



MFSC-1500X Continuous laser source (50μm)								
Material	Thickness (mm)	Speed (m/min)	Power (W)	Gas	Pressure (bar)	spray head (mm)	Focus Position (mm)	Cutting height (mm)
carbon steel	1	22-25	1500	N2/ Air	10	2.0 single	0	0.6
	2	4-5		O2	1.5	1.0 double	5	0.6
	3	3-4			0.6	1.0 double	5	0.6
	4	2.3-2.8			0.6	1.0 double	5	0.6
	5	1.8-2.3			0.6	1.0 double	5	0.6
	6	1.6-2.0			0.6	1.0 double	5	0.6
	8	1.2-1.5			0.8	4.0 double	2	1.5
	10	0.9-1.2			0.8	4.0 double	2	1.5
	12	0.8			0.8	4.0 double	2	1.5
	14	0.65			0.8	4.0 double	2.5	1.5
	16	0.5			0.8	4.0 double	3	1.5
stainless steel	1	20-35	1500	N2	10	2.0 single	0	0.5
	2	44783			10	2.0 single	-1	0.5
	3	4.5-5.5			12	3.0 single	-1.5	0.5
	5	1.5-2.0			15	3.0 single	-5	0.5
	6	0.7-0.9			15	4.0 single	-5	0.5
aluminium alloy	1	15-18	1500	N2	10	2.0 single	0	0.5
	2	4.0-5.0			12	2.0 single	-1	0.5
	3	1.5-2.5			14	2.5 single	-1.5	0.5
	4	1.0-1.3			14	3.0 single	-2.5	0.5
brass	1	12-15	1500	N2	10	3.0 single	0	0.5
	2	4.0-5.0			10	3.0 single	-1	0.5
	3	1.5-2.0			10	3.0 single	-1	0.5

MFSC-2000X continuous wave laser (50 μm)											
Material	Thickness (mm)	Speed (mm/min)	Power (W)	Gas	Pressure (bar)	spray head (mm)	Focus (mm)	Cutting (mm)			
Carbon steel	1	25-30	2000	N2/Air	10	2.0 single	0	0.6			
	2	6-8			10	2.0 single	-1	0.5			
	2	5-6		02	1.5	1.0 double	3	0.6			
	3	3-4			0.8	1.0 double	4	0.6			
	4	2.5-3.0			0.8	1.0 double	4	0.6			
	5	2.2-2.6			0.6	1.0 double	5	0.6			
	6	1.8-2.0			0.6	1.0 double	6	0.8			
	8	1.2-1.6			0.6	1.2 double	5.5	0.8			
	10	1.0-1.2			0.6	1.2 double	5	0.8			
	12	0.8-1.0			0.6	4.0 double	4	1			
	14	0.7-0.85			0.6	4.0 double	4	1			
	16	0.6-0.7			0.6	4.0 double	4	1			
	18	0.5-0.6			0.6	5.0 double	4	1			
	20	0.4-0.5			0.6	5.0 double	4	1			
	stainless steel	1			28-35	2000	N2	10	2.0 single	0	0.5
		2			9.0-15			10	2.0 single	-1	0.5
3		6.0-7.0	12	3.0 single	-1.5			0.5			
4		2.8-3.5	14	3.0 single	-2			0.5			
5		1.5-2.5	15	3.0 single	-3			0.5			
6		1.0-1.5	16	3.5 single	-4			0.5			
8		0.7-0.9	18	4.0 single	-5			0.5			
aluminium		1	22-35	2000	N2			12	2.0 single	0	0.5
	2	8.0-13	12			2.0 single	-0.5	0.5			
	3	4.0-4.5	14			3.0 single	-1	0.5			
	4	2.5-3.0	15			3.0 single	-2	0.5			
	5	1.5-2.0	16			3.0 single	-3	0.5			
	6	0.8-1.3	16			3.5 single	-4	0.5			
brass	1	15-18	2000	N2	10	2.0 single	0	0.8			
	2	6.0-8.0			10	2.0 single	-1	0.5			
	3	2.5-3.0			12	3.0 single	-1.5	0.5			
	4	1.0-1.3			13	3.0 single	-2	0.5			
	5	0.7-0.8			14	3.5 single	-2.5	0.5			
Red copper	1	20-22	2000	02	12	3.0 single	-1	0.5			
	2	5.5-6.5			12	3.0 single	-1	0.5			
	3	2.0-3.0			14	3.0 single	-2	0.5			

MFSC-3000X continuous wave laser (50µm)

Material	Thickness (mm)	Speed (mm/min)	Power (W)	Gas	Pressure (bar)	spray head (mm)	Focus Position	Cutting Thickness
Carbon steel	1	35-40	3000	N2/Air	10	2.0 single	0	0.6
	2	20-25			10	2.0 single	-1	0.6
	2	5.0-6.0	3000	02	1.5	1.0 double	3	0.6
	3	3.5-4.5	3000		0.8	1.0 double	4	0.6
	4	3.2-4.0	3000		0.8	1.0 double	5	0.6
	5	3.0-3.5	3000		0.8	1.0 double	6	0.6
	6	2.5-3.0	3000		0.8	1.0 double	7	0.6
	8	2.0-2.3	3000		0.8	1.2 double	7	0.6
	10	1.4-1.8	3000		0.8	1.2 double	5	0.6
	12	1.2-1.4	3000		0.8	4.0 double	4	0.6
	14	0.8-0.9	2600		0.8	4.0 double	4	1
	16	0.7-0.9	2600		0.6	4.0 double	4	1
	18	0.65-0.75	2400		0.6	4.0 double	4	1
	20	0.6-0.7	2400		0.6	5.0 double	4.5	1
	22	0.5-0.6	2400		0.6	5.0 double	4.5	1
	Stainless Steel	1	45-55		3000	N2	10	2.0 single
2		24-28	10	2.0 single			-0.5	0.5
3		8-13	12	3.0 single			-1	0.5
4		5-6	14	3.0 single			-1.5	0.5
5		3-4	15	3.0 single			-3	0.5
6		2.3-3.0	16	3.0 single			-4	0.5
8		1.0-1.5	16	4.0 single			-5	0.5
10		0.8-1.0	18	4.0 single			-7	0.5
Aluminium	1	40-50	3000	N2	10	2.0 single	0	0.6
	2	15-20			10	2.0 single	-0.5	0.5
	3	8-10			12	3.0 single	-1	0.5
	4	4-5			14	3.0 single	-2	0.5
	5	2.5-3.5			16	3.0 single	-3	0.5
	6	2.0-2.3			16	3.0 single	-4	0.5
	8	0.8-1.3			16	3.5 single	-5	0.5
Brass	1	25-28	3000	N2	10	2.0 single	0	0.5
	2	13-15			10	2.0 single	-1	0.5
	3	5.0-6.0			12	3.0 single	-1	0.5
	4	2.5-3.0			12	3.0 single	-2	0.5
	5	1.8-2.3			13	3.5 single	-2.5	0.5
	6	1.0-1.3			14	4.5 single	-3	0.5
	1	25-28			12	3.0 single	-1	0.5

Red copper	2	8.0-10	3000	O2	12	3.0 single	-1	0.5
	3	3.0-4.5			13	3.0 single	-2	0.5
	4	2.0-2.5			14	3.5 single	-4	0.5

MFSC-4000M Continuous laser source (50µm)

Material	Thicknes	Speed	Power	Gas	Pressure	spray head	Focus	Cutting	
Carbon steel	1	40-50	4000	N <sub>2</sub> / Air	10	2.0 single	0	0.6	
	2	15-20	4000		10	2.0 single	-1	0.6	
	3	10-12	4000		10	2.0 single	-1	0.6	
		3	4.0-4.5	2500	O <sub>2</sub>	0.6	1.0 double	4	0.6
		4	3.5-4.0	3000		0.6	1.0 double	5	0.6
		5	3.0-3.5	3300		0.6	1.0 double	5	0.6
		6	2.6-3.2	3500		0.6	1.0 double	6	0.6
		8	2.0-2.3	4000		0.6	1.2 double	6	0.8
		10	1.8-2.5	4000		0.6	1.2 double	6	0.8
		12	1.5-1.7	2600		0.8	4.0 double	5	1
		14	1.2-1.4	2600		0.8	4.0 double	5	1
		16	1.0-1.2	2600		0.7	4.0 double	5	1
		18	0.7-0.8	2600		0.7	4.0 double	5	1.5
		20	0.6-0.7	2600		0.7	4.0 double	5	1.5
		22	0.5-0.6	2600		0.6	5.0 double	5	1.5
		25	0.4-0.5	2600		0.6	5.0 double	5	1.5
	Stainless Steel	1	50-60	4000W		N <sub>2</sub>	10	2.0 single	0
2		20-25	10		2.0 single		-1	0.5	
3		10-13	12		3.0 single		-1.5	0.5	
4		8-10	13		3.0 single		-2	0.5	
5		4-5	14		3.0 single		-2	0.5	
6		3.5-4.0	15		3.0 single		-2	0.5	
8		1.5-2.0	16		4.0 single		-3	0.5	
10		1.2-1.5	18		4.0 single		-4	0.5	
12		0.7-1.0	18		5.0 single		-5	0.5	
		14	0.6-0.8		18		5.0 single	-8	0.5
		16	0.3-0.5		20		5.0 single	-8	0.5
Aluminium	1	30-50	4000	N <sub>2</sub>	10	2.0 single	0	0.6	
	2	20-24			12	2.0 single	0	0.6	
	3	44847			14	3.0 single	-1	0.6	
	4	44656			14	3.0 single	-2	0.5	
	5	44624			15	3.0 single	-3	0.5	
	6	44595			15	3.0 single	-3	0.5	
	8	1.4-1.8			16	4.0 single	-3	0.5	

	10	0.8-1.1			16	4.0 single	-5	0.5
	12	0.6-0.8			18	5.0 single	-5.5	0.5
Brass	1	30-35	4000	N <sub>2</sub>	10	2.0 single	0	0.5
	2	15-20			10	2.0 single	-1	0.5
	3	44783			12	3.0 single	-1	0.5
	4	5.0-6.0			13	3.0 single	-2	0.5
	5	2.0-3.0			13	3.5 single	-2.5	0.5
	6	2.0-2.5			14	3.5 single	-3	0.5
	8	1.0-1.2			14	4.5 single	-3.5	0.5
Red copper	1	26-30	4000	O <sub>2</sub>	10	3.0 single	-1	0.5
	2	44847			12	3.0 single	-1	0.5
	3	5.5-6.5			12	3.0 single	-2	0.5
	4	2.0-3.0			14	3.5 single	-4	0.5

MFSC-6000W Continuous laser source (100μm)								
Material	Thicknes	Speed	Power	Gas	Pressure	spray	Focus	Cutting
carbon steel	1	60-80	6000	N <sub>2</sub> /Air	10	2.0	0	0.6
	2	40-45			12	2.0	-0.5	0.5
	3	23-28			14	3.0	-1.5	0.5
	4	15-20			14	3.0	-3	0.5
	5	10-13			16	3.5	-3.5	0.5
	6	7-9			18	3.5	-4	0.5
	3	3.6-4.5	3000	O <sub>2</sub>	0.6	1.0	6.5	0.6
	4	3.2-3.5	3000		0.6	1.0	6.5	0.6
	5	2.6-3.2	3500		0.6	1.0	6	0.6
	6	2.5-2.8	4000		0.6	1.0	6	0.6
	8	2.2-2.5	5000		0.6	1.2	6	0.6
	10	2.0-2.2	6000		0.6	1.2	7	0.6
	12	1.8-2.0	6000		0.6	1.2	9	0.6
	14	1.4-1.7	6000		0.5	1.4	12	0.6
	16	0.9-1.2	2200		0.5	5.0	3.5	0.6
	18	0.7-1.0	2200		0.5	5.0	3.5	1.5
	20	0.6-0.8	2300		0.5	5.0	3.5	1.5
	22	0.55-0.65	2400		0.5	5.0	3.5	1.5
	25	0.4-0.6	6000		0.85	1.6	13	0.4
		1	60-80				10	2.0
2		30-35			12	2.0	0	0.5
3		20-24			12	3.0	-0.5	0.5
4		13-16			12	3.0	-1	0.5
5		9-12			14	3.0	-1.5	0.5

stainless steel	6	6.0-8.5	6000	N2	14	4.0	-2	0.5
	8	3.0-4.8			16	4.0	-4	0.5
	10	1.8-2.5			16	4.5	-7.5	0.5
	12	1.5-1.8			18	4.5	-8	0.5
	14	0.8-1.2			16	4.5	-10	0.5
	16	0.7-0.9			18	4.5	-11.5	0.5
	18	0.6-0.7			18	5.0	-12.5	0.5
	20	0.5-0.6			18	5.0	-13	0.5
	22	0.4-0.5			20	6.0	-13	0.5
	25	0.1-0.2			25	6.0	5	0.5
aluminium alloy	1	60-80	6000	N2	10	2.0	0	0.6
	2	30-45			10	2.0	-0.5	0.5
	3	20-28			14	3.0	-1	0.5
	4	12-15			14	3.0	-1.5	0.5
	5	6-8			15	3.0	-2	0.5
	6	5-6			16	4.0	-2.5	0.5
	8	3.0-3.5			16	4.0	-2.5	0.5
	10	2.0-2.5			18	4.0	-3	0.5
	12	1.0-1.3			18	4.0	-4	0.5
	14	0.8-1.1			20	5.0	-5	0.5
	16	0.5-0.8			20	5.0	-7	0.5
	18	0.4-0.6			25	5.0	-9	0.5
	20	0.4-0.55			25	5.0	-10	0.5
brass	1	40-50	6000	N2	10	2.0	0	0.6
	2	20-25			12	2.0	-0.5	0.5
	3	8.0-10			12	3.0	-1	0.5
	4	6.5-7.5			14	3.0	-1.5	0.5
	5	5.5-6.5			14	4.0	-2	0.5
	6	5.0-6.0			16	4.0	-2	0.5
	8	3.0-4.0			16	4.0	-3	0.5
	10	2.0-2.5			16	4.0	-3	0.5
	12	1.0-1.5			18	5.0	-7	0.5
	16	0.7-1.0			20	5.0	-9	0.5
	20	0.1-0.2			20	5.0	-10	0.5
	紫铜	1			30-35	6000	O2	10
2		12-15	10	3.0	-1			0.5
3		7.0-9.0	12	3.0	-2			0.5
4		6.0-7.0	12	3.5	-3			0.5
5		5.0-6.0	13	4.5	-4			0.5
6		2.5-3.5	14	5.0	-5			0.5

	8	1.5-2.0		14	5.0	-5	0.5
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MFMC-8000W Continuous laser source (100μm)

Material	Thicknes	Speed	Power	Gas	Pressure	spray	Focus	Cutting			
carbon steel	1	55-60	8000		10	2.0	0	0.6			
	2	30-35			12	2.0	0	0.5			
	3	20-25			13	3.0	-1	0.5			
	4	15-20			15	3.0	-1.5	0.5			
	5	10-14			15	3.5	-2	0.5			
	6	7-9			16	4.0	-3	0.5			
	8	4.5-6.5			16	4.5	-4	0.5			
	8	2.3-2.5			4000	8000	N <sub>2</sub>	0.6	1.2	6	0.6
	10	2.0-2.3	5000	0.6	1.2			7	0.6		
	12	1.8-2.1	6000	0.6	1.2			8	0.6		
	14	1.7-1.9		0.6	1.4			9	0.6		
	16	1.5-1.6		0.6	1.4			10	0.6		
	20	1.0-1.3		0.6	1.6			12	0.6		
	22	0.6-0.8		0.7	1.6			13	0.7		
	25	0.4-0.5		0.7	1.8			14	0.7		
	30	0.2-0.3		1.3	1.8			13	1		
	stainless steel	1	55-65	8000	N <sub>2</sub>			10	2.0	0	0.6
		2	35-40					12	2.0	0	0.5
		3	24-30			12	3.0	0	0.5		
4		15-22	13			3.0	-1	0.5			
5		12-16	15			4.0	-2	0.5			
6		8-10	15			4.0	-2.5	0.5			
8		5-7	16			4.5	-3.5	0.5			
10		3.5-5	18			4.5	-4.5	0.5			
12		2-3	18			5.0	-6	0.5			
14		1.5-2.0	18			5.0	-7	0.5			
16		1-1.4	20			5.0	-8	0.5			
18		0.9-1.2	22			5.0	-9.5	0.5			
20		0.8-0.9	25			5.0	-11	0.5			
25		0.3-0.5				25	5.0	8	0.5		
		1	35-45					10	2.0	0	0.6
	2	25-30	12	2.0	-1			0.5			
	3	16-20	12	3.0	-1			0.5			
	4	10-13	13	3.0	-3			0.5			
	5	6-7.5	14	3.5	-4			0.5			
	6	5.0-6.5	14	3.5	-4			0.5			

aluminium alloy	8	3-4	8000	N <sub>2</sub>	16	4.5	-6	0.5
	10	2-3			16	4.5	-7	0.5
	12	1.5-2.0			18	5.0	-8	0.5
	14	1.2-1.5			18	5.0	-9	0.5
	16	0.8-1.0			20	5.0	-10	0.5
	18	0.6-0.8			25	5.0	-11	0.5
	20	0.4-0.6			25	5.0	-13	0.5
	25	0.3-0.4			25	5.0	-16	0.5
brass	1	38-45	8000	N <sub>2</sub>	10	2.0	0	0.6
	2	25-28			12	2.0	-1	0.5
	3	15-20			12	3.0	-1	0.5
	4	10-12			12	3.0	-2	0.5
	5	6-8			14	3.0	-3	0.5
	6	5-6			16	3.5	-4	0.5
	8	2.8-3.5			16	4.5	-5	0.5
	10	2.0-2.5			18	5.0	-6	0.5
	12	1.5-2.0			18	5.0	-8	0.5
	14	0.8-1.3			20	5.0	-9	0.5
	16	0.6-1.0			25	5.0	-11	0.5
紫铜	1	30-35	8000	O <sub>2</sub>	10	3.0	-1	0.5
	2	16-20			10	3.0	-1	0.5
	3	10-14			12	3.0	-2	0.5
	4	6.0-8.0			12	3.5	-3	0.5
	5	5.0-6.0			14	4.5	-4	0.5
	6	3.0-4.0			14	5.0	-4	0.5
	8	1.8-2.5			14	5.0	-5	0.5
	10	0.7-1.0			16	5.0	-5	0.5



MFSC-1000X Continuous laser source (50μm)								
Material	Thickne	Speed	Power	Gas	Pressure	spray	Focus	Cutting
carbon steel	0.8	18-20	1000	N <sub>2</sub> /Air	11	2.0 single	0	0.6
	1	10-15			11	2.0 single	0	0.6
	2	4-5	1000	O <sub>2</sub>	1.5	1.0 double	3	0.6
	3	2.5-3.2			0.6	1.0 double	4	0.6
	4	2.3-2.8			0.6	1.0 double	4	0.6
	5	1.8-2.1			0.6	1.0 double	5	0.6
	6	1.2-1.5			0.6	1.0 double	6	0.6
	8	1-1.1			0.6	1.5 double	5.5	1.5
	10	0.7-0.9			0.6	1.5 double	5	1.5
stainless steel	0.8	18-22	1000	N <sub>2</sub>	10	2.0 single	0	0.5
	1	13-18			12	2.0 single	0	0.5
	2	4-6			12	2.0 single	-1	0.5
	3	2.5-3			12	3.0 single	-1.5	0.5
	4	1-1.5			14	3.0 single	-2	0.5
	5	0.6-0.8			16	3.0 single	-3	0.5
aluminium alloy	0.8	18-20	1000	N <sub>2</sub>	10	2.0 single	0	0.8
	1	10-15			12	2.0 single	0	0.5
	2	4-5			14	2.0 single	-1	0.5
	3	1-1.5			16	2.0 single	-1.5	0.5
brass	1	8.0-10	1000	N <sub>2</sub>	10	2.0 single	0	0.5
	2	2.0-2.5			14	2.0 single	-1	0.5
	3	0.8-1.0			16	3.0 single	-1.5	0.5

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