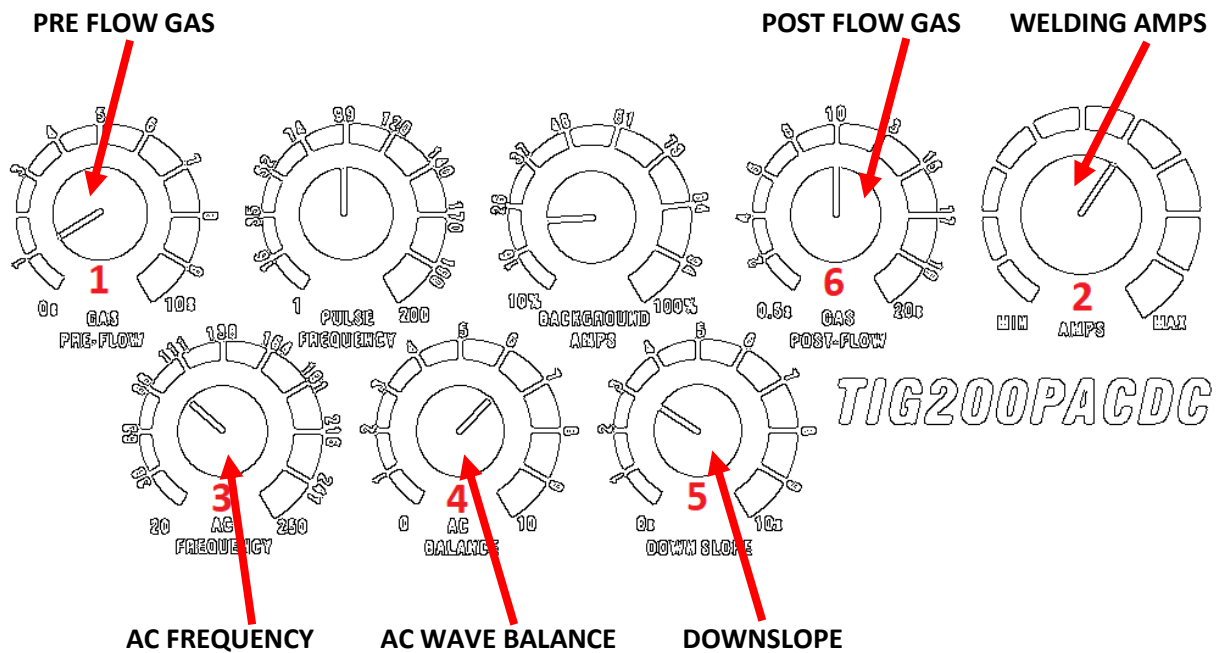
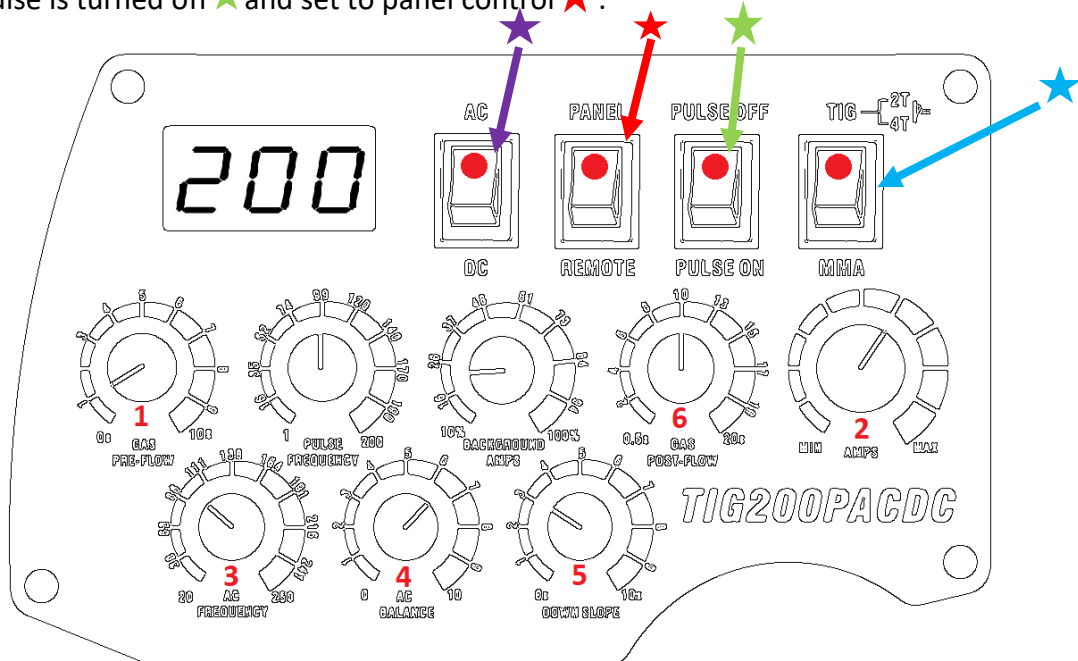


JT-202A AC Welding Basic Set-Up Guide

For AC TIG welding, set up as below and ensure you place the machine in TIG and 2T mode★, AC mode★, pulse is turned off★ and set to panel control★.



Set parameters as follows using control panel image above as reference:

Parameter	Units	Adjustable Range	Guide Setting	User Setting
Job/Material	---	---	---	
PRE-GAS TIME (1)	Seconds	0 ~ 10	0.5	
PEAK CURRENT * (2)	Amps	5 ~ 200	User defined *	
AC FREQUENCY (3)	Hz	20 ~ 250	50	
AC WAVE BALANCE (4)	%	0 ~ 10	5	
DOWN-SLOPE TIME (5)	Seconds	0 ~ 10	1	
POST-GAS TIME (6)	Seconds	0.5 ~ 20	5	

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