm | mm | mm | % | seconds | mm/min | volts | mm/min | volts | mm |
| 2 | 1.5 | 3.8 | 250 | 0.1 | 7890 | 121 | 9585 | 134 | 1.3 |
| 3 | | | | 0.2 | 4850 | 130 | 7120 | 129 | |
| 4 | | | | 0.4 | 3670 | 133 | 5650 | 129 | |
| 6 | | | | 0.5 | 2060 | 139 | 3095 | 132 | 1.6 |
| 8 | | | | 0.6 | 1330 | 139 | 1830 | 136 | 1.7 |
| 10 | | | | 0.7 | 860 | 142 | 1015 | 140 | 1.9 |
| 12 | Edge Start | | | | 620 | 144 | 745 | 142 | 2 |
| 16 | Edge Start | | | | 360 | 152 | 340 | 148 | 2.5 |

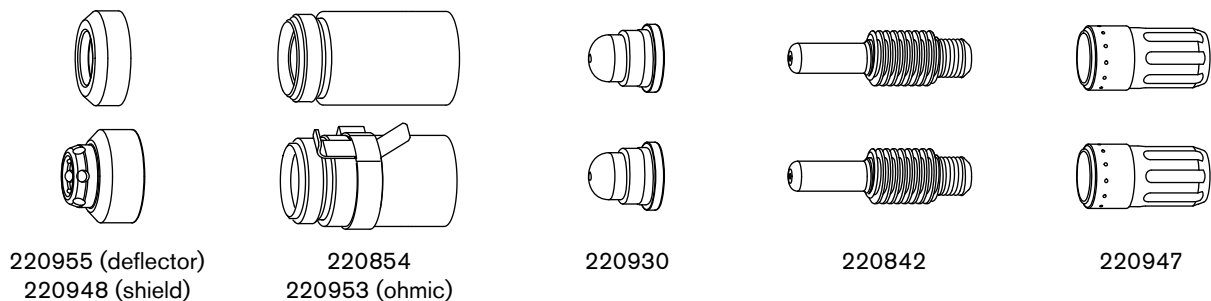
English

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|---------|---------------------|---------|------------|
| | | | | | Cut Speed | Voltage | Cut Speed | Voltage | |
| inches | inches | inches | % | seconds | in/min | volts | in/min | volts | inches |
| 1/10 | 0.06 | 0.15 | 250 | 0.2 | 240 | 126 | 320 | 131 | 0.056 |
| 1/8 | | | | 0.4 | 170 | 131 | 263 | 128 | 0.060 |
| 3/16 | | | | | 120 | 134 | 184 | 130 | 0.061 |
| 1/4 | | | | 0.5 | 70 | 137 | 104 | 132 | 0.063 |
| 3/8 | | | | 0.7 | 36 | 141 | 42 | 139 | 0.073 |
| 1/2 | | | | Edge Start | | | | 21 | 145 |
| 5/8 | Edge Start | | | | 15 | 152 | 14 | 148 | 0.100 |
| 3/4 | Edge Start | | | | 8 | 158 | 9 | 153 | 0.117 |

Gas flow rate - slpm / scfh

| | |
|-----------|-----------------|
| 151 / 320 | Hot (cutflow) |
| 184 / 390 | Cold (postflow) |

Mild Steel – FineCut – Air – Shielded and Unshielded



Metric

| Material Thickness | Current | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Recommended | | Kerf Width | | | |
|--------------------|---------|------------------------|-----------------------|-----|-------------------|-------------|---------|------------|-----|------|----|
| | | | mm | % | | Cut Speed | Voltage | | | | |
| mm | A | mm | mm | % | seconds | mm/min | volts | mm | | | |
| 0.5 | 40 | 1.5 | 3.8 | 250 | 0.0 | 8250 | 78 | 0.7 | | | |
| 0.6 | | | | | | 8250 | 78 | | | | |
| 0.8 | | | | | 0.1 | 8250 | 78 | 0.6 | | | |
| 1 | 0.2 | | | | | 8250 | 78 | 0.7 | | | |
| 1.5 | | | | | | 0.4 | 6400 | 78 | 1.2 | | |
| 2 | 45 | | | | 0.5 | | 2500 | 78 | 1.3 | | |
| 3 | | | | | | 0.6 | | | | 1900 | 78 |
| 4 | | | | | | | | | | | |

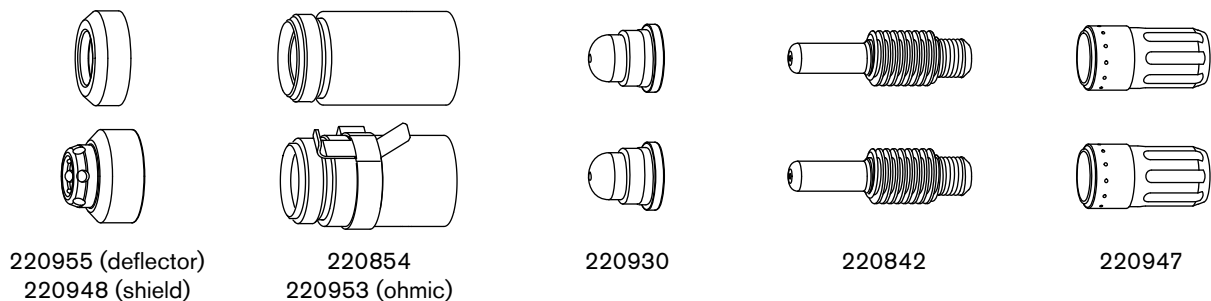
English

| Material Thickness | Current | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Kerf Width | | | |
|--------------------|---------|------------------------|-----------------------|-------|-------------------|-----------------------|---------|------------|-----|-----|-------|
| | | | inches | % | | Cut Speed | Voltage | | | | |
| inches | A | inches | inches | % | seconds | in/min | volts | inches | | | |
| 26 GA | 40 | 0.06 | 0.15 | 250 | 0.0 | 325 | 78 | 0.025 | | | |
| 24 GA | | | | | | 325 | 78 | 0.029 | | | |
| 22 GA | | | | | 0.1 | 325 | 78 | 0.024 | | | |
| 20 GA | 325 | | | | | 78 | 0.020 | | | | |
| 18 GA | 45 | | | | 0.2 | 0.15 | 250 | 0.2 | 325 | 78 | 0.043 |
| 16 GA | | | | | | | | | 0.4 | 250 | 78 |
| 14 GA | | | | | | | | 200 | | 78 | 0.049 |
| 12 GA | | | | | | | | 0.5 | | 120 | 78 |
| 10 GA | | 95 | 78 | 0.051 | | | | | | | |

Gas flow rate – slpm / scfh

| | |
|-----------|-----------------|
| 155 / 330 | Hot (cutflow) |
| 215 / 460 | Cold (postflow) |

Stainless Steel - FineCut - Air - Shielded and Unshielded



Metric

| Material Thickness | Current | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Recommended | | Kerf Width |
|--------------------|---------|------------------------|-----------------------|-----|-------------------|-------------|---------|------------|
| | | | mm | % | | Cut Speed | Voltage | |
| mm | A | mm | mm | % | seconds | mm/min | volts | mm |
| 0.5 | 40 | 0.5 | 2.0 | 400 | 0.0 | 8250 | 68 | 0.6 |
| 0.6 | | | | | | 8250 | 68 | |
| 0.8 | | | | | 0.1 | 8250 | 68 | 0.5 |
| 1 | 0.2 | | | | | 8250 | 68 | |
| 1.5 | | | | | 45 | 0.4 | 6150 | 70 |
| 2 | 4800 | | | | | | 71 | |
| 3 | 0.5 | | | | | 2550 | 80 | 1.4 |
| 4 | | | | | | 1050 | 84 | |

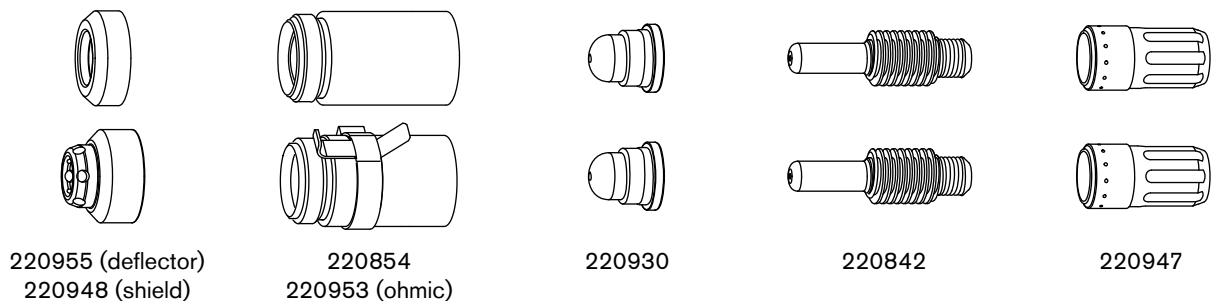
English

| Material Thickness | Current | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Kerf Width |
|--------------------|---------|------------------------|-----------------------|-------|-------------------|-----------------------|---------|------------|
| | | | inches | % | | Cut Speed | Voltage | |
| inches | A | inches | inches | % | seconds | in/min | volts | inches |
| 26 GA | 40 | 0.02 | 0.08 | 400 | 0.0 | 325 | 68 | 0.024 |
| 24 GA | | | | | | 325 | 68 | 0.021 |
| 22 GA | | | | | 0.1 | 325 | 68 | 0.018 |
| 20 GA | 325 | | | | | 68 | 0.017 | |
| 18 GA | 45 | | | | 0.2 | 325 | 68 | 0.036 |
| 16 GA | | | | | | 0.4 | 240 | 70 |
| 14 GA | | | | | 200 | | 70 | 0.040 |
| 12 GA | | | | | 0.5 | 120 | 80 | 0.049 |
| 10 GA | 0.6 | 75 | 80 | 0.055 | | | | |

Gas flow rate - slpm / scfh

| | |
|-----------|-----------------|
| 155 / 330 | Hot (cutflow) |
| 215 / 460 | Cold (postflow) |

Mild Steel – FineCut Low Speed – Air – Shielded and Unshielded



Metric

| Material Thickness mm | Current A | Torch-to-Work Distance mm | Initial Pierce Height | | Pierce Delay Time seconds | Recommended | | Kerf Width mm | | | |
|--------------------------|--------------|---------------------------------|-----------------------|-----|------------------------------|---------------------|------------------|------------------|------|----|-----|
| | | | mm | % | | Cut Speed mm/min | Voltage volts | | | | |
| 0.5 | 30 | 1.5 | 3.8 | 250 | 0.0 | 3800 | 69 | 0.6 | | | |
| 0.6 | | | | | | 3800 | 68 | | | | |
| 0.8 | | | | | | 3800 | 70 | | | | |
| 1* | 40 | | | | 0.2 | 3800 | 72 | 0.8 | | | |
| 1.5* | | | | | | | | | 3800 | 75 | |
| 2 | 45 | | | | 0.4 | 3700 | 76 | 0.7 | | | |
| 3 | | | | | | | | 0.5 | 2750 | 78 | 1.3 |
| 4 | | | | | | | | | | | 0.6 |

English

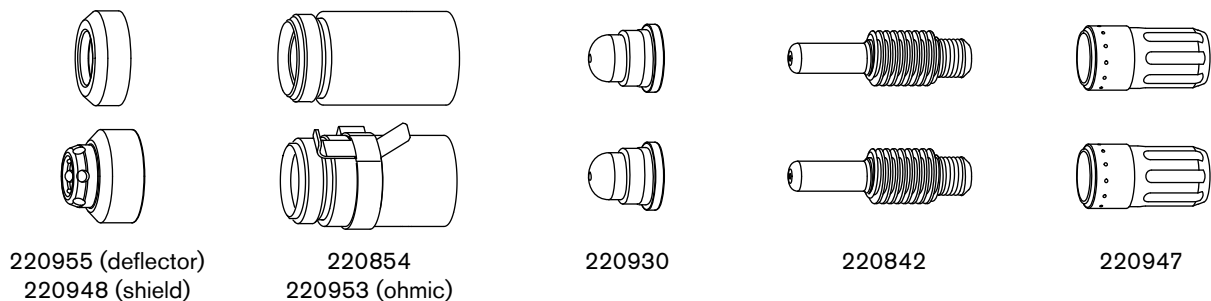
| Material Thickness inches | Current A | Torch-to-Work Distance inches | Initial Pierce Height | | Pierce Delay Time seconds | Best Quality Settings | | Kerf Width inches |
|------------------------------|--------------|-------------------------------------|-----------------------|-------|------------------------------|-----------------------|------------------|----------------------|
| | | | inches | % | | Cut Speed in/min | Voltage volts | |
| 26 GA | 30 | 0.06 | 0.15 | 250 | 0.0 | 150 | 70 | 0.026 |
| 24 GA | | | | | | 150 | 68 | 0.024 |
| 22 GA | | | | | | 150 | 70 | 0.025 |
| 20 GA | 150 | | | | 71 | | | |
| 18 GA | 40 | | | | 0.2 | 150 | 73 | 0.031 |
| 16 GA* | | | | | | | | |
| 14 GA* | 45 | | | | 0.4 | 150 | 76 | 0.027 |
| 12 GA | | | | | | | | |
| 10 GA | | 95 | 78 | 0.051 | | | | |

Gas flow rate – slpm / scfh

| | |
|-----------|-----------------|
| 155 / 330 | Hot (cutflow) |
| 215 / 460 | Cold (postflow) |

* Not a dross-free cut.

Stainless Steel – FineCut Low Speed – Air – Shielded and Unshielded



Metric

| Material Thickness mm | Current A | Torch-to-Work Distance mm | Initial Pierce Height | | Pierce Delay Time seconds | Recommended | | Kerf Width mm | | | |
|--------------------------|--------------|---------------------------------|-----------------------|-----|------------------------------|---------------------|------------------|------------------|------|------|-----|
| | | | mm | % | | Cut Speed mm/min | Voltage volts | | | | |
| 0.5 | 30 | 0.5 | 2.0 | 400 | 0.0 | 3800 | 69 | 0.7 | | | |
| 0.6 | | | | | | 3800 | 69 | | | | |
| 0.8 | | | | | | 3800 | 69 | | | | |
| 1 | 40 | | | | 0.5 | 2.0 | 400 | 0.2 | 3800 | 69 | 0.6 |
| 1.5 | | | | | | | | 0.4 | 2900 | 69 | 0.5 |
| 2 | | | | | | | | | 2750 | 69 | 1.3 |
| 3 | | | | | | | | 45 | 0.5 | 2550 | 80 |
| 4 | 0.6 | | | | | | | | 1050 | 80 | 1.5 |

English

| Material Thickness inches | Current A | Torch-to-Work Distance inches | Initial Pierce Height | | Pierce Delay Time seconds | Best Quality Settings | | Kerf Width inches | | | | |
|------------------------------|--------------|-------------------------------------|-----------------------|-----|------------------------------|-----------------------|------------------|----------------------|------|-----|-------|-------|
| | | | inches | % | | Cut Speed in/min | Voltage volts | | | | | |
| 26 GA | 30 | 0.02 | 0.08 | 400 | 0.0 | 150 | 69 | 0.028 | | | | |
| 24 GA | | | | | | 150 | 69 | | | | | |
| 22 GA | | | | | 0.1 | 150 | 69 | 0.025 | | | | |
| 20 GA | 150 | | | | | 69 | | | | | | |
| 18 GA | 40 | | | | 0.02 | 0.08 | 400 | 0.2 | 145 | 69 | 0.023 | |
| 16 GA | | | | | | | | 0.4 | 115 | 69 | | 0.022 |
| 14 GA | | | | | | | | | 110 | 69 | | 0.021 |
| 12 GA | 45 | | | | | | | 0.02 | 0.08 | 400 | 0.5 | 120 |
| 10 GA | | 0.6 | 75 | 80 | | | | | | | 0.055 | |

Gas flow rate – slpm / scfh

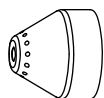
| | |
|-----------|-----------------|
| 155 / 330 | Hot (cutflow) |
| 215 / 460 | Cold (postflow) |

Stainless Steel – 45 A – F5 – Shielded

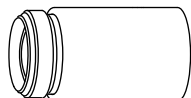
When used with a Powermax system, F5 should be used only to cut stainless steel.



For more information on cutting with F5, download the *Use F5 to Cut Stainless Steel* (809060) Application Note at www.hypertherm.com/docs.



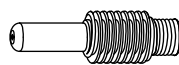
220817



220854
(220953 for ohmic sensing)



220941



220842



220857

Metric

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|-----------|---------------------|-----------|------------|
| | | mm | % | | seconds | Cut Speed | Voltage | Cut Speed | |
| 8 | 1.5 | 3.8 | 250 | 0.8 | 630 | 150 | 860 | 144 | 2.1 |
| 10 | | | | | 435 | 153 | 525 | 147 | 2.3 |
| 12 | | Edge Start | | 340 | 156 | 440 | 150 | 2.5 | |

English

| Material Thickness | Torch-to-Work Distance | Initial Pierce Height | | Pierce Delay Time | Best Quality Settings | | Production Settings | | Kerf Width |
|--------------------|------------------------|-----------------------|-----|-------------------|-----------------------|-----------|---------------------|-----------|------------|
| | | inches | % | | seconds | Cut Speed | Voltage | Cut Speed | |
| 1/4 | 0.06 | 0.15 | 250 | 0.6 | 32 | 147 | 47 | 141 | 0.075 |
| 3/8 | | | | 0.8 | 18 | 152 | 22 | 146 | 0.088 |
| 1/2 | | Edge Start | | 12 | 157 | 16 | 151 | 0.101 | |

Gas flow rate – slpm / scfh

| | |
|-----------|-----------------|
| 149 / 315 | Hot (cutflow) |
| 184 / 390 | Cold (postflow) |



F5 is not recommended for thicknesses less than 7 mm or 1/4 inch or for use with FineCut consumables.