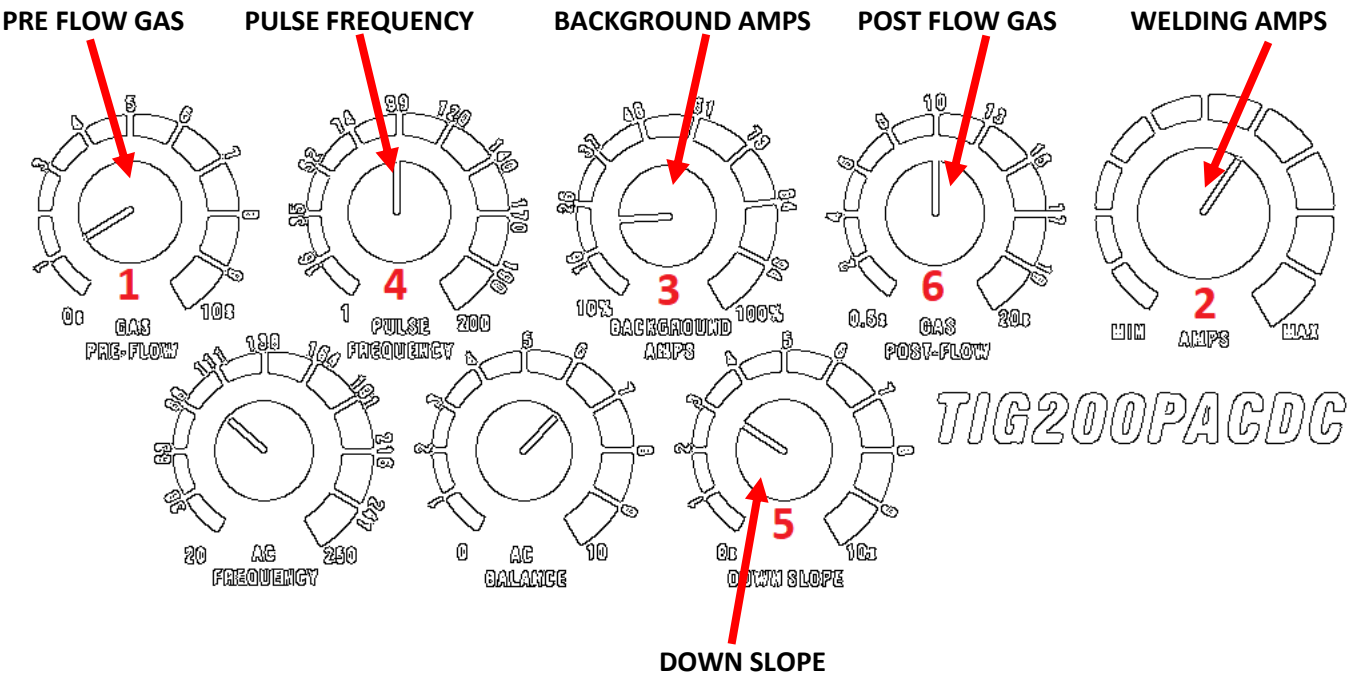
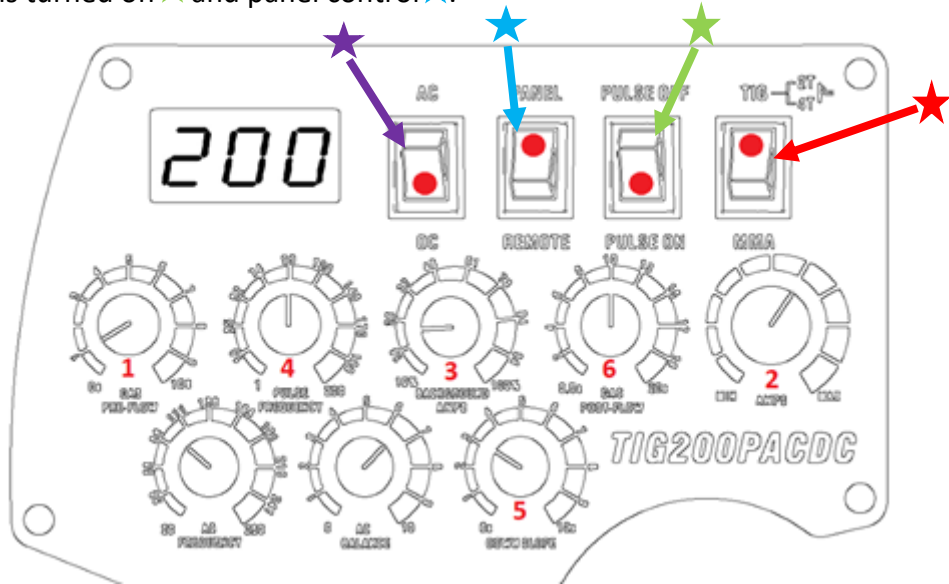


JT-202A DC Welding Pulse Set-Up Guide

For DC TIG Pulse welding, set up as below and ensure you place the machine in TIG and 2T mode★, DC mode★, pulse is turned on★ 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 * |              |
| BACKGROUND CURRENT (3) | %       | 10 ~ 100         | 50             |              |
| DOWN-SLOPE TIME (5)    | Seconds | 0 ~ 10           | 0              |              |
| PULSE FREQUENCY (4)    | Hz      | 1 ~ 200          | 0.5            |              |
| POST-GAS TIME (6)      | Seconds | 0.5 ~ 20         | 3              |              |

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