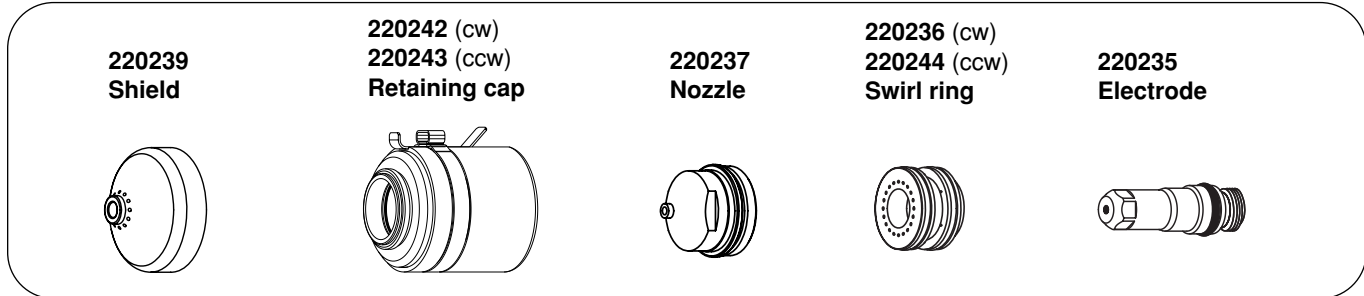


OPERATION

Mild Steel

HySpeed 200 amps • O₂ Plasma / Air Shield

This gas combination gives superior cut speed, minimum dross, minimum surface nitriding and excellent weldability.



Above Water

Material Thickness (inches)	Material Thickness (mm)	Plasma Gas Flow Rate %		Shield Gas (Air) Pressure (psi)	Torch-to-work Distance		Initial Torch Piercing Height		Arc Voltage Setting (volts)	Travel Speed		Approx. Motion Delay Time (sec)
		Preflow (O ₂ % N ₂ %)	Cutflow (O ₂ % N ₂ %)		(inches)	(mm)	(inches)	(mm)		(ipm)	(mm/min.)	
1/4	6	12 38	76 0	60	1/16	1.5	1/8	3	145	230	5800	0.3
5/16	8	(12 / 50)	(90 / 0)	(275)	1/8	3	1/4	6	151	165	4200	0.3
3/8	10	SCFH)	SCFH)	SCFH)	5/32	4	5/16	8	155	140	3500	0.3
1/2	12				1/8	3	1/4	6	155	120	3000	0.3
5/8	15				1/8	3	1/4	6	155	100	2500	0.5
3/4	20				1/8	3	1/4	6	155	75	1900	0.6
7/8	22				1/8	3	1/4	6	159	60	1500	0.7
1	25				1/8	3	1/4	6	160	50	1300	0.7
1 1/4	32				1/8	3	5/16	8	168	30	760	2.6
1-1/2	38				1/8	3	5/16	8	175	20	500	4.0
1-3/4	44				1/8	3	N/A	N/A	180	15	380	N/A
2	50				1/8	3	N/A	N/A	188	10	250	N/A

3" Under Water

Material Thickness (inches)	Material Thickness (mm)	Plasma Gas Flow Rate %		Shield Gas (Air) Pressure (psi)	Torch-to-work Distance		Initial Torch Piercing Height		Arc Voltage Setting (volts)	Travel Speed		Approx. Motion Delay Time (sec)
		Preflow (O ₂ % N ₂ %)	Cutflow (O ₂ % N ₂ %)		(inches)	(mm)	(inches)	(mm)		(ipm)	(mm/min.)	
1/4	6	12 38	76 0	60	1/16	1.5	1/8	3	149	230	5800	0.3
5/16	8	(12 / 50)	(90 / 0)	(275)	1/8	3	1/4	6	151	165	4200	0.3
3/8	10	SCFH)	SCFH)	SCFH)	5/32	4	5/16	8	159	140	3500	0.3
1/2	12				1/8	3	1/4	6	155	105	2700	0.3
5/8	15				1/8	3	1/4	6	161	90	2300	0.5
3/4	20				1/8	3	1/4	6	161	65	1600	0.6
7/8	22				1/8	3	1/4	6	161	55	1400	0.7
1	25				1/8	3	1/4	6	164	45	1100	0.7

Notes: **Set oxygen plasma gas inlet pressure to 120 psi (8.3 bar).**
Set nitrogen plasma gas inlet pressure to 120 psi (8.3 bar)
Set shield gas inlet pressure to 90 psi (6.2 bar)
 Production cutting above 1" (25 mm) not recommended.
 Drop cutting above 1-1/2" (38 mm) not recommended