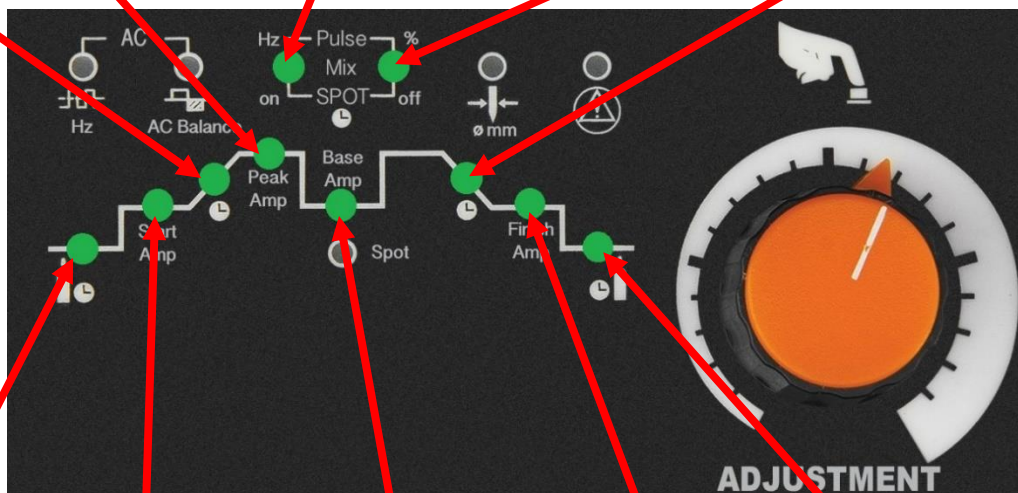


JT-315P MWD DC Welding Basic Set-Up Guide – With Pulse

For DC TIG Pulse welding, set up as below and ensure you place the machine in DC Pulse and 2T mode as well as setting your tungsten size.



UPSLOPE WELDING AMPS PULSE FREQUENCY PULSE WIDTH DOWN SLOPE



PRE FLOW GAS START AMPS BACKGROUND AMPS FINAL AMPS POST FLOW GAS

Set parameters as follows using images above as reference:

Parameter	Units	Adjustable Range	Guide Setting	User Setting
Job/Material	---	---	---	
PRE-GAS TIME	Seconds	0.5 ~ 10	0.5	
START-CURRENT	Amps	10 ~ 315	15	
UP-SLOPE TIME	Seconds	0 ~ 15	0	
PEAK CURRENT *	Amps	10 ~ 315	User defined *	
BASE CURRENT **	Amps	10 ~ 315	50% **	
PULSE FREQUENCY	Hz	0.5 ~ 200	1	
PULSE WIDTH	%	5 ~ 95	50	
DOWN-SLOPE TIME	Seconds	0 ~ 15	1	
FINAL CURRENT	Amps	10 ~ 315	10	
POST-GAS TIME	Seconds	0.5 ~ 15	2	

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

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

Note: Please ensure you have set the water cooling option to ON/OFF depending on TIG Torch fitted