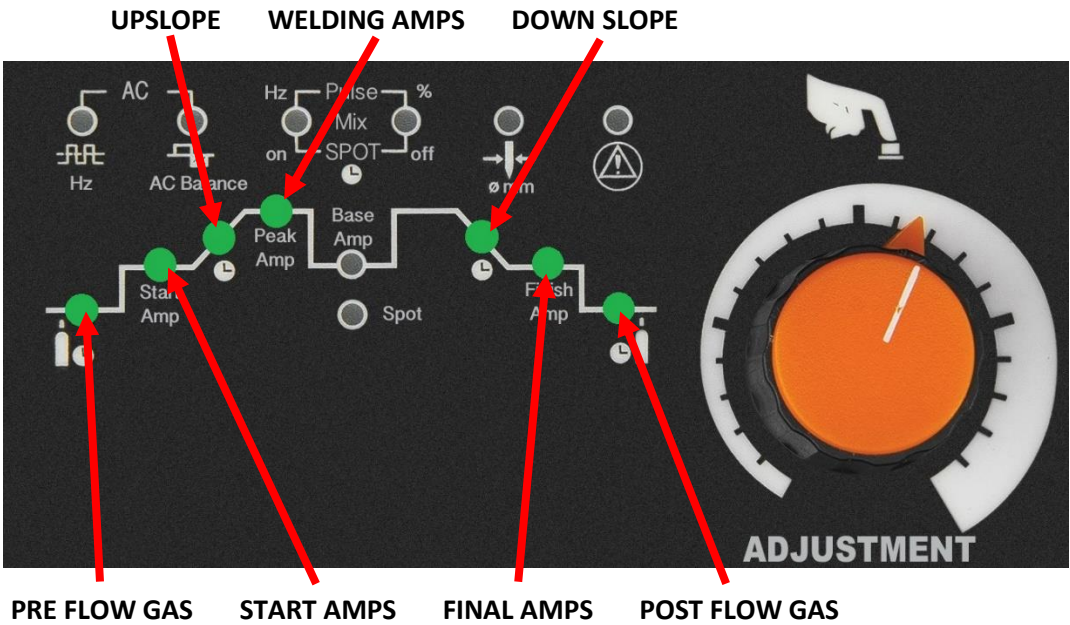


JT-315P MWD DC Welding Basic Set-Up Guide

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



Set parameters as follows using control panel image 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	15	
UP-SLOPE TIME	Seconds	0 ~ 15	0	
PEAK CURRENT *	Amps	10 ~ 315	User defined *	
DOWN-SLOPE TIME	Seconds	0 ~ 15	1	
FINAL CURRENT	Amps	10 ~ 315	10	
POST-GAS TIME	Seconds	0.5 ~ 15	2	

* 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