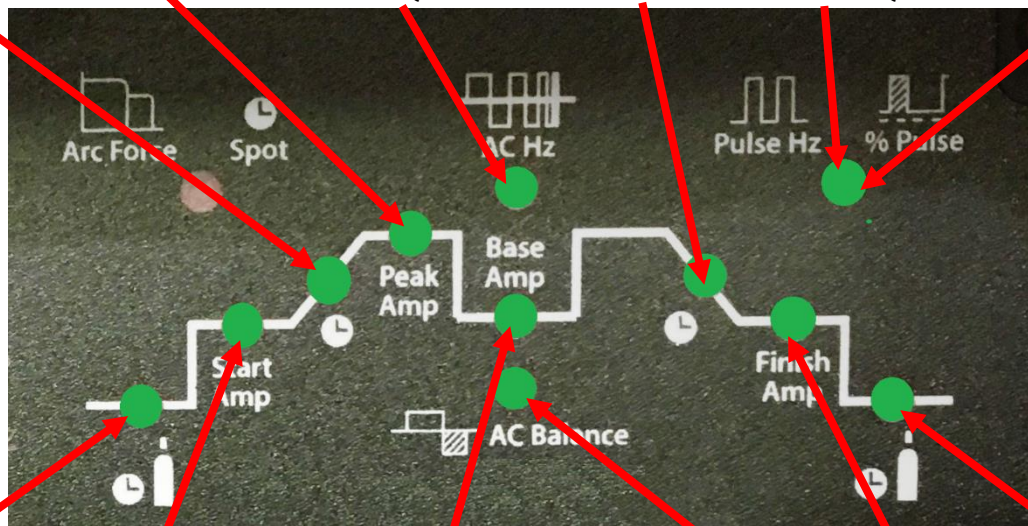


JT-200DS AC Welding Basic Set-Up Guide – With Pulse

For AC Pulse TIG welding, set up as below and ensure that you have set the tungsten size first ★



UPSLOPE WELDING AMPS AC FREQUENCY DOWN SLOPE PULSE FREQUENCY PULSE WIDTH



PRE FLOW GAS START AMPS BACKGROUND CURRENT AC BALANCE FINAL AMPS POST FLOW GAS

Set parameters as follows using images above as reference:

| Parameter | Units | Adjustable Range | Guide Setting | User Setting |
|-----------------|---------|------------------|----------------|--------------|
| Job/Material | --- | --- | --- | |
| PRE-GAS TIME | Seconds | 0.1 ~ 3.0 | 0.5 | |
| START-CURRENT | Amps | 5 ~ 160 | 10 | |
| UP-SLOPE TIME | Seconds | 0 ~ 10 | 0 | |
| PEAK CURRENT * | Amps | 5 ~ 200 | User defined * | |
| BASE CURRENT ** | Amps | 5 ~ 200 | 50% ** | |
| AC FREQUENCY | Hz | 20 ~ 250 | 100 | |
| AC BALANCE | % | 15 ~ 85 | 40 | |
| PULSE FREQUENCY | Hz | 0.2 ~ 200 | 2 | |
| PULSE WIDTH | % | 10 ~ 90 | 50 | |
| DOWN-SLOPE TIME | Seconds | 0 ~ 15 | 2 | |
| FINAL CURRENT | Amps | 5 ~ 200 | 10 | |
| POST-GAS TIME | Seconds | 0.5 ~ 15 | 5 | |

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

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