

CUTTING PARAMETERS FOR SUDA FIBER LASER 2200W

RAYCUS/2000W IPG

1: CUTTING SS PARAMETERS

Material thickness [mm]	Focus	Laser power [w]	Cutting speed [m/min]	Gas pressure N2[bar]	Nozzel- Φ [mm]
1		2200/2000	40	14-17	1.5single
2		2200/2000	12	15-18	1.5single
3		2200/2000	7	15-18	2.0 single
4		2200/2000	2	15-18	2.0 single
5		2200/2000	1.6	18-20	2.5 single
6		2200/2000	1.2	18-20	3.0 single
8		2200/2000	0.6	18-20	3.0 single

2: Cutting Carbon steel parameters

Material thickness [mm]	Focu s	Laser power [w]	Cutting speed [m/min]	Gas pressure N2[bar]	Nozzel- Φ [mm]
1		2200/2000	40	0.4-0.8	1.5double
2		2200/2000	12	0.4-0.7	1.5double
3		2200/2000	4.5	0.2-0.5	1.5double
4		2200/2000	4.5	0.15-0.3	2.0double
5		2200/2000	2.5	0.05-0.2	2.0double
6		2200/2000	2	0.05-0.2	2.0double
8		2200/2000	1.6	0.05-0.15	2.0double
10		2200/2000	1.3	0.05-0.15	2.0double
12		2200/2000	1.2	0.05-0.15	2.5double
14		2200/2000	0.9	0.05-0.15	3.0double

16		2200/2000	0.7	0.05-0.15	3.5double
20		2200/2000	0.6	0.05-0.15	4.0double

3: Cutting Aluminum parameters

Material thickness [mm]	Focus	Laser power [w]	Cutting speed [m/min]	Gas pressure N2[bar]	Nozzel- Φ [mm]
1		2200/2000	20	14-17	1.5 single
2		2200/2000	7	15-18	1.5 single
3		2200/2000	5	15-18	2.0 single
4		2200/2000	2.5	15-18	2.0 single
6		2200/2000	1.2	18-20	3.0 single

4: Cutting Copper Parameters

Material thickness [mm]	Focus	Laser power [w]	Cutting speed [m/min]	Gas pressure N2[bar]	Nozzel- Φ [mm]
1		2200/2000	18	14-17	1.5 single
2		2200/2000	7	15-18	1.5 single
3		2200/2000	5	15-18	2.0 single
4		2200/2000	2.5	15-18	2.0 single
6		2200/2000	1.2	18-20	3.0 single