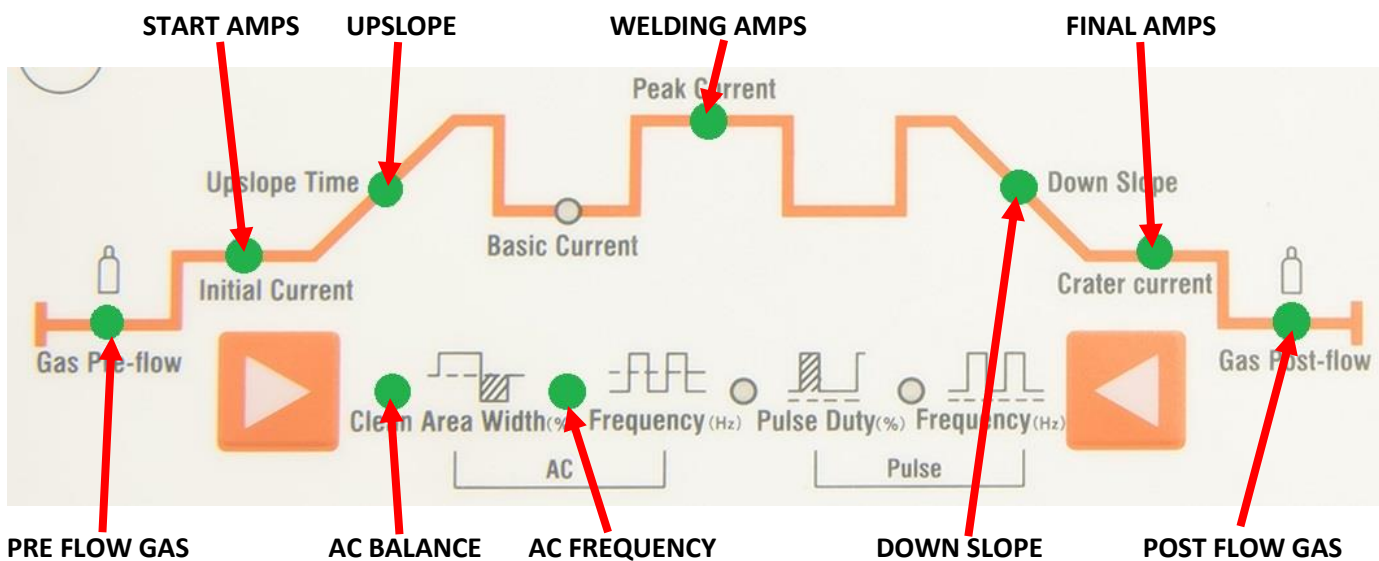
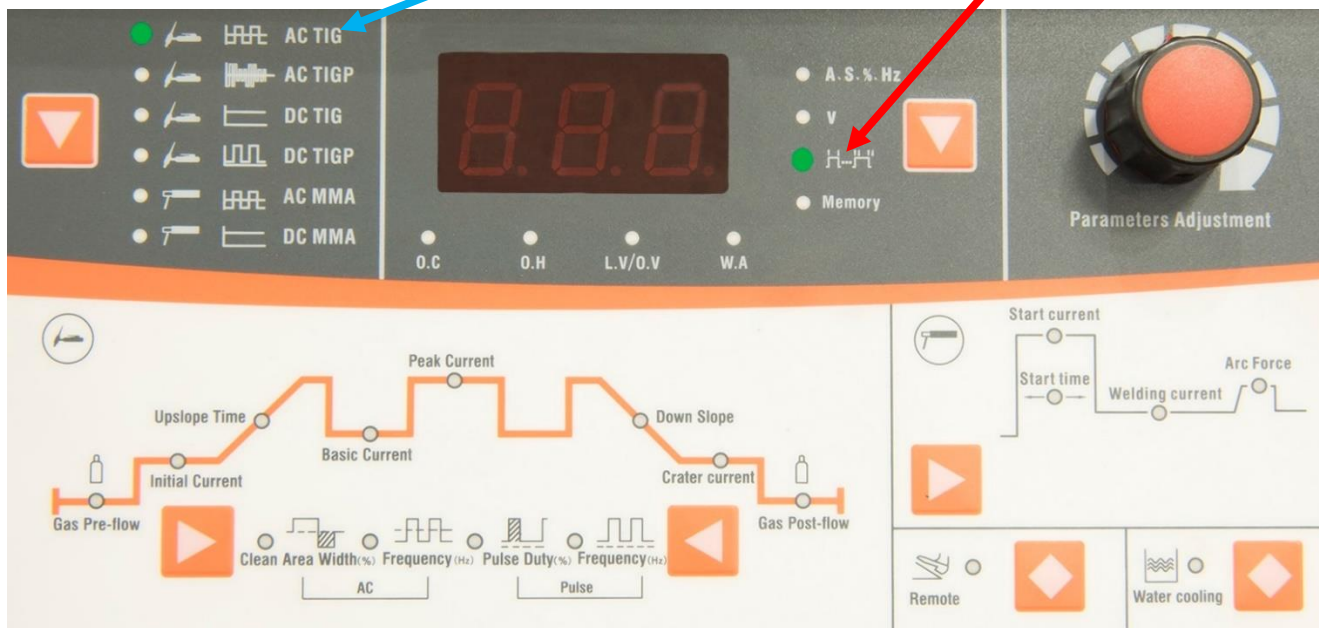


## JT-500D AC Welding Basic Set-Up Guide

For AC TIG welding, set up as below and ensure you place the machine in AC ★ and 2T ★ mode (which is setting number 2).



Set parameters as follows using images above as reference:

Parameter	Units	Adjustable Range	Guide Setting	User Setting
Job/Material	---	---	---	
PRE-GAS TIME	Seconds	0 ~ 15	0.5	
START-CURRENT	Amps	5 ~ 250	20	
UP-SLOPE TIME	Seconds	0 ~ 60	0	
PEAK CURRENT *	Amps	5 ~ 510	User defined *	
AC FREQUENCY	Hz	5 ~ 99.9	70	
AC BALANCE	%	10 ~ 60	30	
DOWN-SLOPE TIME	Seconds	0 ~ 60	1	
FINAL CURRENT	Amps	5 ~ 250	20	
POST-GAS TIME	Seconds	2 ~ 20	7	

\* Depends on material thickness (30A per mm) eg. 3mm = 90A

**Note:** Please ensure you have set the water cooling option to ON/OFF depending on TIG Torch fitted v1 2020