

Material	Type	Thickness (mm)	Thickness (in)	Gauge	Amps	Speed (ipm)	Mode	Tip	Tip Type	Clearance	Pierce	Comments
Aluminum		0.38	0.015	11	45	15-40	RW45	1.0mm	Mech			clean cut
Aluminum		3.175	0.125	11	35	80	RW45	1.0mm				on the money
Aluminum		15.24	0.6	30	30	15		8mm				Very little dross, Nic cut
Aluminum		0.9652	0.038	26	30	15	RW45	9mm		0.6		Very little dross, Nic cut
Cast Iron		5.08	0.2	26	30	15	RW45	10.9mm		0.4		Should have maybe gone slower by 1-2 ipm
Galvanized		0	0	26	25	40	RW45	1.0mm		0.5		Minimal dross, cleaned up with flap wheel, could have run faster
Mild Steel	Hot	21.136	0.84	25	66	66	RW45	6mm		0.6		cut quality was incredible! nothing on the front at all this was a big cut that took a while and had 43 chams to cut, dross on the back came
Mild Steel		9.225	0.375	0000	45	12	RW45	9mm		0.4		As small bit of dross but checked right off with no trouble
Mild Steel		9.525	0.375	0000	45	12	RW45	9mm		1		good cut with some dross but easy to chip off
Mild Steel		9.525	0.375	0000	45	12	RW45	9mm		1		See Pic
Mild Steel		6.35	0.25	3	45	20	RW45			1		See Pic
Mild Steel		4.7625	0.1875	7	45	40	RW45	1.0mm		1		See Pic
Mild Steel		4.7625	0.1875	7	30	30	RW45	0.4		1		See Pic
Mild Steel	Hot	3.584	0.141	86	45	42	RW45	1.0mm		1		Dross removed with sig hammer, some cuts better than others. Seemed to have a problem with smaller bits and cutting evenly
Mild Steel		3.571875	0.140725	80	30	60				0.5		Almost no dross
Mild Steel		3.175	0.125	11	45	75	RW45			0.15		0.6
Mild Steel		3.175	0.125	11	35	65	RW45	8mm		1		very little dross around small letters
Mild Steel		3.175	0.125	11	40	80	RW45			1		quite a bit of bottom dross
Mild Steel	Hot	3.175	0.125	11	35	50	RW45	8mm		0.5		some dross on rear, front back clean cut
Mild Steel	Hot	1.905	0.075	86	28	72	RW45	6mm		0.001		cut quality was incredible! nothing on the front at all this was a big cut that took a while and had 43 chams to cut, dross on the back came
Mild Steel	Hot	1.651	0.065	86	30	120	RW45	8mm		0.5		Very fine detail, came out great! Test cuts on straight lines show 0.021 or 0.026 kerf width
Mild Steel	Hot	1.651	0.065	86	45	120	RW45	9mm		0.4		50 PSI (more blow out force)
Mild Steel	Cold	1.5748	0.062	28	70	70	RW45	6mm		0.1		Clean cut, very little dross
Mild Steel		0.635	0.025	24	20	120						Clean cut
Stainless	304		0.25	3	45	15	RW45	9mm				very little dross
Stainless	304	1.6129	0.0635	86	30	95	RW45	1.0mm				dross easily removed with pliers, weldat stock nozzles
Steel		4.7625	0.1875	7	40	45	RW45					dross easily removed with pliers
Steel		3.175	0.125	11	45	65	RW45					dross easily removed with pliers
Steel		2.778125	0.109375	12	30	70	RW45	8mm				Perfect cut, nearly dross free; 0.31 Kerf Width
Steel		13.288	0.523	14	30	80		8mm				Clean cut, little under side dross
Steel	Cold	1.176	0.044	20	80	80	RW45	8mm			0.6	