DC TIG Setup

- · Pre-gas: 0.5 1 sec.
- · Start Amps: 15A.
- · Up Slope: 0.5 sec.
- · Peak Amps: Depends on material thickness.
- · Down Slope: 1.5 sec.
- · End Amps: 15A.

 \cdot Post Gas: 1 second to every 10Amps of Peak Current, E.g: 100 Amps = 10 Seconds. Increase if tungsten is becoming black/dirty after welding. Post gas is required to ensure tungsten cools under gas coverage and does not oxidize.

· When using pulse, set pulse width to 50% and pulse frequency to best suit the job.

AC TIG Setup (Aluminium TIG welding)

- · Pre-gas: 0.5 1 sec.
- · Start Amps: 20A.
- · Up Slope: 0.5 sec.
- · Peak Amps: Depends on material thickness.
- · Down Slope: 1.5 sec.
- · End Amps: 20A.

 \cdot Post Gas: 1 second to every 10Amps of Peak Current, E.g: 100 Amps = 10 Seconds. 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 0 (balanced wave) and adjust to suit application.
- · AC Hz (frequency): Start at 120Hz and adjust to suit application.
- \cdot When using pulse, set pulse width to 50% and pulse frequency to best suit the job.

 \cdot Note that the max pulse frequency is tied to the AC frequency. This because a high pulse frequency in relation to the AC frequency can interfere with the AC welding wave form. Increase the AC frequency to increase the max pulse frequency.

Mix TIG Setup

- \cdot Same as AC TIG setup. See above.
- \cdot Mix ACDC %: Start at 50% and adjust to suit application.
- \cdot Mix ACDC Hz (frequency): 3Hz. Adjust to suit application.
- \cdot Note there is no pulse function with Mix TIG.

