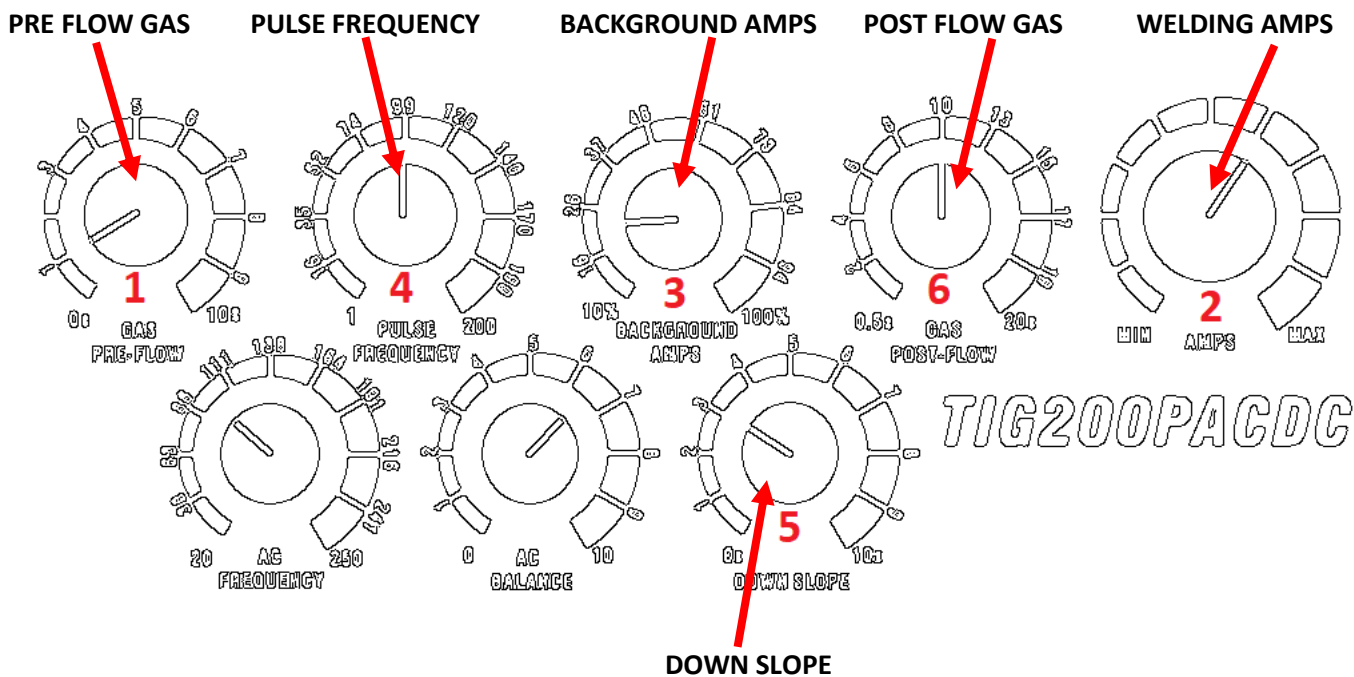
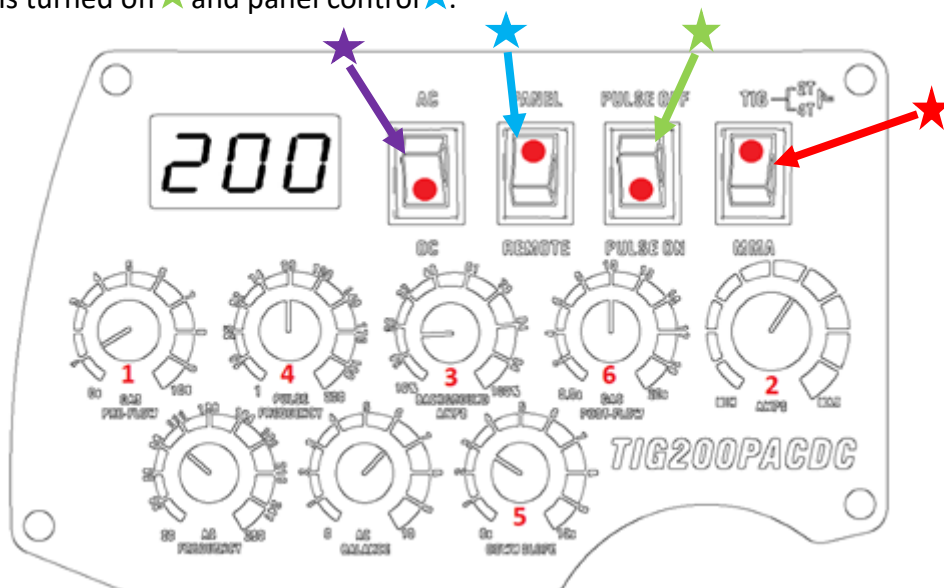


JT-202A DC Welding Pulse Set-Up Guide

For DC TIG Pulse welding, set up as below and ensure you place the machine in TIG and 2T mode★, DC mode★, pulse is turned on★ and 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 ~ 3.0	0.5	
WELDING CURRENT * (2)	Amps	5 ~ 200	User defined *	
BACKGROUND CURRENT (3)	%	10 ~ 100	50	
DOWN-SLOPE TIME (5)	Seconds	0 ~ 10	0	
PULSE FREQUENCY (4)	Hz	1 ~ 200	0.5	
POST-GAS TIME (6)	Seconds	0.5 ~ 20	3	

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