

PLASMA CUTTING PARAMETER GUIDE

The following parameters can be used as a guide to cutting different materials and thicknesses with the VIPER CUT 30. They are intended as a guide only, you may adjust depending on personal preference as well as the condition of the torch/material/air.

VIPER CUT 30 - MILD STEEL PARAMETERS (75 PSI)

Material Thickness (mm)	Amps	Travel Speed (mm/min)
2-3mm	24A	360 mm/min
5-6mm	27A	340 mm/min
8-10mm	30A	240 mm/min
12mm	30A	200 mm/min

VIPER CUT 30 - STAINLESS STEEL/ALUMINIUM PARAMETERS (75 PSI)

Material Thickness (mm)	Amps	Travel Speed (mm/min)
2-3mm	25A	360 mm/min
5mm	27A	300 mm/min
6mm	30A	300 mm/min