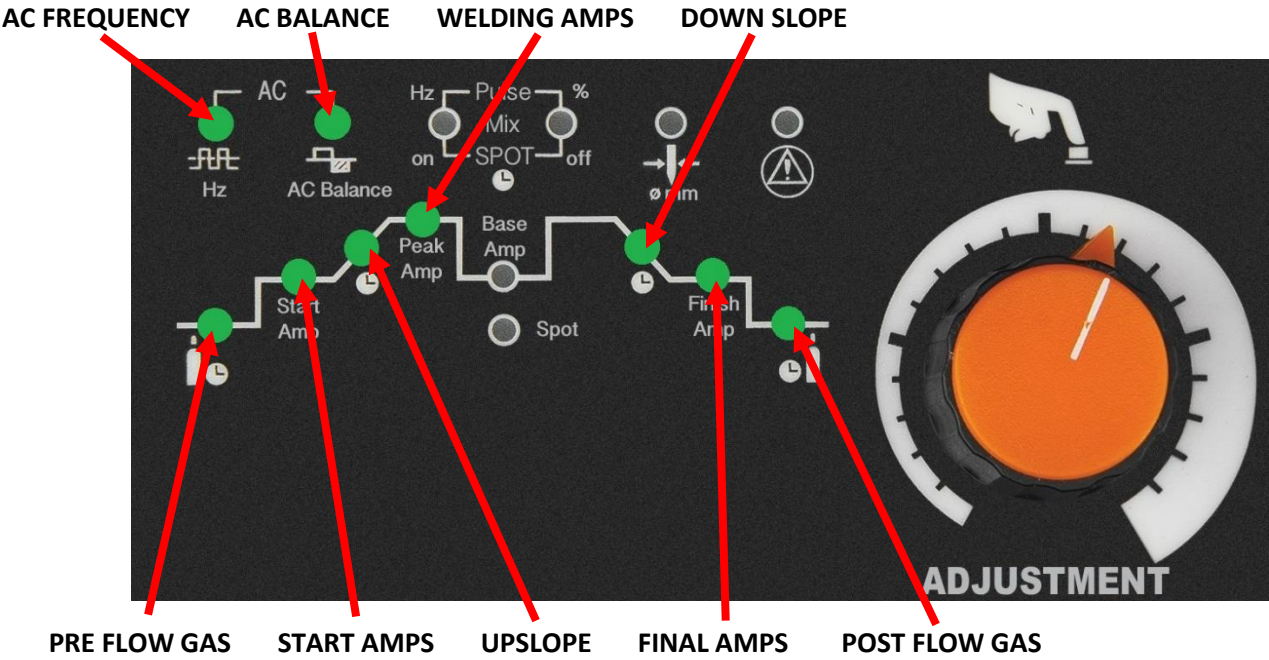


JT-315P MWD AC Welding Basic Set-Up Guide

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



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	30 ~ 315	User defined *	
AC FREQUENCY	Hz	50 ~ 200	70	
AC BALANCE	%	20 ~ 60	40	
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

Note: Please ensure you have set the water cooling option to ON/OFF depending on TIG Torch fitted