

注：以下参数仅供参考，切割后的工件1) 没有切割说明速度太快，需要降低速度，挂渣太多，说明速度太慢，需要提高速度  
3) 注意穿孔时间

the blow parameter are just for reference. 1)if not cut through metal sheet.means cutting speed is so fast we should reduce speed;2)if there are some slags on surface(not clean)means cutting speed is slow now we need speed up 3) note: piercing time

any question contact us whatsapp/wechat:+86 185 6020 5338

THICKNESS (mm) 板子厚度	Nozzle size (mm) 喷嘴孔径	CURRENT(A) 电流	ARC Number 弧压	CUTTING SPEED (mm/min) 切割速度	piercing time delay(s) 穿孔延时	torch-to-work distance 切割时距离板的距离
1-2.5mm	1.1	63A	120	6000-7500	0.1S	3-5mm
3mm	1.1 or 1.3	63A		3200	0.1S	
4mm	1.3	63A		2700	0.2S	
5mm	1.5	63A		1600	0.2S	
6mm	1.5	63A	125	1200	0.2S	
7mm	1.5	100A	135	2500	0.2S	
8mm	1.5	100A	140	1800	0.2S	
10mm	1.7	120A	150	1000	0.2S	
12mm	1.7	120A		800	0.3S	

16mm	1.7	120A	155	600	0.3S	3-5mm
18mm	1.9	160A		1200	0.3S	
20mm	1.9	160A		700	0.3S	
25mm	2.1	200A	160	800	0.3S	
30mm	2.1	200A		600	0.3S	
35mm	2.1	200A		300	0.3S	