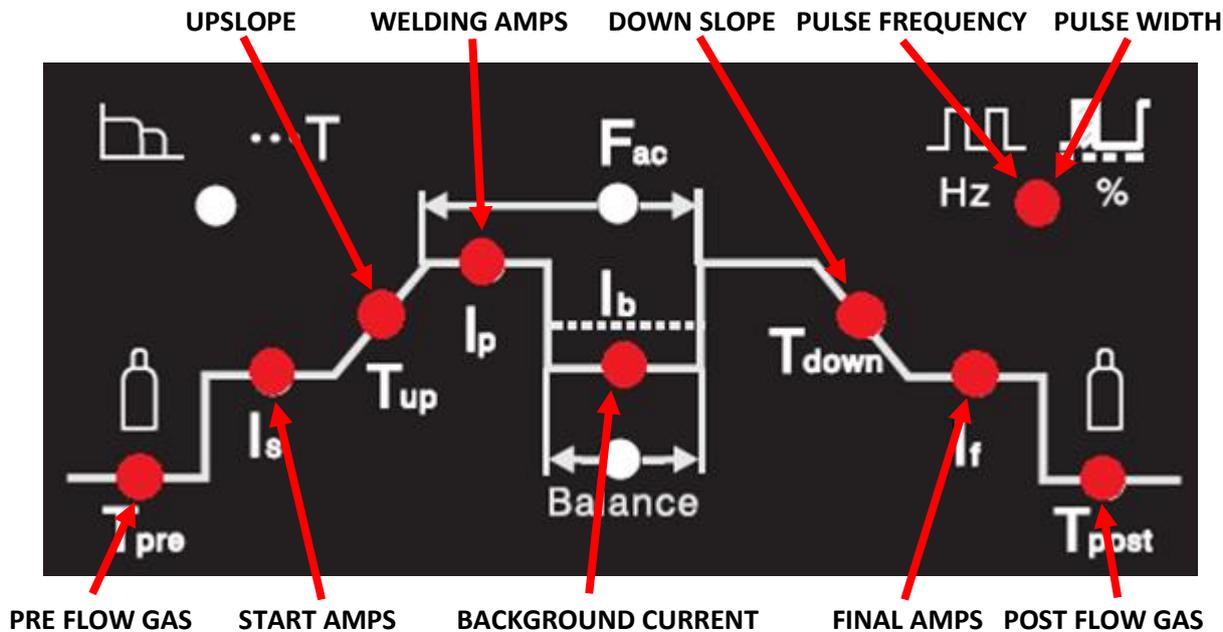
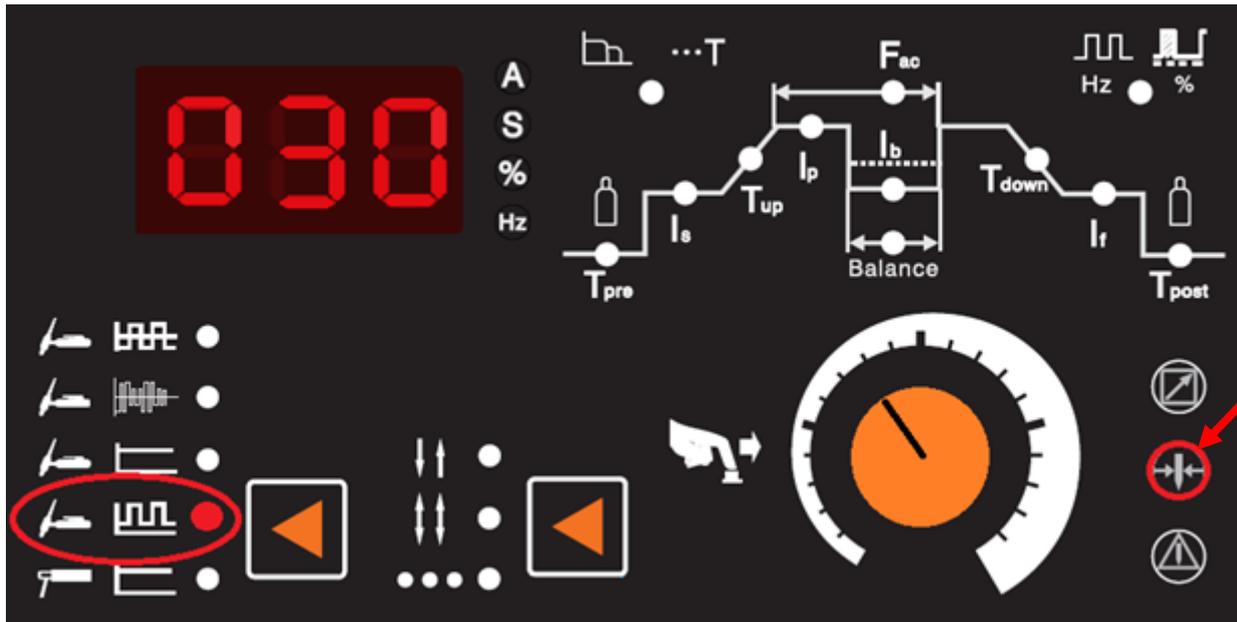


JT-202D DC Welding Basic Set-Up Guide – With Pulse

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



Set parameters as follows using images 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 * | |
| BASE CURRENT ** | Amps | 5 ~ 200 | 50% ** | |
| PULSE FREQUENCY | Hz | 0.2 ~ 200 | 75 | |
| PULSE WIDTH | % | 10 ~ 90 | 50 | |
| DOWN-SLOPE TIME | Seconds | 0 ~ 15 | 2 | |
| FINAL CURRENT | Amps | 5 ~ 200 | 10 | |
| POST-GAS TIME | Seconds | 0.5 ~ 15 | 3 | |

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

** Set base current to 50% of your peak welding current