

6-2. Cutting Speed

Mild Steel

Arc Current	Material Thickness		Recommended Cut Speeds	
	Inches	mm	IPM	mm/min
30	22ga (0.03)	0.79	461	11,704
	18ga (0.05)	1.22	303	7,701
	16ga (0.06)	1.52	279	7,092
	14ga (0.08)	2.01	201	5,100
40	22ga (0.03)	0.79	822	20,889
	18ga (0.05)	1.22	466	11,847
	16ga (0.06)	1.52	441	11,196
	14ga (0.08)	2.01	358	9,103
	1/8 in. (0.13)	3.18	218	5,547
	1/4 (0.25)	6.35	64	1,626
	3/8 ((0.38)	9.53	36	914
	1/2 (0.50)	12.70	22	559
5/8 (0.63)	15.88	13	330	

Stainless

Arc Current	Material Thickness		Recommended Cut Speeds	
	Inches	mm	IPM	mm/min
30	16ga (0.06)	1.52	174	4,419
	12ga (0.11)	2.67	86	2,184
40	12ga (0.11)	2.67	154	3,911
	1/8 (0.13)	3.18	137	3,480
	1/4 (0.25)	6.35	52	1,321
	3/8 (0.38)	9.53		
1/2 (0.50)	12.70	18	457	

Aluminum

Arc Current	Material Thickness		Recommended Cut Speeds	
	Inches	mm	IPM	mm/min
30	16ga (0.06)	1.52	329	8,357
	12ga (0.11)	2.67	198	5,029
40	3/32 (0.09)	2.36	281	7,137
	1/8 (0.13)	3.18	241	6,121
	1/4 (0.25)	6.35	78	1,981
	3/8 (0.38)	9.53	34	864

☞ Recommended cut speed is approximately 80% of maximum.

☞ Aluminum and Stainless Steel cut speeds at these thicknesses may be reduced as much as 20%.