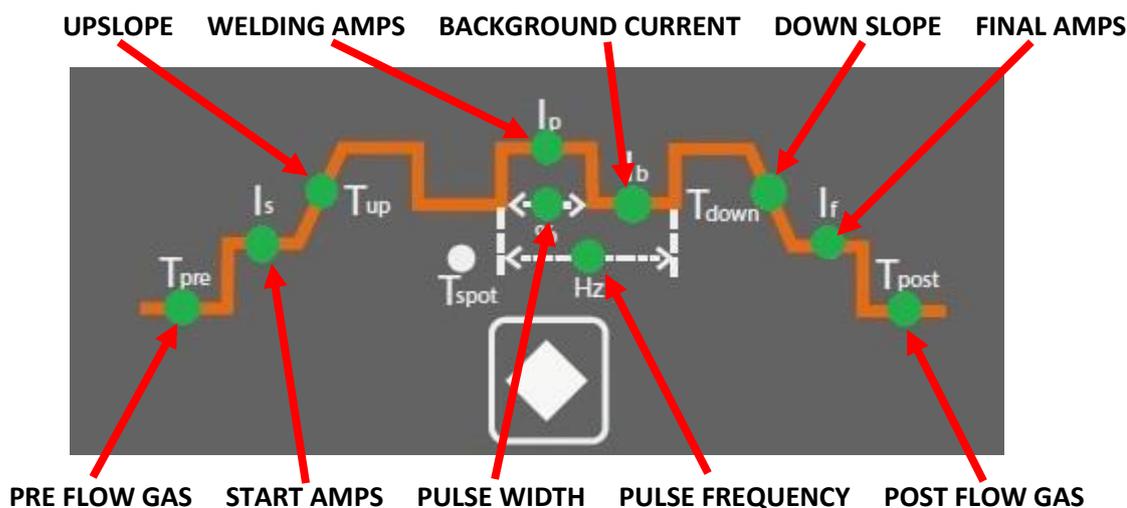
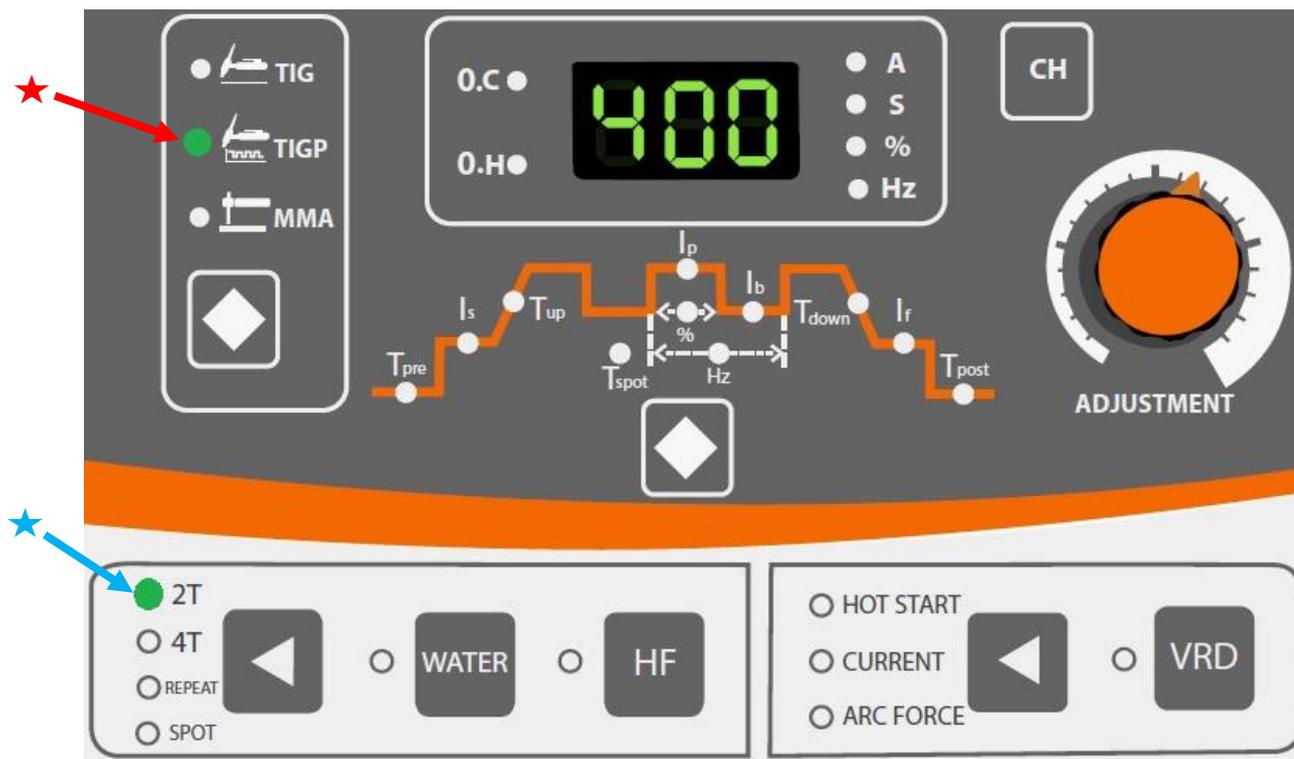


JT-400P DC Welding Basic Set-Up Guide – With Pulse

For DC TIG Pulse welding, set up as below and ensure you place the machine in TIG Pulse★ and 2T★ mode



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	0.2	
START-CURRENT	Amps	5 ~ 400	10	
UP-SLOPE TIME	Seconds	0 ~ 10	0	
PEAK CURRENT	Amps	5 ~ 400	User defined *	
BASE CURRENT	Amps	5 ~ 400	50% **	
PULSE FREQUENCY	Hz	0.5 ~ 200	50	
PULSE WIDTH	%	10 ~ 90	50	
DOWN-SLOPE TIME	Seconds	0 ~ 10	0.5	
FINAL CURRENT	Amps	5 ~ 400	10	
POST-GAS TIME	Seconds	0 ~ 15	2	

* Depends on material thickness (example to use is 30A per mm) e.g. 3mm = 90A

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

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