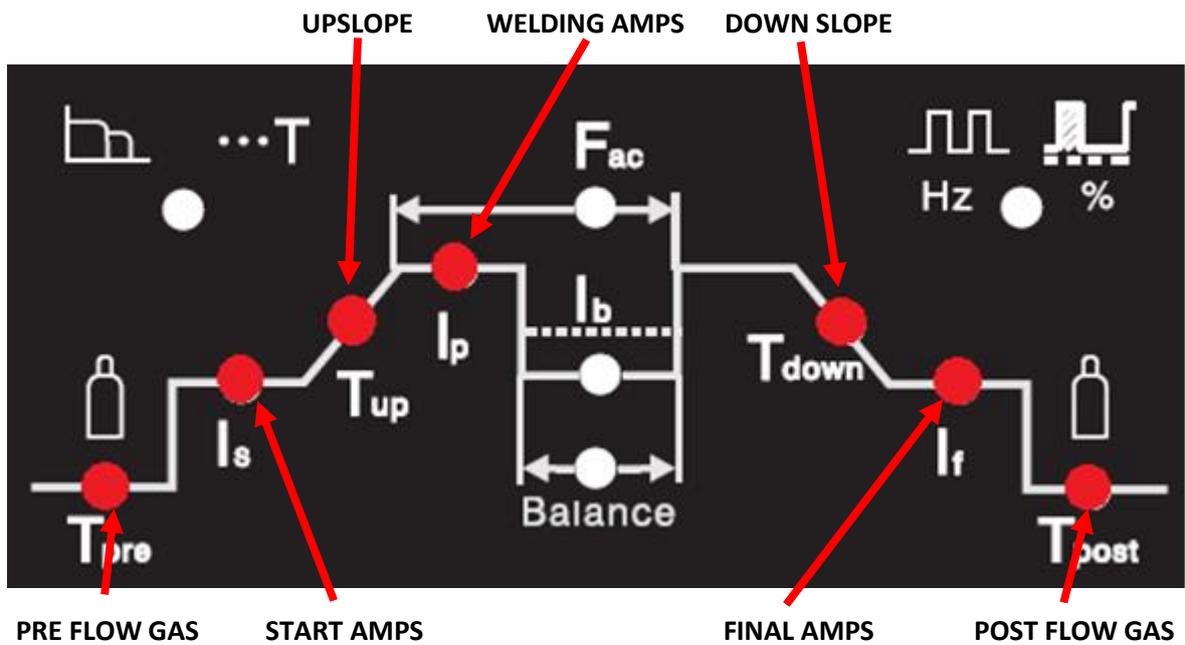
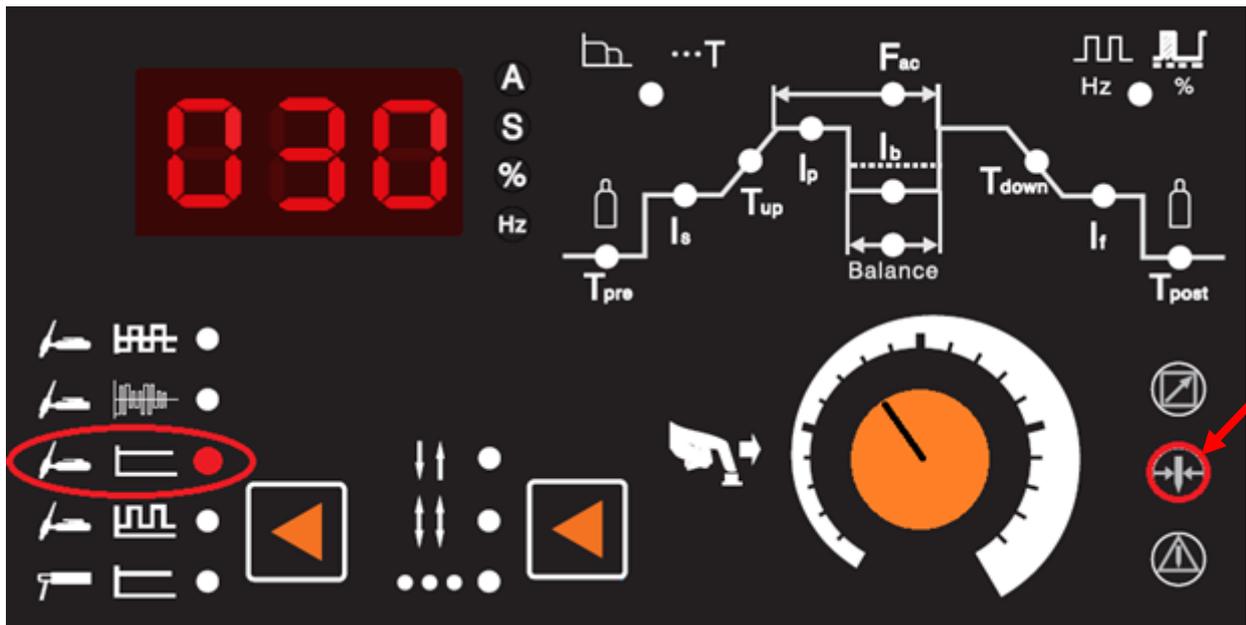


## JT-202D DC Welding Basic Set-Up Guide

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



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 | 0.1 ~ 3.0        | 0.2            |              |
| START-CURRENT   | Amps    | 5 ~ 160          | 15             |              |
| UP-SLOPE TIME   | Seconds | 0 ~ 10           | 0              |              |
| PEAK CURRENT *  | Amps    | 5 ~ 200          | User defined * |              |
| DOWN-SLOPE TIME | Seconds | 0 ~ 15           | 1              |              |
| FINAL CURRENT   | Amps    | 5 ~ 200          | 10             |              |
| POST-GAS TIME   | Seconds | 0.5 ~ 15         | 3              |              |

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