

30000W Laser Cutting Table

Material	Thickness[mm]	Speed[m/min]	Power[W]	Gas	Pressure[bar]	Nozzle[m]
Mild Steel	5	22-30	30000	N2/Air	8	3.0S
	6	18-22			8	3.0S
	8	14-16			8	3.0S
	10	12-14			8	3.5S
	12	10-12			8	3.5S
	14	8-10			8	4.0S
	16	8-8.5			8	5.0S
	18	5.5-6.5			10	6.0S
	20	4.5-5.5			10	6.0S
	25	2.8-3.2			10	6.0S
Mild Steel	10	2-2.3	6000	O2 Positive focus	0.6	1.2E
	12	1.8-2	7500		0.6	1.2E
	14	1.6-1.8	8500		0.6	1.4E
	16	1.6-1.8	9500		0.6	1.4E
	20	1.5-1.6	12000		0.6	1.6E
	22	1.4-1.5	18000		0.7	1.4SP
	25	1.2-1.4	18000		1.0	1.5SP
	30	1.2-1.3	19000		1.2	1.5SP
	40	0.9-1.1	20000		1.4	1.5SP
	50	0.6-0.8	30000		1.6	1.8SP
	60	0.2-0.25			1.6	1.8E
	70	0.18-0.2			1.7	1.8E

Material	Thickness[mm]	Speed[m/min]	Power[W]	Gas	Pressure[bar]	Nozzle[m]
	80	0.12-0.15			1.8	1.8E
Mild Steel	12	3.2-3.5	30000	O2 Negative focus	1	1.6SP
	14	3-3.2			1	1.6SP
	16	3-3.1			1	1.6SP
	20	2.8-3			1.2	1.6SP
	25	2.6-2.8			1.3	1.8SP
	30	2.2-2.6			1.4	1.8SP
	35	1.4-1.6			1.4	2.0SP
	40	1-1.4			1.5	2.5S
	45	0.8-0.9			1.6	2.5S
Stainless Steel	1	50-60	30000	N2	8	2.0S
	2	50-60			8	2.0S
	3	40-50			8	2.5S
	4	35-40			8	2.5S
	5	25-30			8	3.0S
	6	22-25			8	3.5B
	8	18-22			8	5.0B
	10	13-16			8	5.0B
	12	10-12			8	6.0B
	14	8-10			8	6.0B
	16	7-8			8	6.0B
	18	6-7			8	6.0B
	20	4-5			12	6.0B
	25	2-2.5			12	7.0B

Material	Thickness[mm]	Speed[m/min]	Power[W]	Gas	Pressure[bar]	Nozzle[m]
	30	1.2-2			12	7.0B
	40	0.6-0.8			16	7.0B
	50	0.2-0.3			16	8.0B
	60	0.15-0.2			20	8.0B
	70	0.1-0.13			20	8.0B
	80	0.08-0.1			20	8.0B
	90	0.05-0.06			20	8.0B
	100	0.04-0.05			20	8.0B
Stainless Steel	1	50-60	30000	Air	8	2.0S
	2	50-60			8	2.5S
	3	40-50			8	2.5S
	4	35-40			8	3.5B
	5	25-30			8	3.5B
	6	22-25			8	3.5B
	8	18-22			10	3.5B
	10	14-18			10	3.5B
	12	12-14			10	5.0B
	14	10-12			10	5.0B
	16	8-9			10	5.0B
	18	6-7			10	5.0B
	20	5-6			10	5.0B
	25	2.5-3			10	5.0B
	30	1.5-2			10	5.0B
	40	0.8-1			16	7.0B

Material	Thickness[mm]	Speed[m/min]	Power[W]	Gas	Pressure[bar]	Nozzle[m]
	50	0.2-0.3			16	8.0B
	60	0.15-0.2			20	8.0B
	70	0.1-0.13			20	8.0B
Aluminum Alloy	1	55-60	30000	N2	8	2.0S
	2	40-45			8	2.0S
	3	30-35			10	2.5S
	4	25-30			12	2.5S
	5	18-25			14	3.0S
	6	18-20			14	3.0S
	8	15-18			14	3.5S
	10	12-15			14	3.5S
	12	10-12			16	5.0B
	14	8-10			16	5.0B
	16	6-8			16	5.0B
	18	3-4			16	5.0B
	20	2-3			18	6.0B
	25	1.5-2			18	6.0B
	30	0.8-1			20	7.0B
	40	0.5-0.8			20	7.0B
	50	0.4-0.6			20	8.0B
	60	0.2-0.3			20	8.0B
Brass	1	40-45	30000	N2	12	2.0S
	2	35-40			12	2.0S
	3	28-30			12	2.0S

Material	Thickness[mm]	Speed[m/min]	Power[W]	Gas	Pressure[bar]	Nozzle[m]
	4	20-25			12	2.5S
	5	18-20			14	2.5S
	6	15-18			14	3.0S
	8	10-15			14	3.0S
	10	8-10			14	5.0B
	12	5-8			14	5.0B
	14	3-5			16	5.0B
	16	1.5-2			18	5.0B
	18	1.2-1.5			18	5.0B
	20	0.8-1			18	6.0B
Copper	1	25-30	30000	O2	5	2.0S
	2	25-30			5	2.0S
	3	20-25			6	2.0S
	4	18-20			8	2.5S
	5	15-18			8	2.5S
	6	10-15			8	3.0S
	8	6-10			10	3.0S
	10	2-3.5			12	3.5S
	12	2-2.5			12	3.5S