

Layer Parameter Settings

Global Parameter

layer1

Material: Thickness: 0.0mm nozzle model:

☒ Short Move ☐ Pre-pierce ☐ Evaporation film ☐ Path Cool ☐ Multi-times 0 ☐ Keep puffing ☐ Disable ☐ Disable Follow Standard

Cut Pierce

Cut Speed: 1 m/min

Lift Height: 3 mm

Cut Height: 3 mm

Cut Gas: Oxygen

Cut Pressure: 0.1 BAR

Cut Cur: 70 %

Cut Pwr: 700 W

Cut Pwr: 10 %

Cut Freq: 1000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 0 ms

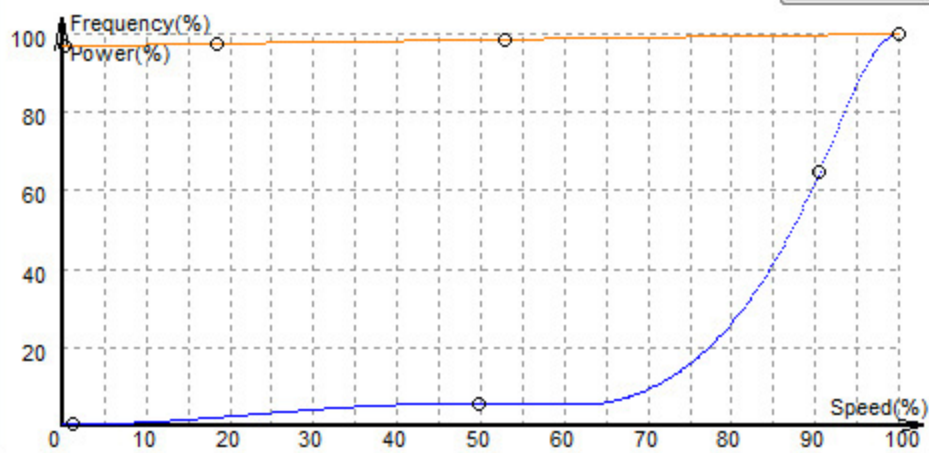
Laser off delay: 0 ms

☐ Slow Lead Length: 2 mm Speed: 0.18 m/min

☐ Slow Stop Length: 2 mm Speed: 0.18 m/min

☒ Dymc Pwr Adj ☒ Dymc Freq Adj ☐ Show in Abs

Curve edit



User Notes GRAVIROVKA

焦点3.5
双1.0

Гравировка

✓ OK(O)

Layer Parameter Settings



Global Parameter

layer1

Material: Thickness: 0.0mm nozzle model:

☒ Short Move ☐ Pre-pierce ☐ Evaporation film ☐ Path Cool ☐ Multi-times ☐ Keep puffing ☐ Disable ☐ Disable Follow

☒ No Pierce ☐ 1 Stage ☐ 2 Stages ☐ 3 Stages

<input checked="" type="checkbox"/> Step Time: <input type="text" value="600"/> ms	<input type="checkbox"/> Step Time: <input type="text" value="1020"/> ms	<input type="checkbox"/> Step Time: <input type="text" value="1000"/> ms
Piercing Height: <input type="text" value="10"/> mm	Piercing Height: <input type="text" value="15"/> mm	Piercing Height: <input type="text" value="15"/> mm
Piercing Gas: <input type="text" value="Oxygen"/>	Piercing Gas: <input type="text" value="Oxygen"/>	Piercing Gas: <input type="text" value="Oxygen"/>
Piercing Pres: <input type="text" value="0.1"/> BAR	Piercing Pres: <input type="text" value="0.5"/> BAR	Piercing Pres: <input type="text" value="5"/> BAR
Piercing Cur: <input type="text" value="100"/> %	Piercing Cur: <input type="text" value="100"/> %	Piercing Cur: <input type="text" value="100"/> %
Piercing Pwr: <input type="text" value="1,000"/> W	Piercing Pwr: <input type="text" value="1,000"/> W	Piercing Pwr: <input type="text" value="1,000"/> W
Piercing Pwr: <input type="text" value="60"/> %	Piercing Pwr: <input type="text" value="70"/> %	Piercing Pwr: <input type="text" value="50"/> %
Piercing Freq: <input type="text" value="400"/> Hz	Piercing Freq: <input type="text" value="400"/> Hz	Piercing Freq: <input type="text" value="5000"/> Hz
Beam Size: <input type="text" value="0"/> x	Beam Size: <input type="text" value="0"/> x	Beam Size: <input type="text" value="0"/> x
Piercing Focus: <input type="text" value="0"/> mm	Piercing Focus: <input type="text" value="0"/> mm	Piercing Focus: <input type="text" value="0"/> mm
Piercing Time: <input type="text" value="0"/> ms	Piercing Time: <input type="text" value="1500"/> ms	Piercing Time: <input type="text" value="200"/> ms
<input type="checkbox"/> Extra Puffing: <input type="text" value="500"/> ms	<input type="checkbox"/> Extra Puffing: <input type="text" value="500"/> ms	<input type="checkbox"/> Extra Puffing: <input type="text" value="500"/> ms

User Notes GRAVIROVKA

焦点3.5
双1.0

Гравировка

☒ OK(0)

Layer Parameter Settings

Global Parameter

layer 1

Material: Thickness: 0.0mm nozzle model:

☒ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

Cut Speed: 1.6 m/min

Lift Height: 35 mm

Cut Height: 0.5 mm

Cut Gas: Oxygen

Cut Pressure: 0.5 BAR

Cut Cur: 100 %

Cut Pwr: 100 %

Cut Freq: 5000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 0 ms

Laser off delay: 0 ms

☐ Slow Lead Length: 2 mm Speed: 0.18 m/min

☐ Slow Stop Length: 2 mm Speed: 0.18 m/min

☒ Dymc Pwr Adj

☒ Dymc Freq Adj

☐ Show in Abs

Curve edit

Frequency(%)

Power(%)

Speed(%)

100

80

60

40

20

0

10

20

30

40

50

60

70

80

90

100

User Notes 3 mm good quality nozzle 1.5 focus +3.5 GQ

焦点3.5
双1.0

CT3, 09Г2C

t=3 MM

OK(O)

Global Parameter

layer 1

Material:

Thickness: 0.0mm

nozzle model:

☒ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

☐ No Pierce

☒ 1 Stage

☐ 2 Stages

☐ 3 Stages

☒ Step Time:

600

ms

Piercing Height:

10

mm

Piercing Gas:

Oxygen

Piercing Pres:

0.1

BAR

Piercing Cur:

100

%

Piercing Pwr:

30

%

Piercing Freq:

400

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

0

ms

☐ Extra Puffing:

500

ms

☐ Step Time:

1020

ms

Piercing Height:

15

mm

Piercing Gas:

Oxygen

Piercing Pres:

0.5

BAR

Piercing Cur:

100

%

Piercing Pwr:

70

%

Piercing Freq:

400

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

1500

ms

☐ Extra Puffing:

500

ms

☐ Step Time:

1000

ms

Piercing Height:

15

mm

Piercing Gas:

Oxygen

Piercing Pres:

5

BAR

Piercing Cur:

100

%

Piercing Pwr:

50

%

Piercing Freq:

5000

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

200

ms

☐ Extra Puffing:

500

ms

User Notes 3 mm good quality nozzle 1.5 focus +3.5 GQ

焦点3.5
双1.0

CT3, 09Γ2C

t=3 MM

✓

OK(O)

Layer Parameter Settings

Global Parameterlayer 1

Material:Thickness: 0.0mmnozzle model:

☐ Short Move☐ Pre-pierce☐ Evaporation film☐ Path Cool☐ Multi-times 0☐ Keep puffing☐ Disable☐ Disable FollowStandard

CutPierce

Cut Speed:1.2 m/min

Lift Height:25 mm

Cut Height:0.5 mm

Cut Gas:Oxygen

Cut Pressure:0.6 BAR

Cut Cur:1,000 W

Cut Pwr:100 %

Cut Freq:5000 Hz

Beam Size:0 x

Cut Focus:0.01 mm

Delay Time:0 ms

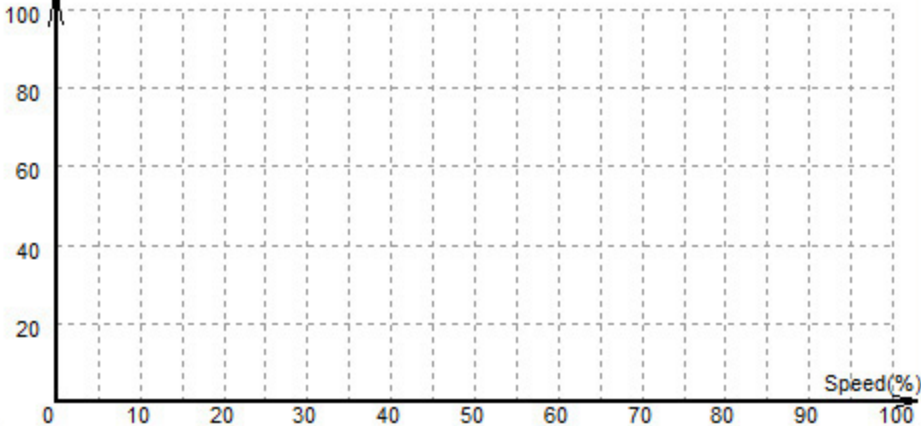
Laser off delay150 ms

☒ Slow LeadLength: 4 mmSpeed: 0.4 m/min

☐ Slow StopLength: 4 mmSpeed: 0.4 m/min

☐ Dymc Pwr Adj☐ Dymc Freq Adj☐ Show in Abs

Curve edit



User Notes4 mm good quality nozzle 1.5 focus +2.5

CT3, 09Γ2C

t=4 mm

✓OK(O)

Material:

Thickness: 0.0mm

nozzle model:

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

☐ No Pierce☒ 1 Stage☐ 2 Stages☐ 3 Stages

<input checked="" type="checkbox"/> Step Time:	2000	ms	<input checked="" type="checkbox"/> Step Time:	1000	ms	<input type="checkbox"/> Step Time:	1000	ms
Piercing Height	5	mm	Piercing Height	5	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.3	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	60	%	Piercing Cur:	100	%
	1,000	W		600	W		1,000	W
Piercing Pwr:	20	%	Piercing Pwr:	30	%	Piercing Pwr:	50	%
Piercing Freq:	400	Hz	Piercing Freq:	1000	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	700	ms	Piercing Time:	2000	ms	Piercing Time:	200	ms
<input type="checkbox"/> Extra Puffing:	1000	ms	<input type="checkbox"/> Extra Puffing:	500	ms	<input type="checkbox"/> Extra Puffing:	500	ms

User Notes

4 mm good quality nozzle 1.5 focus +2.5

CT3, 09Г2C

t=4 mm

Layer Parameter Settings

Global Parameter

layer 1

Material:

Thickness: 0.0mm

nozzle model:

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

Cut Speed: 1.4 m/min

Lift Height: 18 mm

Cut Height: 0.8 mm

Cut Gas: Oxygen

Cut Pressure: 0.55 BAR

Cut Cur: 100 %

Cut Pwr: 1,000 W

Cut Freq: 100 %

Cut Freq: 5000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 0 ms

Laser off delay: 100 ms

☐ Slow Lead Length: 2 mm Speed: 0.1 m/min

☐ Slow Stop Length: 2 mm Speed: 0.18 m/min

☒ Dymc Pwr Adj

☐ Dymc Freq Adj

☐ Show in Abs

Curve edit

Power(%)

Speed(%)	Power(%)
0	85
20	90
65	98
100	100

Speed(%)

User Notes 5 mm good quality nozzle 1.5 focus +2.5



CT3, 09Г2C

t=5 mm

✓ OK(O)

Global Parameter

layer 1

Material: Thickness: 0.0mm nozzle model:  

☐ Short Move ☐ Pre-pierce ☐ Evaporation film ☐ Path Cool ☐ Multi-times 0 ☐ Keep puffing ☐ Disable ☐ Disable Follow Standard

Cut

Pierce

☐ No Pierce ☒ 1 Stage ☐ 2 Stages ☐ 3 Stages

☒ Step Time: 700 ms
Piercing Height: 6 mm
Piercing Gas: Oxygen
Piercing Pres: 0.1 BAR
Piercing Cur: 100 %
Piercing Pwr: 40 %
Piercing Freq: 1000 Hz
Beam Size: 0 x
Piercing Focus: 0 mm
Piercing Time: 500 ms
☐ Extra Puffing: 1000 ms

☒ Step Time: 1100 ms
Piercing Height: 6 mm
Piercing Gas: Oxygen
Piercing Pres: 0.3 BAR
Piercing Cur: 60 %
Piercing Pwr: 30 %
Piercing Freq: 1000 Hz
Beam Size: 0 x
Piercing Focus: 0 mm
Piercing Time: 2000 ms
☐ Extra Puffing: 500 ms

☐ Step Time: 1000 ms
Piercing Height: 15 mm
Piercing Gas: Oxygen
Piercing Pres: 5 BAR
Piercing Cur: 100 %
Piercing Pwr: 50 %
Piercing Freq: 5000 Hz
Beam Size: 0 x
Piercing Focus: 0 mm
Piercing Time: 200 ms
☐ Extra Puffing: 500 ms

Layer Parameter Settings

Global Parameter

layer 1

Material: Thickness: 0.0mm nozzle model:

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

Cut Speed: 1 m/min

Lift Height: 35 mm

Cut Height: 0.8 mm

Cut Gas: Oxygen

Cut Pressure: 0.5 BAR

Cut Cur: 100 %

1,000 W

Cut Pwr: 100 %

Cut Freq: 5000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 0 ms

Laser off delay: 100 ms

☐ Slow Lead Length: 2 mm Speed: 0.1 m/min

☐ Slow Stop Length: 2 mm Speed: 0.18 m/min

☒ Dymc Pwr Adj

☐ Dymc Freq Adj

☐ Show in Abs

Curve edit

Power(%)

Speed(%)	Power(%)
0	85
20	92
65	98
100	100

Speed(%)

User Notes 6 mm good quality nozzle 1.5 focus +3

CT3, 09Γ2C

t=6 mm

✓

OK(O)

Layer Parameter Settings



Global Parameter

layer 1

Material: Thickness: 0.0mm nozzle model:



☐ Short Move ☐ Pre-pierce ☐ Evaporation film ☐ Path Cool ☐ Multi-times ☐ Keep puffing ☐ Disable ☐ Disable Follow

Cut Pierce

☐ No Pierce ☒ 1 Stage ☐ 2 Stages ☐ 3 Stages

<input checked="" type="checkbox"/> Step Time: 5000 ms	<input checked="" type="checkbox"/> Step Time: 1100 ms	<input type="checkbox"/> Step Time: 1000 ms
Piercing Height: 6 mm	Piercing Height: 4 mm	Piercing Height: 15 mm
Piercing Gas: Oxygen	Piercing Gas: Oxygen	Piercing Gas: Oxygen
Piercing Pres: 0.1 BAR	Piercing Pres: 0.3 BAR	Piercing Pres: 5 BAR
Piercing Cur: 100 %	Piercing Cur: 90 %	Piercing Cur: 100 %
Piercing Pwr: 1,000 W	Piercing Pwr: 900 W	Piercing Pwr: 1,000 W
Piercing Freq: 35 %	Piercing Freq: 30 %	Piercing Freq: 50 %
Piercing Freq: 600 Hz	Piercing Freq: 800 Hz	Piercing Freq: 5000 Hz
Beam Size: 0 x	Beam Size: 0 x	Beam Size: 0 x
Piercing Focus: 0 mm	Piercing Focus: 0 mm	Piercing Focus: 0 mm
Piercing Time: 0 ms	Piercing Time: 2000 ms	Piercing Time: 200 ms
<input type="checkbox"/> Extra Puffing: 1000 ms	<input type="checkbox"/> Extra Puffing: 500 ms	<input type="checkbox"/> Extra Puffing: 500 ms

User Notes 6 mm good quality nozzle 1.5 focus +3

CT3, 09Γ2C

t=6 mm

☒ OK(O)

Layer Parameter Settings

Global Parameter

layer 1

Material:

Thickness: 0.0mm

nozzle model:

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

Cut Speed: 0.7 m/min

Lift Height: 17 mm

Cut Height: 1 mm

Cut Gas: Oxygen

Cut Pressure: 0.6 BAR

Cut Cur: 100 %

1,000 W

Cut Pwr: 100 %

Cut Freq: 5000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 0 ms

Laser off delay: 200 ms

☐ Slow Lead

Length: 5 mm

Speed: 0.2 m/min

☐ Slow Stop

Length: 5 mm

Speed: 0.2 m/min

☐ Dymc Pwr Adj

☐ Dymc Freq Adj

☐ Show in Abs

Curve edit

100

80

60

40

20

0

0

10

20

30

40

50

60

70

80

90

100

Speed(%)

User Notes

8 mm good quality nozzle 1.5 focus +2

焦点2

双2.0

CT3, 09Г2C

t=8 mm

✓

OK(O)

Global Parameter

layer 1

Material:Thickness: 0.0mmnozzle model:

☐ Short Move☐ Pre-pierce☐ Evaporation film☐ Path Cool☐ Multi-times

0

☐ Keep puffing☐ Disable☐ Disable Follow

Standard

CutPierce

☐ No Pierce☒ 1 Stage☐ 2 Stages☐ 3 Stages

☒ Step Time:

3000

ms

Piercing Height:

5

mm

Piercing Gas:

Oxygen

Piercing Pres:

0.1

BAR

Piercing Cur:

100

%

Piercing Pwr:

1,000

W

Piercing Freq:

400

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

700

ms

☐ Extra Puffing:

500

ms

☐ Step Time:

300

ms

Piercing Height:

10

mm

Piercing Gas:

Oxygen

Piercing Pres:

0.2

BAR

Piercing Cur:

100

%

Piercing Pwr:

1,000

W

Piercing Freq:

400

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

2000

ms

☐ Extra Puffing:

500

ms

☐ Step Time:

1000

ms

Piercing Height:

15

mm

Piercing Gas:

Oxygen

Piercing Pres:

5

BAR

Piercing Cur:

100

%

Piercing Pwr:

1,000

W

Piercing Freq:

5000

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

200

ms

☐ Extra Puffing:

500

ms

Global Parameter

layer 1

Material:

Thickness: 0.0mm

nozzle model:

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

Cut Speed: 0.6 m/min

Lift Height: 14 mm

Cut Height: 0.8 mm

Cut Gas: Oxygen

Cut Pressure: 0.6 BAR

Cut Cur: 100 %

Cut Pwr: 100 %

Cut Freq: 5000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 400 ms

Laser off delay: 100 ms

☐ Slow Lead

Length: 2 mm

Speed: 0.1 m/min

☐ Slow Stop

Length: 2 mm

Speed: 0.18 m/min

☒ Dymc Pwr Adj

☒ Dymc Freq Adj

☐ Show in Abs

Curve edit

Frequency(%)

Power(%)

Speed(%)

The graph displays two curves: a blue curve for Frequency(%) and an orange curve for Power(%). The x-axis represents Speed(%) from 0 to 100, and the y-axis represents both Frequency(%) and Power(%) from 0 to 100. The blue curve starts at (0,0) and rises to (100,100). The orange curve starts at (0,100) and remains at 100% until approximately 90% speed, then drops to 0% at 100% speed.

Speed(%)	Frequency(%)	Power(%)
0	0	100
10	0	100
20	0	100
30	0	100
40	0	100
50	0	100
60	0	100
70	0	100
80	0	100
90	0	100
100	100	0

Global Parameter

layer 1

Material:Thickness: 0.0mmnozzle model:

☐ Short Move☐ Pre-pierce☐ Evaporation film☐ Path Cool☐ Multi-times

0

☐ Keep puffing☐ Disable☐ Disable Follow

Standard

Cut

Pierce

☐ No Pierce☒ 1 Stage☐ 2 Stages☐ 3 Stages

☒ Step Time:

4000

ms

Piercing Height:

7

mm

Piercing Gas:

Oxygen

Piercing Pres:

0.4

BAR

Piercing Cur:

100

%

Piercing Pwr:

1,000

W

Piercing Freq:

600

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

550

ms

☐ Extra Puffing:

500

ms

☒ Step Time:

4000

ms

Piercing Height:

8

mm

Piercing Gas:

Oxygen

Piercing Pres:

0.4

BAR

Piercing Cur:

100

%

Piercing Pwr:

1,000

W

Piercing Freq:

800

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

800

ms

☐ Extra Puffing:

500

ms

☐ Step Time:

1000

ms

Piercing Height:

15

mm

Piercing Gas:

Oxygen

Piercing Pres:

5

BAR

Piercing Cur:

100

%

Piercing Pwr:

1,000

W

Piercing Freq:

5000

Hz

Beam Size:

0

x

Piercing Focus:

0

mm

Piercing Time:

200

ms

☐ Extra Puffing:

500

ms

User Notes

10 mm good quality nozzle 2 focus +2.5(max edt)



Ст3, 09Г2С Вариант №1 t=10 мм

✓

OK(O)

Global Parameter

layer 1

Material: Thickness: 0.0mm nozzle model:  

☐ Short Move ☐ Pre-pierce ☐ Evaporation film ☐ Path Cool ☐ Multi-times 0 ☐ Keep puffing ☐ Disable ☐ Disable Follow Standard

Cut

Pierce

☐ No Pierce ☒ 1 Stage ☐ 2 Stages ☐ 3 Stages

☒ Step Time: 12000 ms
Piercing Height: 7 mm
Piercing Gas: Oxygen
Piercing Pres: 0.4 BAR
Piercing Cur: 100 %
Piercing Pwr: 1,000 W
Piercing Freq: 600 Hz
Beam Size: 0 x
Piercing Focus: 0 mm
Piercing Time: 0 ms
☐ Extra Puffing: 500 ms

☒ Step Time: 4000 ms
Piercing Height: 8 mm
Piercing Gas: Oxygen
Piercing Pres: 0.4 BAR
Piercing Cur: 100 %
Piercing Pwr: 55 %
Piercing Freq: 800 Hz
Beam Size: 0 x
Piercing Focus: 0 mm
Piercing Time: 800 ms
☐ Extra Puffing: 500 ms

☐ Step Time: 1000 ms
Piercing Height: 15 mm
Piercing Gas: Oxygen
Piercing Pres: 5 BAR
Piercing Cur: 100 %
Piercing Pwr: 50 %
Piercing Freq: 5000 Hz
Beam Size: 0 x
Piercing Focus: 0 mm
Piercing Time: 200 ms
☐ Extra Puffing: 500 ms

User Notes 10 mm good quality nozzle 2 focus +2.5(max edt)

Global Parameter

layer 1

Material: 不锈钢

Thickness: 12.0mm

nozzle model: d1.5

📁

📄

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

Cut Speed: 3.2 m/min

Lift Height: 8 mm

Cut Height: 0.5 mm

Cut Gas: NitrogenH

Cut Pressure: 0.45 BAR

Cut Cur: 100 %

1,000 W

Cut Pwr: 100 %

Cut Freq: 5000 Hz

Beam Size: 0 x

Cut Focus: 0 mm

Delay Time: 400 ms

Laser off delay: 0 ms

☐ Slow Lead

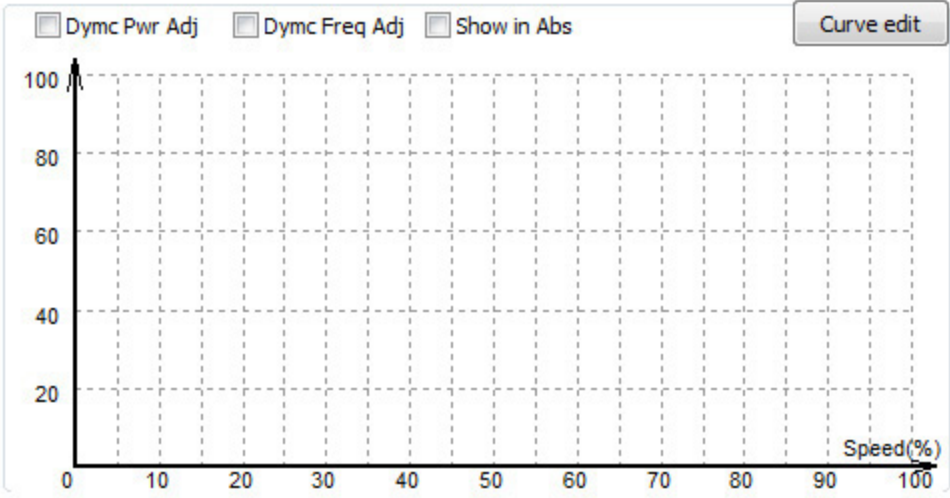
Length: 3 mm

Speed: 0.12 m/min

☐ Slow Stop

Length: 0 mm

Speed: 0.12 m/min



User Notes

3mm 340 st

MPa 0.78 fokus -2.85

08X18H10 (AISI 304)

t=3 MM

Material: 不锈钢

Thickness: 12.0mm

nozzle model: d1.5

📁

📄

☐ Short Move

☐ Pre-pierce

☐ Evaporation film

☐ Path Cool

☐ Multi-times

0

☐ Keep puffing

☐ Disable

☐ Disable Follow

Standard

Cut

Pierce

☐ No Pierce

☒ 1 Stage

☐ 2 Stages

☐ 3 Stages

<input checked="" type="checkbox"/> Step Time:	200	ms	<input type="checkbox"/> Step Time:	1000	ms	<input type="checkbox"/> Step Time:	1000	ms
Piercing Height:	2	mm	Piercing Height:	11	mm	Piercing Height:	15	mm
Piercing Gas:	NitrogenH		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	1.1	BAR	Piercing Pres:	1.2	BAR	Piercing Pres:	1	BAR
Piercing Cur:	100	%	Piercing Cur:	100	%	Piercing Cur:	100	%
	1,000	W		1,000	W		1,000	W
Piercing Pwr:	100	%	Piercing Pwr:	100	%	Piercing Pwr:	50	%
Piercing Freq:	100	Hz	Piercing Freq:	100	Hz	Piercing Freq:	50	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	500	ms	Piercing Time:	1000	ms	Piercing Time:	200	ms
<input type="checkbox"/> Extra Puffing:	500	ms	<input checked="" type="checkbox"/> Extra Puffing:	500	ms	<input checked="" type="checkbox"/> Extra Puffing:	500	ms

User Notes

3mm 340 st

MPa 0.78 fokus -2.85

08X18H10 (AISI 304)

t=3 MM