

Laser Cutting Data Sheet of 2000W

Material	Thickness (mm)	Speed (m/min)	Gas	Power (%)	Focus Length (mm)	Pressure (bar)	Nozzle
Carbon Steel	1						
	2	5-6	O2	60	4-6	0.8-2	1.0 double
	2	13-16	Air	100	3	15	1.0 double
	3	3.2-4.5	O2	100	4-6	0.8-1.5	1.0 double
	4	2.8-3.0			4-6	0.6-0.9	1.0 double
	5	2.5-2.8			4-6	0.6-0.9	1.0 double
	6	2.0-2.4			4-6	0.6-0.9	1.0 double
	8	1.-1.5			3	0.6-0.9	2.5 double
	10	1-1.2			3	0.6-0.9	2.5 double
	12	0.9-1.1			3.5	0.6-0.9	3.5 double
	14	0.8-0.9			3.5	0.6-0.9	3.5 double
	16	0.65-0.75			4	0.6-0.9	3.5 double
	18	0.5-0.6			4	0.6-0.9	4.0/4.5
Stainless Steel	1	36			N2	100	-2
	2	13-14	-2	20			2.0 Single
	3	6-7	-3	20			2.0 Single
	4	3.5-4.5	-3	20			2.5 Single
	5	1.8-2	-3	20			3.0 Single
	6	1.5-1.8	-4	20			3.0 Single
	8	0.6-0.8	-4	20			4.0 Single
Aluminum	1	18	N2	100	-1	20	2.0 Single
	2	13-15			-1	20	2.0 Single
	3	6-7			-2	20	2.0 Single
	4	3-5			-2	20	2.5 Single
	5	1.8-2.5			-2	20	2.5 Single
	6	1-1.5			-2	20	2.5 Single
Brass	1	20-25	N2	100	-1	20	1.5 Single
	2	9-12			-1	20	1.5 Single
	3	4-5.5			-1	20	2.0 Single
	4	2.5-3			-2	20	2.0 Single
	5	1.4-1.8			-2	20	2.0 Single
	6	0.8-1			-2	20	3.0 Single
Copper	1		N2	100			
	2	5-6			-2	20	1.5 Single
	3	2.5-3.5			-2	20	2.0 Single
	4	1-1.5			-2	20	2.0 Single

Note:

- 1) The above data is tested by the laser with 50um central wavelength.
- 2) Regarding to the laser cutting head to be tested, the rate between collimating and focus optical is 100:125.
- 3) The data is just for reference and will be a little difference depends on laser cutting head of brands.

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