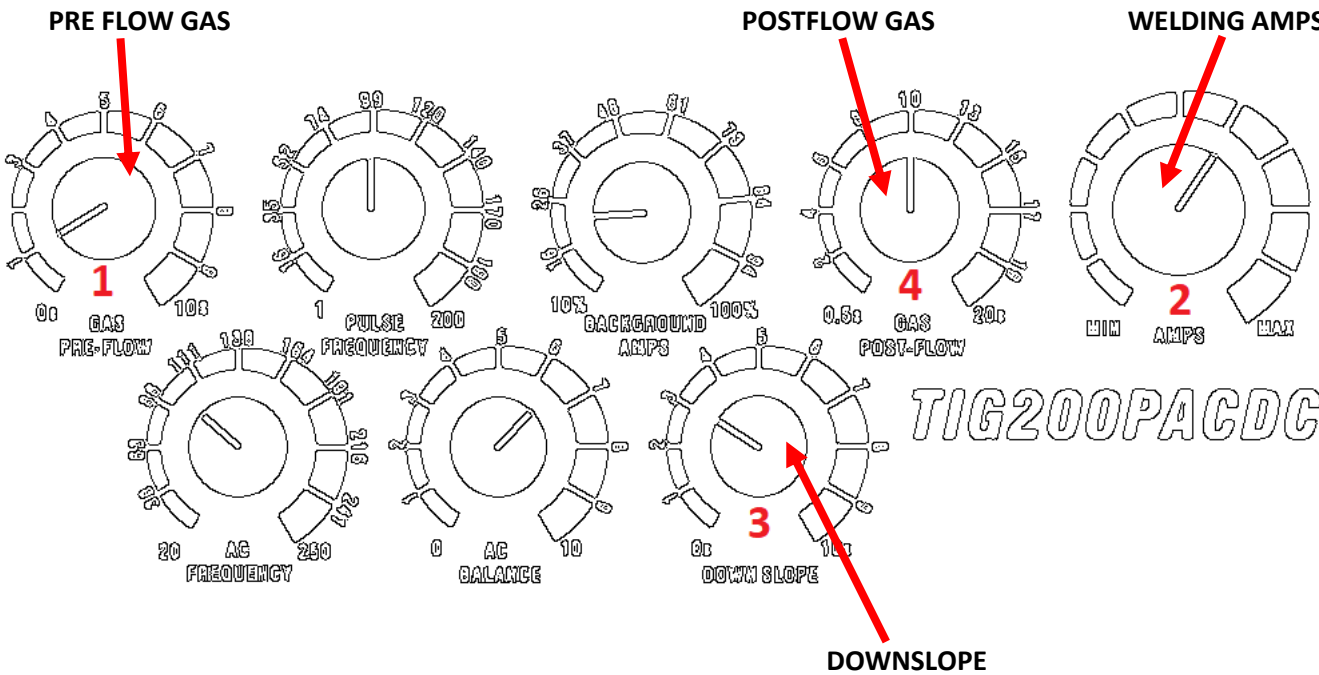
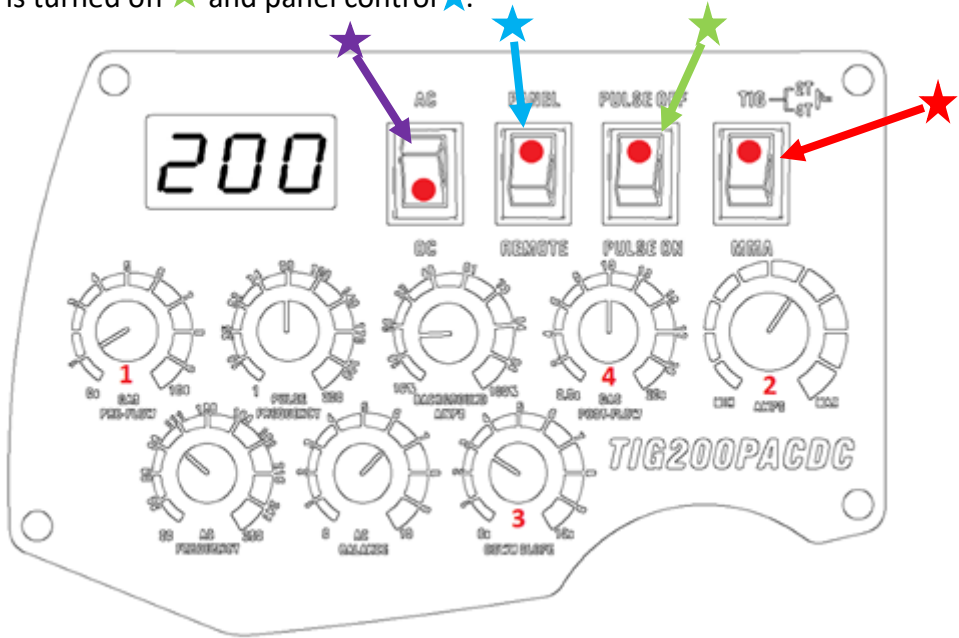


JT-202A DC Welding Basic Set-Up Guide

For DC TIG welding, set up as below and ensure you place the machine in TIG and 2T mode★, DC mode★, pulse is turned off★ and 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 ~ 3.0	0.5	
WELDING CURRENT * (2)	Amps	5 ~ 200	User defined *	
DOWN-SLOPE TIME (3)	Seconds	0 ~ 10	0	
POST-GAS TIME (4)	Seconds	0.5 ~ 20	3	

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