

Metal Type	Thickness	Speed			Amps	(PSI)	Notes
	IMP	IPM	mm/m	mm/s = {E2/60}	Amps	PSI	
Mild Steel	26g (.015)	236.22	5999.988	99.9998	20	40	
	20g (.035)		0	0	20	40	
	18g (.048)		0	0	25	45	
	16g (.059)	110	2794	46.56666667	30	50	
	15g (0.065)	115	2921	48.68333333	40	55	0.9s pierce delay
	10g (.102)	110.24	2800.096	46.66826667	40	55	
	3/16"	62.99	1599.946	26.66576667	45	60	
	1/4"	47.24	1199.896	19.99826667	45	60	
	5/16"	43.31	1100.074	18.33456667	50	65	
	3/8"	39.37	999.998	16.66663333	55	70	
	1/2"	23.62	599.948	9.999133333	60	75	
	1/2"	9	228.6	3.81	50	60	1.5s pierce delay
	5/8"	17.72	450.088	7.501466667	60	75	
	3/4"	11.81	299.974	4.999566667	60	75	
	1/8	80	2032	33.86666667	45	58	0.8 pierce delay
	3/16	90	2286	38.1	45	60	
	1/16	120	3048	50.8	35	50	
	3/8	40	1016	16.93333333	55	70	0.7 pierce delay
	1/4	48	1219.2	20.32	45	60	0.8 pierce delay
Aluminum	26g (.015)	271.65	6899.91	114.9985	20	40	
	20g (.035)		0	0	20	40	
	18g (.048)		0	0	25	45	
	16g (.059)	126.77	3219.958	53.66596667	30	50	
	10g (.102)	99.61	2530.094	42.16823333	40	55	
	3/16"	72.44	1839.976	30.66626667	45	60	
	1/4"	54.33	1379.982	22.9997	45	60	
	5/16"	49.8	1264.92	21.082	50	65	
	3/8"	45.28	1150.112	19.16853333	55	70	
	1/2"	27.17	690.118	11.50196667	60	75	
	5/8"	20.37	517.398	8.6233	60	75	
	3/4"	13.58	344.932	5.748866667	60	75	
	1/8"	70	1778	29.63333333	45	60	0.9 pierce delay
Stainless	1/8	70	1778	29.63333333	45	55	0.8 pierce delay
	26g (.015)	188.98	4800.092	80.00153333	20	40	
	20g (.035)		0	0	20	40	
	18g (.048)		0	0	25	45	
	16g (.059)	88.19	2240.026	37.33376667	30	50	
	10g (.102)	69.29	1759.966	29.33276667	40	55	
	3/16"	50.39	1279.906	21.33176667	45	60	
	1/4"	37.8	960.12	16.002	45	60	
	5/16"	34.65	880.11	14.6685	50	65	
	3/8"	31.5	800.1	13.335	55	70	
	1/2"	18.9	480.06	8.001	60	75	
consumables	amperage						
0.8	20-30					762	
0.9	30-40						
1	40-50						
1.2	60-70						

Metal Type	Thickness	Thickness	Speed	Speed	Amps	Tip Size	Cut Height	(PSI)		Notes
	IMP	MM	IPM	MM/M	Amps	MM	IMP	PSI	PSI	
Mild Steel	26g	0.45	236	6000	20	0.9	0.06"	40		
	20g	0.9		0	20	0.9	0.06"	40		
	18g	1.2		3000	25	0.9	0.06"	45		
	16g	1.6	110	2800	30	0.9	0.06"	50		
	10g	3.2	87	2200	40	0.9	0.06"	55		
	3/16"	4.7	63	1600	45	1	0.06"	60		
	1/4"	6.3	47	1200	45	1	0.06"	60		
	5/16"	8	43	1100	50	1	0.06"	65		
	3/8"	9.5	39	1000	55	1	0.06"	70		
	1/2"	12.7	24	600	60	1	0.06"	75		
	1/2"	1/2"	7	183	50	1.1	0.06"	60		1.5s pierce delay
	5/8"	15.8	18	450	60	1	0.06"	75		
	3/4"	19	12	300	60	1	0.06"	75		

Metal Type	Thickness	Thickness	Speed	Speed	Amps	Tip Size	Cut Height	Air Pressure (PSI)		Notes
	IMP	MM	IPM	MM/M	Amps	MM	IMP	PSI	PSI	
	3/4"	3/4"	9	240	60	1	0.06"	75		

Metal Type	Thickness	Thickness	Speed	Speed	Amps	Tip Size	Cut Height	Air Pressure (PSI)		Notes	
	IMP	MM	IPM	MM/M	Amps	MM	IMP	PSI	PSI		
Aluminum	26g	0.45	272	6900	20	0.9	0.06"	40			
	20g	0.9		0	20	0.9	0.06"	40			
	18g	1.2	25	3200	25	0.9	0.06"	45			
	16g	1.6	127	3220	30	0.9	0.06"	50			
	10g	3.2	100	2530	40	0.9	0.06"	55			
	3/16"	4.7	72	1840	45	1	0.06"	60			
	1/4"	6.3	54	1380	45	1	0.06"	60			
	5/16"	8	50	1265	50	1	0.06"	65			
	3/8"	9.5	45	1150	55	1	0.06"	70			
	1/2"	12.7	27	690	60	1	0.06"	75			
	5/8"	15.8	20	517	60	1	0.06"	75			
	3/4"	19	14	345	60	1	0.06"	75			
	Stainless	26g	0.45	189	4800	20	0.9	0.06"	40		
		20g	0.9		0	20	0.9	0.06"	40		
18g		1.2		0	25	0.9	0.06"	45			
16g		1.6	88	2240	30	0.9	0.06"	50			
10g		3.2	69	1760	40	0.9	0.06"	55			
3/16"		4.7	50	1280	45	1	0.06"	60			
1/4"		6.3	38	960	45	1	0.06"	60			
5/16"		8	35	880	50	1	0.06"	65			
3/8"		9.5	32	800	55	1	0.06"	70			
1/2"		12.7	19	480	60	1	0.06"	75			

