



Cutting Speed Chart

This cutting speed chart includes preliminary data and is subject to change without notice

Torch Model		XT™-300				
Production Piercing & Cutting Capacity		5/8" (15 mm)				
Maximum Piercing & Cutting Capacity		3/4" (20 mm)				
Maximum Edge Start		1-1/4" (30 mm)				
Material	Thickness Inch	Speed IPM	Amps	Plasma/Shield	Thickness mm	Speed mm/min.
Mild Steel						
	20 ga.	130	30	O ₂ /O ₂	1	3050
	10 ga.	30			3	910
	10 ga.	210	70	O ₂ /Air	3	6620
	1/4	120			6	3100
	3/16	190	100	O ₂ /Air	5	4670
	1/4	150			6	4030
	3/8	95			10	2300
	1/2	64			12	1800
	5/8	50			15	1370
	3/4	25			20	640
	1/4	150	100	Air/Air (Conventional)	6	4150
	3/8	85			10	2120
	1/2	75			12	1960
	3/4	30			20	720
Stainless Steel						
	26 ga.	350	30	Air/Air	.6	8300
	20 ga.	300			1	7190
	16 ga.	110			1.5	3100
	14 ga.	170	50	N ₂ /H ₂ O	2	4310
	12 ga.	150			3	3660
	3/16	70			5	1523
	10 ga.	120	70	N ₂ /H ₂ O	3	3040
	3/16	90			5	2140
	1/4	50			6	1495
	1/4	95	100	N ₂ /H ₂ O	6	2665
	3/8	65			10	1595
	1/2	50			12	1355
	5/8	25			15	750
	1/2	42	100	Ar-H ₂ /N ₂	12	1140
Aluminum						
	16 ga.	140	50	N ₂ /H ₂ O	2	2990
	11 ga.	60			3	1520
	3/16	40			5	950
	3/8	70	100	N ₂ /H ₂ O	10	1665
	1/2	40			12	1190
	5/8	35			15	925
	1/2	50	100	Ar-H ₂ /N ₂	12	1330

Note: Take care in comparison. The speeds noted above are best cut speeds. Often, competitors show maximum cutting speeds. Although much higher speeds can be achieved, edge quality and bevel angle may be compromised. The capabilities shown in this table were obtained by using new consumables, correct gas and current settings, accurate torch height control and with the torch perpendicular to the workpiece. The operating chart does not list all processes available for the Ultra-Cut 100. Please contact Thermal Dynamics for more information.