



## 500W

Metal	thickness/mm	speed mm/s	pressure	Nozzle	power	Gas
SS	1	200	1.6Mpa	2.0 S	100%	N2
	2	50	1.8Mpa	2.0 S	100%	
	3	15	2.0Mpa	3.0 S	100%	
CS	1	150	5bar	1.5 D	98%	O2
	2	90	5bar	2.0 D	98%	
	3	55	5bar	2.0 D	98%	
	4	25	3bar	2.0 D	98%	
	5	20	2bar	2.0 D	98%	
	6	15	1bar	2.0 D	98%	



## 750W


Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
SS	1	240	1.6Mpa	2.0 S	100%	N2
	2	80	1.8Mpa	2.0 S	100%	
	3	25	2.0Mpa	3.0 S	100%	
	4	18	2.0Mpa	3.0 S	100%	
	5	10	2.2Mpa	3.0 S	100%	
CS	1	150	5bar	1.5 D	98%	O2
	2	80	4bar	2.0 D	98%	
	3	70	4bar	2.0 D	98%	
	4	30	3bar	2.0 D	98%	
	5	25	2bar	2.0 D	98%	
	6	18	2bar	2.0 D	98%	
	8	15	1bar	3.0 D	98%	




## 1000W


Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
SS	1	400	1.6Mpa	2.0 S	100%	氮气
	2	100	1.8Mpa	2.0 S	100%	
	3	50	2.0Mpa	3.0 S	100%	
	4	25	2.0Mpa	3.0 S	100%	
	5	15	2.2Mpa	3.0 S	100%	
	6	10	2.4Mpa	4.0 S	100%	

CS	1	150	6bar	2.0 D	98%	氧气
	2	100	5bar	2.0 D	98%	
	3	70	1bar	2.0 D	98%	
	4	40	1bar	2.0 D	98%	
	5	30	2bar	2.0 D	98%	
	6	25	0.8bar	2.0 D	98%	
	8	18	0.8bar	2.0 D	98%	
	10	15	0.8bar	3.0 D	98%	
	12	10	0.8bar	3.0 D	98%	

		1500W				
Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
SS	1	550	1.6Mpa	2.0 S	100%	N2
	2	180	1.6Mpa	2.0 S	100%	
	3	90	1.6Mpa	2.0 S	100%	
	4	50	1.6Mpa	2.0 S	100%	
	5	30	2.0Mpa	3.0 S	100%	
	6	20	2.0Mpa	3.0 S	100%	
CS	1	180	6bar	2.0 D	98%	O2
	2	80	3bar	2.0 D	98%	
	3	50	3bar	2.0 D	98%	
	4	40	0.8bar	1.5 D	98%	
	5	30	0.8bar	2.0 D	98%	
	6	25	0.8bar	2.0 D	98%	
	8	20	0.8bar	2.0 D	98%	
	10	18	0.8bar	3.0 D	98%	
	12	12	0.1bar	3.0 D	98%	
	14	10	0.1bar	3.0 D	98%	
	16	8	0.1bar	3.0 D	98%	
	18	10	0.1bar	3.0 D	98%	
	20	8	0.1bar	4.5 D	98%	

		2200W				
Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
SS	1	600	1.4Mpa	2.0 S	100%	N2
	2	200	1.4Mpa	2.0 S	100%	
	3	100	1.6Mpa	2.0 S	100%	
	4	70	2.0Mpa	3.0 S	100%	

	5	40	2.2Mpa	3.0 S	100%	
	6	25	2.4Mpa	3.0 S	100%	
	8	15	2.4Mpa	3.0 S	100%	
CS	1	180	9bar	1.5 D	50%	O2
	2	100	5bar	1.5 D	50%	
	3	60	0.8bar	1.0 D	98%	
	4	50	0.8bar	1.0 D	98%	
	5	40	0.8bar	1.0 D	98%	
	6	30	0.8bar	1.0 D	80%	
	8	20	0.8bar	2.0 D	98%	
	10	18	0.8bar	4.0 D	98%	
	12	15	0.8bar	4.0 D	98%	
	14	13	0.8bar	4.0 D	98%	
	16	11	0.8bar	4.0 D	98%	
	18	10	0.8bar	4.0 D	98%	
	20	9	0.8bar	4.5 D	98%	

		3300W				
Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
SS	1	900	1.2Mpa	2.0 S	100%	N2
	2	300	1.6Mpa	2.0 S	100%	
	3	130	1.8Mpa	2.0 S	100%	
	4	80	2.4Mpa	3.0 S	100%	
	5	60	2.4Mpa	3.0 S	100%	
	6	40	2.4Mpa	4.0 S	100%	
	8	25	2.4Mpa	4.0 S	100%	
	10	18	2.4Mpa	4.0 S	100%	
CS	1	150	9bar	2.0 D	33%	O2
	2	100	5bar	2.0 D	35%	
	3	70	1bar	1.0 D	90%	
	4	60	1bar	1.0 D	90%	
	5	50	1bar	1.0 D	60%	
	6	40	1bar	1.0 D	90%	
	8	20	0.6bar	2.0 D	60%	
	10	18	0.6bar	3.0 D	50%	
	12	15	0.6bar	3.0 D	60%	
	14	13	0.8bar	3.0 D	60%	
	16	12	0.8bar	3.0 D	70%	
	18	10	0.8bar	4.5 D	70%	
	20	10	0.8bar	4.5 D	70%	



## 4000W

Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
CS	1	180	0.9	2.0 D	20%	N2
	2	100	0.5	2.0 D	20%	
	3	60	0.1	1.0 D	60%	
	4	50	0.1	1.0 D	80%	
	5	50	0.08	1.2 D	80%	
	6	40	0.08	1.2 D	80%	
	8	35	0.08	1.2 D	80%	
	10	20	0.06	3.5 D	45%	
	12	16	0.06	3.5 D	50%	
	14	13	0.06	3.5 D	50%	
	16	12	0.06	3.5 D	50%	
	18	11	0.06	3.5 D	50%	
	20	10	0.07	4.0 D	50%	
	22	9	0.07	4.0 D	50%	
SS	1	900	1.2Mpa	1.5 S	100%	O2
	2	400	1.2Mpa	1.5 S	100%	
	3	170	1.6Mpa	2.0 S	100%	
	4	120	2.0Mpa	2.0 S	100%	
	5	90	2.0Mpa	3.0 S	100%	
	6	60	2.4Mpa	4.0 S	100%	
	8	25	2.4Mpa	4.0 S	100%	
	10	20	2.4Mpa	4.0 S	100%	
	12	14	2.4Mpa	5.0 S	100%	



## 6000W

Metal	thickness/mm	Speed mm/s	Pressure	Nozzle	Power	Gas
SS	1	800	1.6Mpa	2.0 S	60%	N2
	2	600	1.6Mpa	2.0 S	100%	
	3	200	1.6Mpa	2.0 S		
	4	150	2.0Mpa	3.0 S		
	5	100	2.0Mpa	3.0 S		
	6	70	2.4Mpa	3.0 S		

	8	50	2.4Mpa	4.0 S		
	10	35	2.4Mpa	4.0 S		
	12	25	2.4Mpa	4.0 S		
	14	18	2.4Mpa	4.0 S		
CS	1	150	0.6Mpa	2.0 D	20%	02
	2	100	0.6Mpa	2.0 D	20%	
	3	60	0.1Mpa	1.0 D	50%	
	3	80	0.5Mpa	2.0 D	20%	
	4	60	0.1Mpa	1.0 D	50%	
	5	55	0.1Mpa	1.0 D	50%	
	6	55	0.1Mpa	1.0 D	50%	
	8	20	0.06Mpa	2.0 D	25%	
	8	38	0.08Mpa	1.5 D	60%	
	10	20	0.08Mpa	3.0 D	27%	
	10	40	0.06Mpa	1.5 D	70%	
	12	15	0.06Mpa	3.0 D	27%	
	14	13	0.08Mpa	3.0 D	34%	
	16	12	0.08Mpa	3.0 D	35%	
	18	12	0.1Mpa	4.5 D	40%	
	20	11	0.08Mpa	4.5 D	40%	
22	10	0.1Mpa	4.5 D	40%		

2017/10/31