

Torch type: SCM80R

Gas type: Compressed Air

Gas Pressure: 5.0 bar

Gas flow: 160l/min

Material type: Mild steel

Machine	Arc current (amps)	Material thickness (mm)	Torch-to-work distance (mm)	Initial pierce height (mm)	Pierce time delay (sec)
CUT45PFC	30	5	4	4	0.7
		10	4	4	3
	45	5	4	5	0.5
		10	4	5	0.8
		20	4	Edge start recommended	
CUT80	50	10	4	5	0.8
		20	4	Edge start recommended	
	80	10	4	5	0.6
		20	4	5	3.5
		30	4	Edge start recommended	
		40	4	Edge start recommended	

Recommended		Maximum	
Cut speed (mm/min)	Voltage (V)	Cut speed (mm/min)	Voltage (V)
500	120	750	116
150	136	250	132
1000	115		
500	124	740	114
120	137	185	134
600	126	800	122
200	137	250	134
1000	115		
400	123	600	120
150	137	220	135
		100	143