

PRIMEWELD CUT CHART

AIR PRESSURE	CUTTING AMPS
40	20A
50	30A
55	40A
65	50A
75	60A

CUTTING SPEED REFERENCE TABLE

MILD STEEL AMPS	PSI	MATERIAL THICKNESS INCH	DISTANCE TO WORK	IPM
20	40	26GA	0.06	236.22
30	50	16G	0.06	110.24
40	55	10G	0.06	86.61
45	60	3/16	0.06	62.99
45	60	1/4	0.06	47.24
50	65	1/3	0.06	43.31
55	70	2/5	0.06	39.37
60	75	1/2	0.06	23.62
60	75	5/8	0.06	17.72
60	75	3/4	0.06	11.81

STAINLESS STEEL AMPS	PSI	MATERIAL THICKNESS	DISTANCE TO WORK	IPM
20	40	26GA	0.06	188.98
30	50	16G	0.06	88.19
40	55	10G	0.06	69.29
45	60	3/16	0.06	50.39
45	60	1/4	0.06	37.81
50	65	1/3	0.06	34.65
55	70	2/5	0.06	31.51
60	75	1/2	0.06	18.91
60	75	5/8	0.06	14.17
60	75	3/4	0.06	9.45

ALUMINUM AMPS	PSI	MATERIAL THICKNESS	DISTANCE TO WORK	IPM
20	40	26GA	0.06	271.65
30	50	16G	0.06	126.77
40	55	10G	0.06	99.61
45	60	3/16	0.06	72.44
45	60	1/4	0.06	54.33
50	65	1/3	0.06	49.81
55	70	2/5	0.06	45.28
60	75	1/2	0.06	27.17
60	75	5/8	0.06	20.37
60	75	3/4	0.06	13.58