

# TIG 200 AC/DC PFC Quick Setup Guide

## AC TIG Setup (Aluminium TIG welding)

- Pre-gas: 0.5 – 1 sec.
- Start Amps: 20A.
- Up Slope: 0.5 sec.
- Peak Amps: Depending on material thickness.
- Down Slope: 1.5 sec.
- End Amps: 20A.
- Post Gas: 5-6 sec minimum. Increase if tungsten is becoming black/dirty after welding. Post gas is required to ensure tungsten cools under gas coverage and does not oxidize.
- AC Balance: Start at 40% (balanced wave) and adjust to suit application.
- AC Hz (frequency): Start at 120Hz and adjust to suit application

## DC TIG Setup

- Pre-gas: 0.5 – 1 sec.
- Start Amps: 15A.
- Up Slope: 0.5 sec.
- Peak Amps: Depending on material thickness.
- Down Slope: 1.5 sec.
- End Amps: 15A.
- Post Gas: 5-6 sec minimum. Increase if tungsten is becoming black/dirty after welding. Post gas is required to ensure tungsten cools under gas coverage and does not oxidize.

## Mix TIG Setup

- Same as AC TIG setup. See above.
- Mix ACDC %: Start at 50% and adjust to suit application.
- Mix ACDC Hz (frequency): 3Hz. Adjust to suit application.

## MMA Setup

- Hot Start: 30A to start with. Adjust to suit application.
- Arc Force: 10A to start with. Adjust to suit application.

