



Jinan Weihua Machinery & Equipment Co., LTD

Website: www.weihualaser.com Email: manager@jnweihua.com

Mobile & Whatsapp: +86-15853160596

1. Cutting Parameter of Cutting Stainless Steel and Carbon Steel by SLW Laser Tube

Laser Cutting						
Material	Thickness(mm)	Auxiliary Gas	220w (mm/s)	300w (mm/s)	500w (mm/s)	600w (mm/s)
Stainless steel	0.5	oxygen	70	100	144	180
	1.0	oxygen	18	60	96	110
	2.0	oxygen	8	25	48	60
	3.0	oxygen	4	10	18	25
Carbon steel	0.5	oxygen	33	110	180	220
	1.0	oxygen	25	80	144	150
	2.0	oxygen	10	30	60	80
	3.0	oxygen	5	15	24	35

2. Cutting Speed of Acrylic

Thickness \ Laser power	5mm	10mm	20mm	30mm
220w	31-33mm/s	13-15mm/s	5-7mm/s	4-5mm/s
300w	45-47mm/s	19-21mm/s	7-9mm/s	6-8mm/s
500w	70-80mm/s	31-36mm/s	13-15mm/s	12-14mm/s
600w	90-95mm/s	40-45mm/s	15-20mm/s	14-16mm/s

3. Speed Setting for Laser tube Cutting of Picture Frame Boards

Thickness \ Laser power	12mm	20mm	30mm
220w	6-10mm/s	3-6mm/s	2-5mm/s



Jinan Weihua Machinery & Equipment Co., LTD

Website: www.weihualaser.com Email: manager@jnweihua.com

Mobile & Whatsapp: +86-15853160596

300w	20-25mm/s	10-15mm/s	6-8mm/s
500w	35-40mm/s	17-22mm/s	12-15mm/s
600w	45-50mm/s	23-28mm/s	18-20mm/s

Weihua Laser