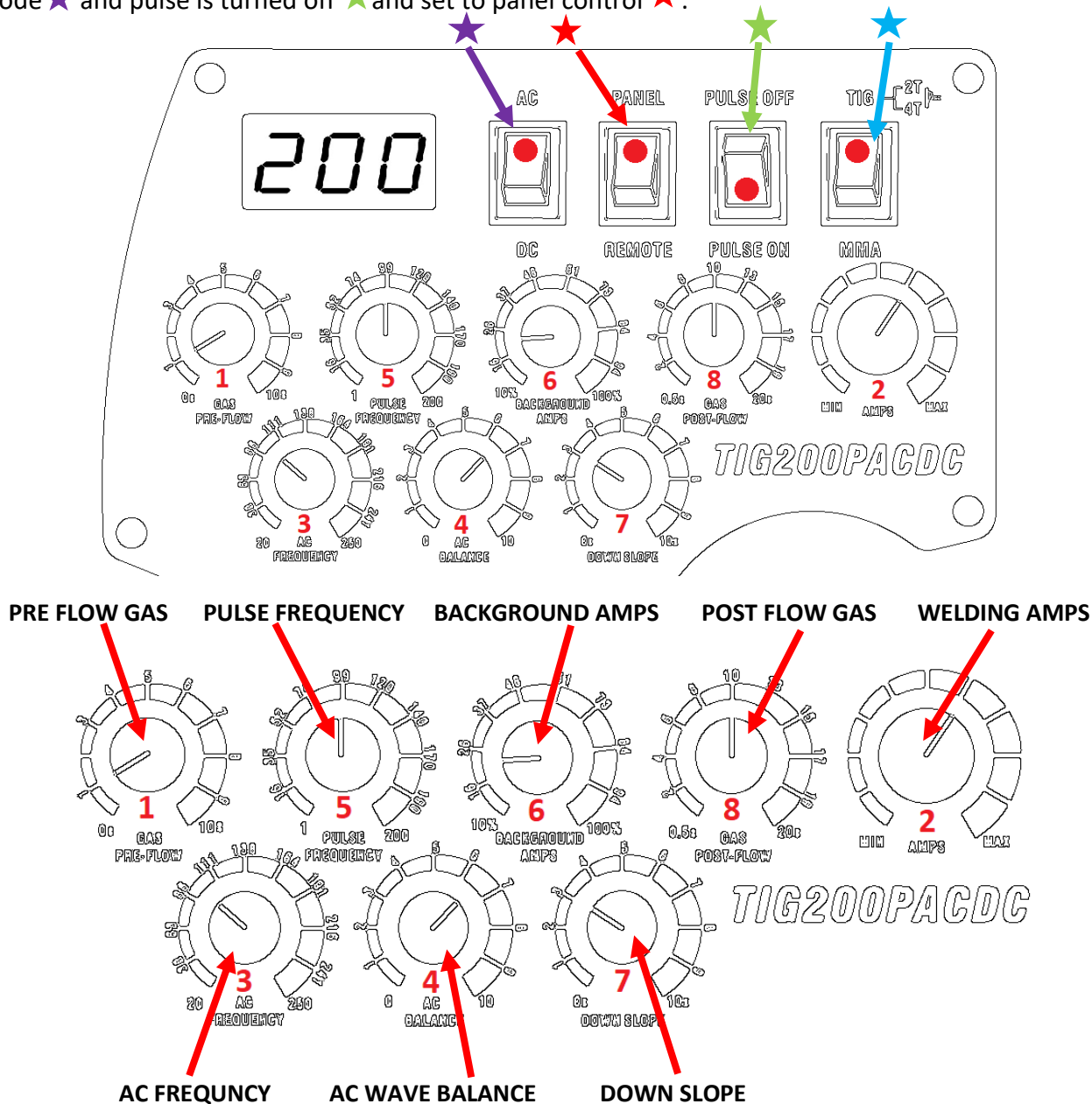


JT-202A AC Pulse Welding Set-Up Guide

For AC TIG pulse welding, set up as below and ensure you place the machine in TIG and 2T mode ★, AC mode ★ and pulse is turned on ★ and set to panel control ★.



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

Parameter	Units	Adjustable Range	Guide Setting	User Setting
Job/Material	---	---	---	
PRE-GAS TIME (1)	Seconds	0 ~ 10	0.5	
PEAK CURRENT * (2)	Amps	5 ~ 200	User defined *	
BACKGROUND CURRENT (6)	%	10 ~ 100	50	
PULSE FREQUENCY (5)	Hz	1 ~ 200	0.5	
AC FREQUENCY (3)	Hz	20 ~ 250	50	
AC WAVE BALANCE (4)	%	0 ~ 10	5	
DOWN-SLOPE TIME (7)	Seconds	0 ~ 10	1	
POST-GAS TIME (8)	Seconds	0.5 ~ 20	5	

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