

SINCE 1958

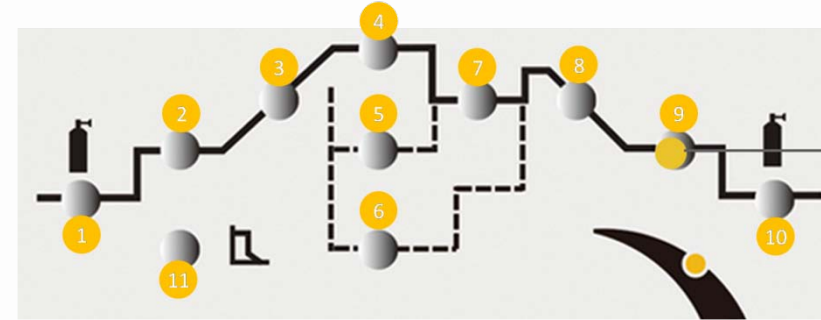


TOTAL WELDING AND CUTTING SOLUTIONS

POWER TIG 200DP III



WELDING PROCEDURE PARAMETERS SELECTION AND SETTING



- 1- Pre-Flow ; Shielding gas pre-flow time (sec.); in TIG (GTAW) welding mode; used for providing the shielding gas to the weld zone before the arc striking.
- 2- Ignition Current; In TIG (GTAW) welding mode; used for setting the start current.
- 3- Up-Slope; In TIG (GTAW) welding mode; used for setting the time (sec.) for the ignition current to the welding current.
- 4- Welding Current ; In TIG (GTAW) and MMA (SMAW) welding modes; used for setting the welding current.
Peak Current : In Pulse TIG (GTAW) welding mode; used for setting the peak current.
- 5- Pulse Ratio ; In Pulse TIG (GTAW) welding mode; used for setting the percentage (%) time of the pulse prequency for welding current.
- 6- Frequency; In Pulse TIG (GTAW) welding mode; used for setting the pulse frequency in Hertz(Hz.)
- 7- Base- Current; In Pulse TIG (GTAW) welding mode; used for setting the TIG (GTAW) back-ground current.
- 8- Down-Slope; In TIG (GTAW) welding mode; used for setting the time (in sec.) for the welding current to the crater current.
- 9- Crater Current; In TIG (GTAW) welding mode; used for setting the crater current at the end of down-slope .
- 10- Post-Flow ; Shielding gas post-flow time (sec.); in TIG (GTAW) welding mode; used for providing the shielding gas to the weld zone after arc extinguished.
- 11- Arc – Force; In MMA (SMAW) welding mode; it used for preventing the electrode from sticking during welding. Arc force is a temporary increase of the output current during welding when the arc is too short.

