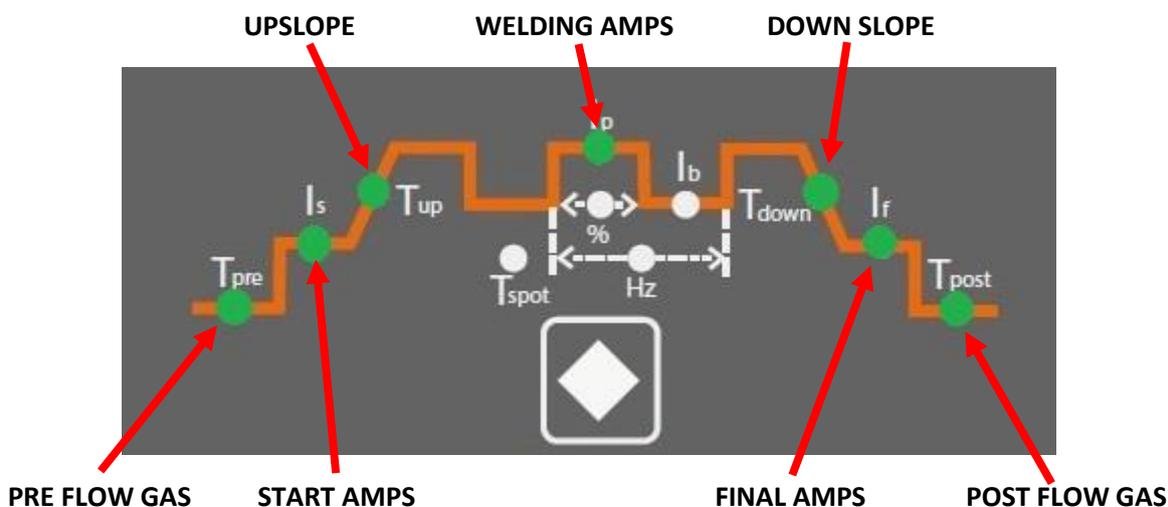


## JT-400P DC Welding Basic Set-Up Guide

For DC TIG welding the set-up is as below, please ensure you place machine in TIG ★ and 2T ★ mode



Set parameters as follows using control panel image above as reference:

Parameter	Units	Adjustable Range	Guide Setting	User Setting
Job/Material	---	---	---	
PRE-GAS TIME	Seconds	0 ~ 15	0.2	
START-CURRENT	Amps	5 ~ 400	10	
UP-SLOPE TIME	Seconds	0 ~ 10	0	
PEAK CURRENT *	Amps	5 ~ 400	User defined *	
DOWN-SLOPE TIME	Seconds	0 ~ 10	0.5	
FINAL CURRENT	Amps	5 ~ 400	10	
POST-GAS TIME	Seconds	0 ~ 15	2	

\* Depends on material thickness (example to use is 30A per mm) e.g. 3mm = 90A

**Note:** Please ensure you have set the water cooling option to ON/OFF depending on TIG Torch fitted V1 2020