


PULSE PARAMETERS ADJUSTMENT (Only in MANUAL MODE)

STICK DC PULSE J--


V
68.0


I
100

Mode    Jobs 

1) Press the button  (Fig.1,ref.3) to enter in the menu ;

STICK settings


	Hot-Start:	+10%
	Arc-Force:	15%
	Hot-Start duration:	0.2s
	VRD 18V:	OFF
	DC Polarity:	STD(DCEp)

Home Pulse 


2) Press the button PULSE (Fig.1,ref.2) to go in the next page;

3) Here, turning the encoder (Fig.1,ref.6), it is possible to regulate the pulse frequency ;

Frequency


PPS 

5.0Hz


Home Pulse 

4) Press the encoder (Fig.1,ref.6) to jump to the next function : Duty Cycle ;

Duty Cycle

PPS 


50%

Home Pulse 


5) Turn the encoder (Fig.1,ref. 6) to modify the Duty Cycle value;

6) Press the encoder (Fig.1,ref.6) to jump to the next function BASE CURRENT ;

Base %

PPS 

30%

Home Pulse 


7) Turn the encoder (Fig.1,ref. 6) to modify the base current value;

8) Press the button HOME (Fig.1,ref. 1) to come back to the main screen;

TIG WELDING

1) Press the button MODE (Fig.1, ref.1) to enter in the menu.

Mode selection

	STICK
	TIG 2T
	TIG 4T
	TIG SPOT
	TIG RESET/BILEVEL

Home

2) Use the encoder (Fig.1, ref.6) to select the Welding Mode and press it to confirm the choice.