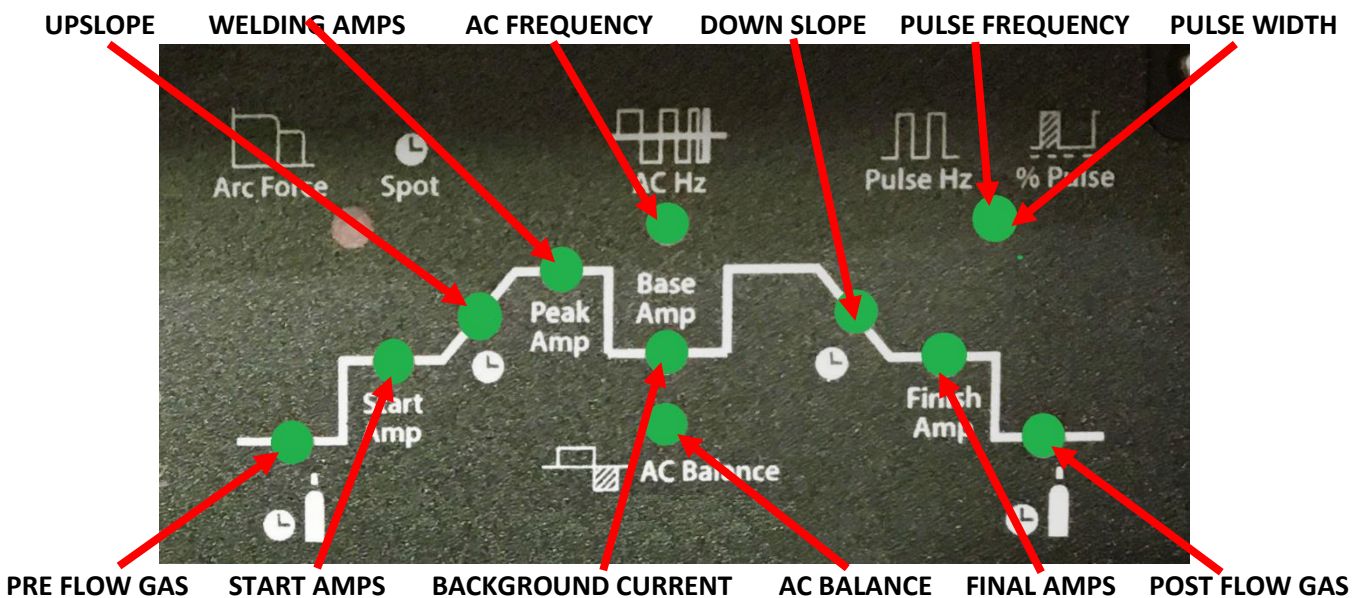


JT-200DS AC Welding Basic Set-Up Guide – With Pulse

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



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 ~ 10	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	10 ~ 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	7	

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

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