

Method for gas-laser cutting of materials, in which laser radiation is directed into the cutting area of the workpiece coaxially with a jet of working gas formed by a conical nozzle. During the cutting process, the workpiece is moved using a two-axis table, and a photodetector captures the secondary visible radiation in the cutting area. The photodetector is ring-shaped and is mounted on the conical nozzle. Upon detection of the secondary visible radiation, the photodetector sends a signal to the computer, which controls the speed of the two-axis table.