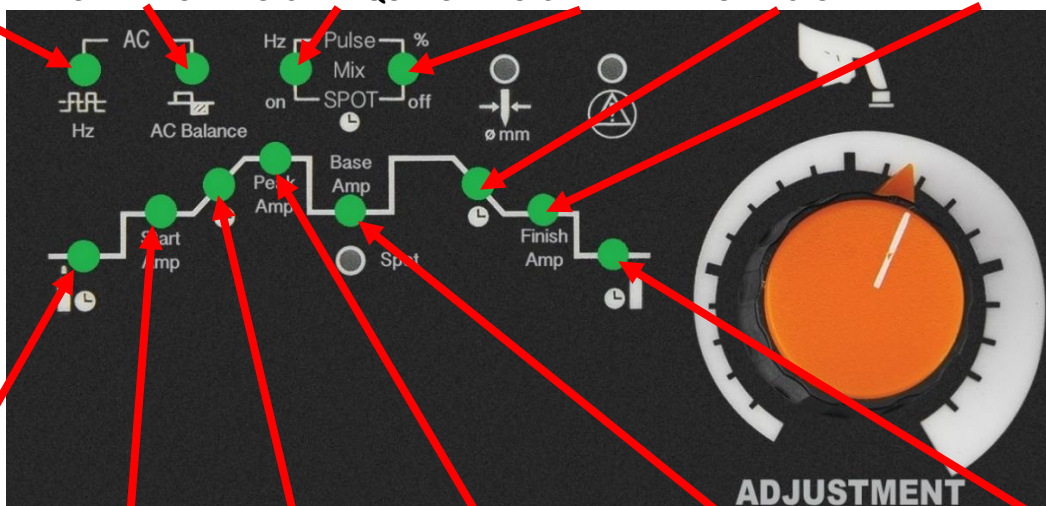


## JT-315P MWD AC Welding Basic Set-Up Guide – With Pulse

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



AC FREQUENCY    AC BALANCE    PULSE FREQUENCY    PULSE WIDTH    DOWN SLOPE    FINAL AMPS



PRE FLOW GAS    START AMPS    UPSLOPE    WELDING AMPS    BACKGROUND CURRENT    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	20	
UP-SLOPE TIME	Seconds	0 ~ 15	0	
PEAK CURRENT *	Amps	10 ~ 315	User defined *	
BASE CURRENT **	Amps	10 ~ 315	50% **	
AC FREQUENCY	Hz	50 ~ 200	70	
AC BALANCE	%	20 ~ 60	40	
PULSE FREQUENCY	Hz	0.5 ~ 9.8	1	
PULSE WIDTH	%	5 ~ 95	50	
DOWN-SLOPE TIME	Seconds	0 ~ 15	1	
FINAL CURRENT	Amps	10 ~ 315	20	
POST-GAS TIME	Seconds	0.5 ~ 15	7	

\* 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