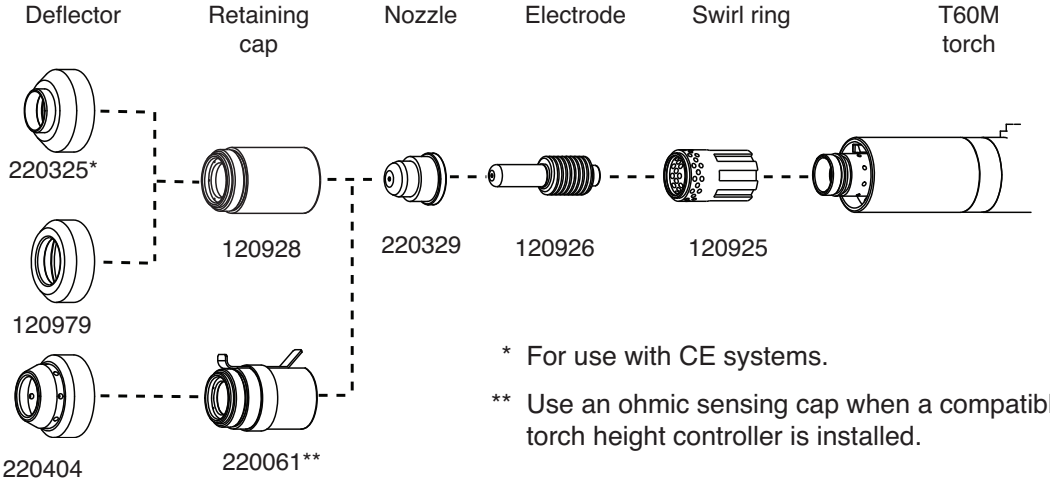
FineCut consumables

- Torch-to-work distance for the following cut chart is 0.08 inches (2.032 mm) for mild steel and 0.010 inches (0.254 mm) for stainless steel.



* For use with CE systems.

** Use an ohmic sensing cap when a compatible torch height controller is installed.

Mild steel

Arc current	Arc voltage	Material thickness		Approximate travel speeds	
		inches	**mm**	ipm	mm/min
50	76	**10 ga**	**3.4**	90	2286
40	83	**10 ga**	**3.4**	50	1270
45	77	**12 ga**	**2.7**	120	3048
40	81	**12 ga**	**2.7**	70	1778
	79	**14 ga**	**1.9**	135	3429
	79	**16 ga**	**1.5**	150	3810
	79	**18 ga**	**1.2**	150	3810
	78	**20 ga**	**0.9**	120	3048
30	80	**24 ga**	**0.6**	150	3810

Stainless steel

Arc current	Arc voltage	Material thickness		Approximate travel speeds	
		inches	**mm**	ipm	mm/min
50	63	**10 ga**	**3.4**	80	1905
40	73	**10 ga**	**3.4**	60	1524
45	63	**12 ga**	**2.7**	100	3174
40	72	**12 ga**	**2.7**	80	1905
	65	**14 ga**	**1.9**	150	3810
	64	**16 ga**	**1.5**	150	3810
	64	**18 ga**	**1.2**	150	3810
	65	**20 ga**	**0.9**	150	3810
30	66	**24 ga**	**0.6**	150	3810