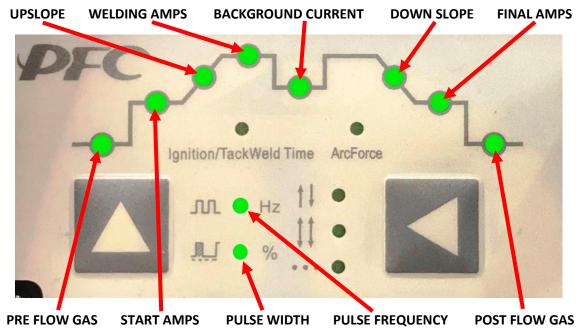
Wilkinson Star Technical

JT-200P-PFC 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





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 ~ 2.0 | 0.2 | |
| START-CURRENT | Amps | 10 ~ 200 | 10 | |
| UP-SLOPE TIME | Seconds | 0 ~ 10 | 0 | |
| PEAK CURRENT | Amps | 10 ~ 200 | User defined * | |
| BASE CURRENT | Amps | 10 ~ 200 | 50% ** | |
| PULSE FREQUENCY | Hz | 0.5 ~ 200 | 50 | |
| PULSE WIDTH | % | 10~90 | 50 | |
| DOWN-SLOPE TIME | Seconds | 0 ~ 10 | 0.5 | |
| FINAL CURRENT | Amps | 10 ~ 200 | 10 | |
| POST-GAS TIME | Seconds | 1.0 ~ 20 | 2 | |

^{*} Depends on material thickness (example to use is 30A per mm) e.g. 3mm = 90A

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^{**} Set base current to 50% of your peak welding current