

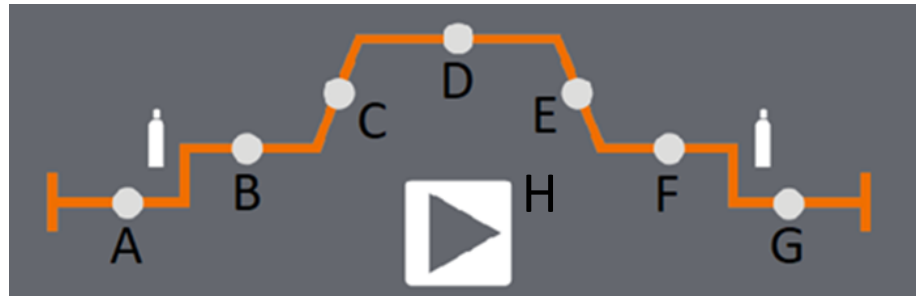
JM-250P Basic Set-Up Guide – Standard MIG/MAG

For standard MIG/MAG welding, set up as below and select 2T/4T trigger mode dependant on user requirements. Material type and wire size selection will have no effect in standard MIG/MAG mode.



The parameter selection button (H) allows you to scroll through the adjustable parameters for conventional MIG/MAG as follows:

- A. P-1: Gas pre-flow time (2T/4T)
- B. P-2: Initial parameters (4T only)
- C. P-3: Upslope time (4T only)
- D. - Peak welding parameters
- E. P-4: Downslope time (4T only)
- F. P-5: Final parameter (4T only)
- G. P-6: Post-flow time (2T/4T)
- H. - Parameter selection button



The corresponding indicators will be lit according to selected parameters, the variable setting is noted in the left display and the adjustable values are shown on the right displays which are adjusted using the right control dial. However; INITIAL, PEAK and FINAL parameters are adjusted using the corresponding display control dial for wire feed speed and voltage.

Parameter	Units	Adjustable Range	Guide Setting	Notes
Job/Material	---	---	---	---
A. PRE-GAS TIME	Seconds	0.0 ~ 10	0.5	
B. INITIAL Parameter	WFS V	3-15m/min 9.0-36.0V	Match PEAK parameter	Adjustment only available in "4T" mode
C. UP-SLOPE TIME	Seconds	0.1 ~ 5	0.1	Adjustment only available in "4T" mode
D. PEAK Parameter	WFS V	3-15m/min 9.0-36.0V	User defined *	
E. DOWN-SLOPE TIME	Seconds	0.1 ~ 5	0.1	Adjustment only available in "4T" mode
F. FINAL Parameter	WFS V	3-15m/min 9.0-36.0V	Match PEAK parameter	Adjustment only available in "4T" mode
G. POST-GAS TIME	Seconds	0.1~ 10	2.0	