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Material	Thickness (mm)	Cutting speed(m/min)	Auxiliary Gas
Stainless steel	1	55-60	Air/Oxygen
	2	25-30	Air/Oxygen
	3	10-12	Air/Oxygen
	5	4-4.5	Air/Oxygen
	6	2.5-3	Air/Oxygen
	8	1.2-1.5	Air/Oxygen
	10	0.6-0.8	Air/Oxygen
Carbon Steel	1	31.8-45	Air/Oxygen
	2	4-6	Oxygen
	3	3.5-5	Oxygen
	4	2.4-3.3	Oxygen
	5	2.4-3.0	Oxygen
	6	2.4-3.0	Oxygen
	8	1.8-2.4	Oxygen
	10	1.1-1.9	Oxygen
	12	1-1.3	Oxygen
	14	0.8-1.2	Oxygen
	16	0.6-0.9	Oxygen
	18	0.5-0.7	Oxygen
	20	0.48-0.6	Oxygen
Aluminum	1	50-60	Nitrogen
	2	9-11	Nitrogen
	3	4-5	Nitrogen
	4	2-2.4	Nitrogen
	6	1.6-2	Nitrogen
Brass	1	30-40	Nitrogen
	2	12-15	Nitrogen
	3	6-8	Nitrogen
	4	3-4	Nitrogen
	6	0.7-0.9	Nitrogen