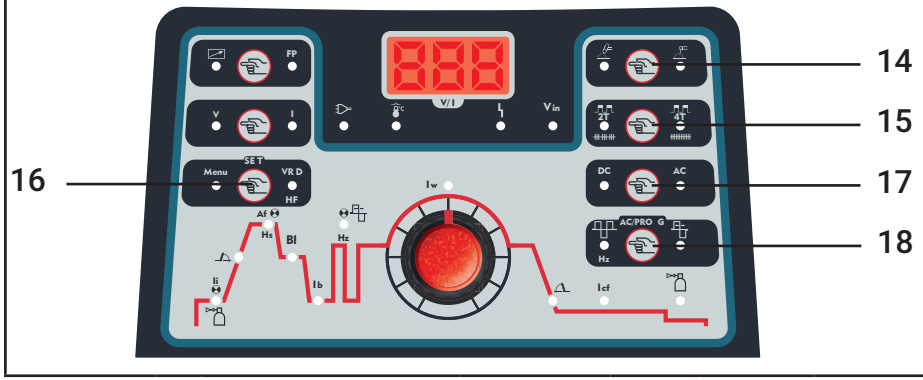
AC/DC TIG Fast Set-up

MATERIAL	THICKNESS (mm)	TIG process (14-17)	Pulsed (15)	JOIN	Iw (welding current)	Ib (base current)	Slope down time	Icf (crater filler current)	Post Gas Time	Frequency Hz (18)	Balance (18)	Electrode Diameter
Mild Steel	2	DC			90				3			
	4	DC			120				3			
	4	DC	Yes		140	60			3			
	4	DC			120				3			
	6	DC			160				3			
	6	DC	Yes		170	80			3			
	6	DC			180				3			
Stainless Steel	1	DC	Yes		50	20			4			
	2	DC	Yes		70	30			4			
	4	DC	Yes		110	60						
Alluminium	2	AC			70		0,5	20	4	82	0	2,4
	4	AC			110		0,5	20	4	92	0	2,4
	4	AC			130		0,5	20	4	64	0	2,4
	8	AC			180		0,5	20	4	64	0	3,2



Key Legend

14: Process selection
15: 2T / 4T selection. Press again for Pulsed Mode
16: Menù button for welding parameters setting
17: DC or AC selection
18: AC frequency / Balance wave selection

77611713