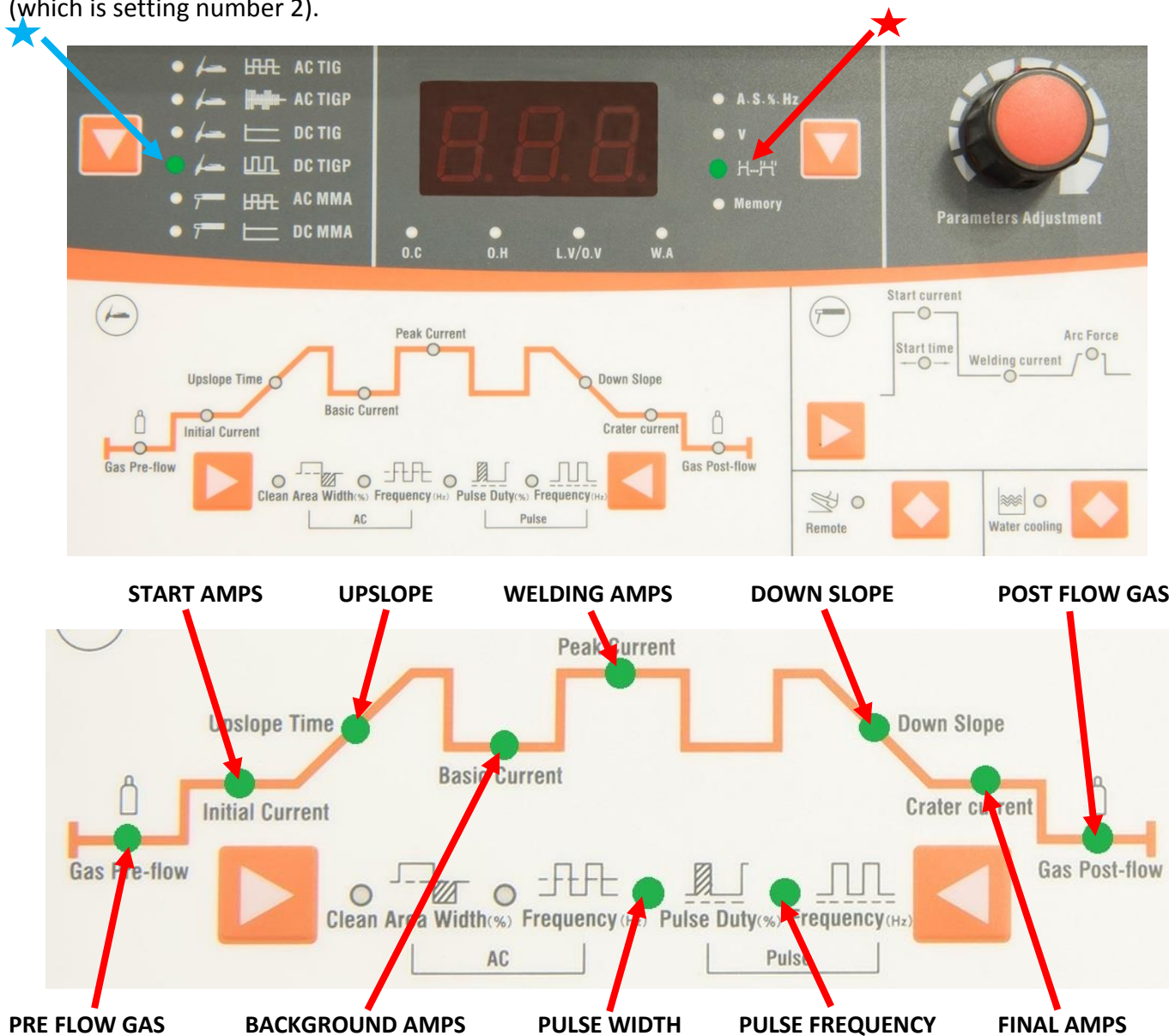


## JT-500D DC Welding Basic Set-Up Guide – With Pulse

For DC TIG Pulse welding, set up as below and ensure you place the machine in DC Pulse ★ 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	10 ~ 510	10	
UP-SLOPE TIME	Seconds	0 ~ 60	0	
PEAK CURRENT *	Amps	10 ~ 510	User defined *	
BASE CURRENT **	Amps	10 ~ 510	50% **	
PULSE FREQUENCY	Hz	0.5 ~ 200	1.5	
PULSE WIDTH	%	10 ~ 90	50	
DOWN-SLOPE TIME	Seconds	0 ~ 60	1	
FINAL CURRENT	Amps	10 ~ 510	10	
POST-GAS TIME	Seconds	0 ~ 20	2	

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

\*\* Set base current to 50% of your peak welding current

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

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