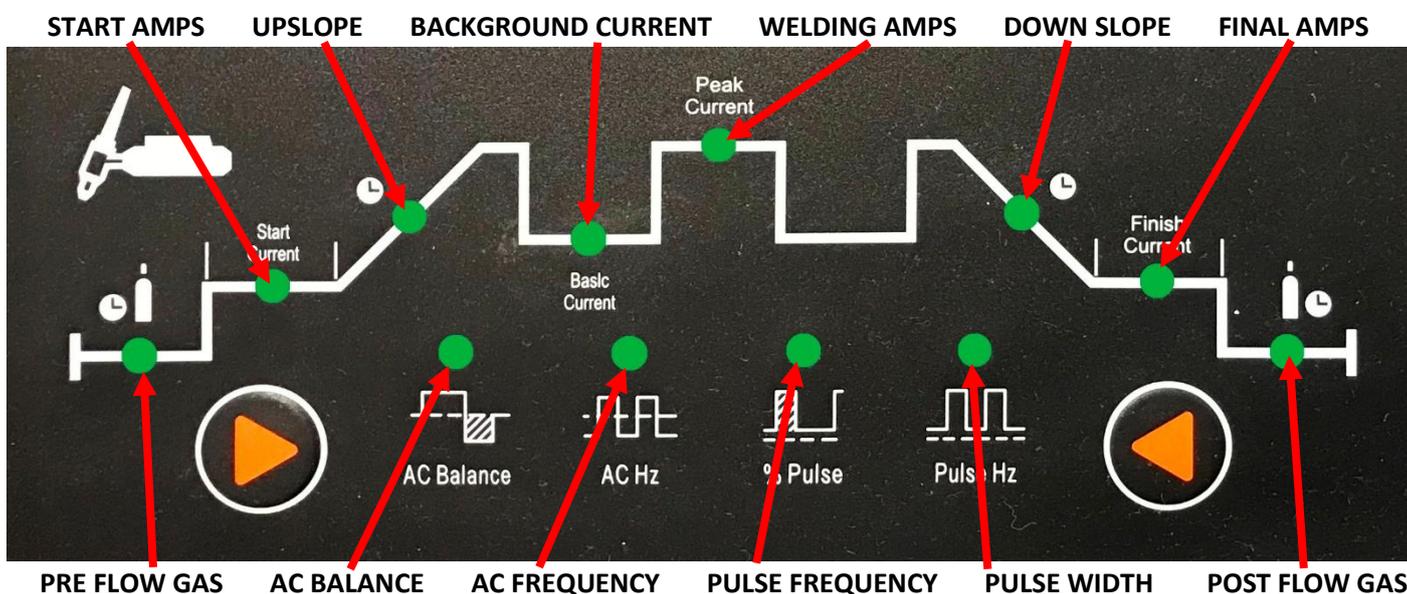
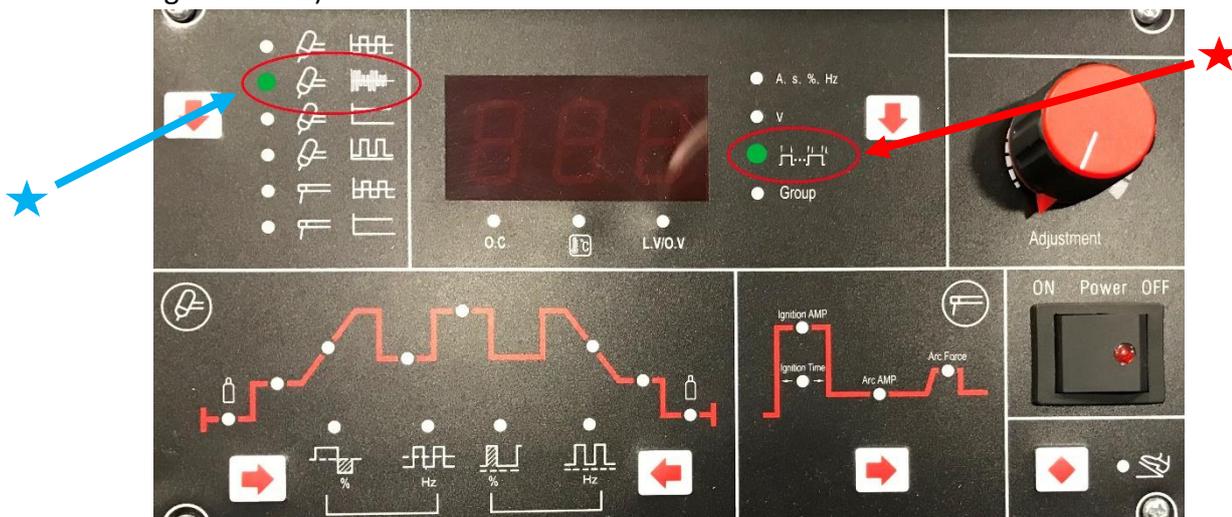


JT-200D AC Welding Basic Set-Up Guide – With Pulse

For AC Pulse TIG welding, set up as below and ensure you place the machine in AC Pulse ★ and 2T ★ mode (which is setting number 2)



Set parameters as follows using images above as reference:

Parameter	Units	Adjustable Range	Guide Setting	User Setting
Job/Material	---	---	---	
PRE-GAS TIME	Seconds	0 ~ 15	0.5	
START-CURRENT	Amps	20 ~ 200	20	
UP-SLOPE TIME	Seconds	0 ~ 60	0	
PEAK CURRENT *	Amps	30 ~ 205	User defined *	
BASE CURRENT **	Amps	30 ~ 205	50% **	
AC FREQUENCY	Hz	20 ~ 70	70	
AC BALANCE	%	10 ~ 60	35	
PULSE FREQUENCY	Hz	0.5 ~ 5	1	
PULSE WIDTH	%	10 ~ 90	50	
DOWN-SLOPE TIME	Seconds	0 ~ 60	1	
FINAL CURRENT	Amps	20 ~ 200	20	
POST-GAS TIME	Seconds	0 ~ 20	7	

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

** Set base current to 50% of your peak welding current