

Mild Steel: Gas flow rate CP450G

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 30 | Plasma | | Secondary | |
| Gas | O2/O2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 4,1 | 0,25 | 5,5 | 0,33 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 45 | Plasma | | Secondary | |
| Gas | O2/O2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 5,2 | 0,31 | 7,5 | 0,45 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 50 Speed | Plasma | | Secondary | |
| Gas | O2/O2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 5,5 | 0,33 | 6,2 | 0,37 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 80 | Plasma | | Secondary | |
| Gas | O2/AIR | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 9,8 | 0,59 | 21,7 | 1,30 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 120 | Plasma | | Secondary | |
| Gas | O2/AIR | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 15,8 | 0,95 | 20,1 | 1,21 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 200 | Plasma | | Secondary | |
| Gas | O2/AIR | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 16,5 | 0,99 | 28,2 | 1,69 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 250 | Plasma | | Secondary | |
| Gas | O2/AIR | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 26,8 | 1,61 | 48,2 | 2,89 |

| Material | MS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 400 | Plasma | | Secondary | |
| Gas | O2/AIR | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 78,1 | 4,69 | 72,1 | 4,33 |

Stainless Steel: Gas flow rates CP450G

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 70 | Plasma | | Secondary | |
| Gas | N2/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 10,7 | 0,64 | 74,3 | 4,46 |

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 70 | Plasma | | Secondary | |
| Gas | F5/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 10,3 | 0,62 | 74,4 | 4,46 |

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 120 | Plasma | | Secondary | |
| Gas | N2/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 12,4 | 0,74 | 70,0 | 4,20 |

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 120 | Plasma | | Secondary | |
| Gas | H35/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 31,9 | 1,91 | 72,2 | 4,33 |

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 200 | Plasma | | Secondary | |
| Gas | H35/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 33,3 | 2,00 | 61,6 | 3,70 |

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 250 | Plasma | | Secondary | |
| Gas | H35/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 53,0 | 3,18 | 65,6 | 3,94 |

| Material | SS | Flow rate | | | |
|-------------|-----------|-----------|--------|-----------|--------|
| Current [A] | 420 | Plasma | | Secondary | |
| Gas | H35/N2 | [l/min] | [m3/h] | [l/min] | [m3/h] |
| | Cutflow_C | 43,2 | 2,59 | 75,1 | 4,51 |