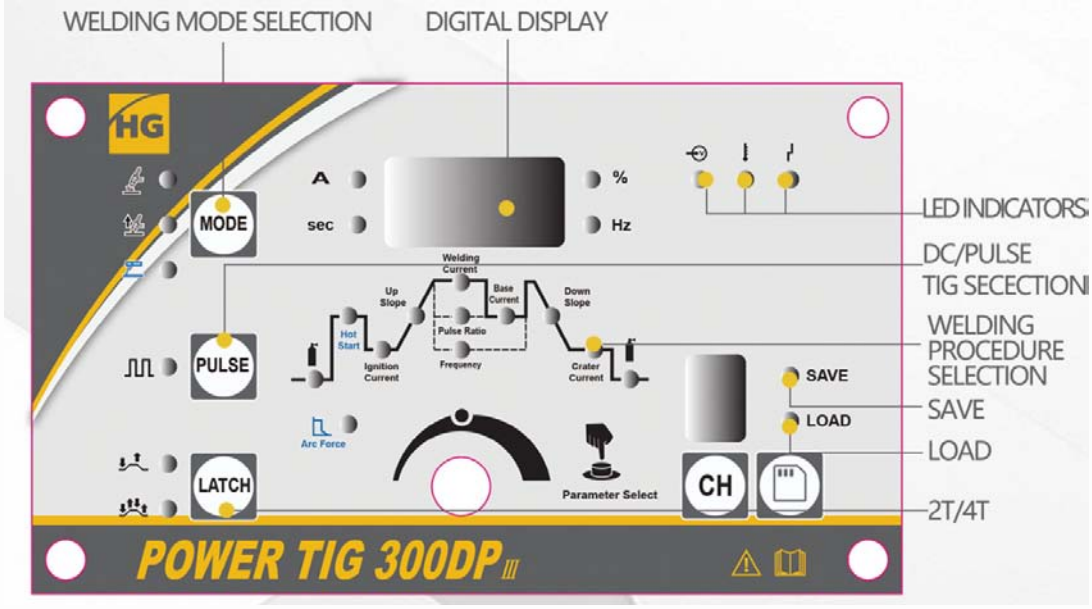
SINCE 1958

HUGONG

TOTAL WELDING AND CUTTING SOLUTIONS

POWER TIG 300DP III



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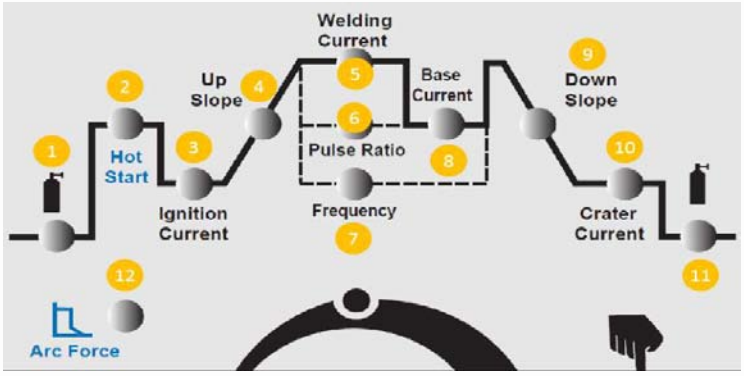
TOTAL WELDING AND CUTTING SOLUTIONS

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- Hot-Start; In MMA (SMAW) welding mode; used for temporary increase of the output current during the start of weld.
3- Ignition Current; In TIG (GTAW) welding mode; used for setting the start current.
4- Up-Slope; In TIG (GTAW) welding mode; used for setting the time (sec.) for the ignition current to the welding current.
5- 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.
6- Pulse Ratio ; In Pulse TIG (GTAW) welding mode; used for setting the percentage (%) time of the pulse frequency for welding current.
7- Frequency; In Pulse TIG (GTAW) welding mode; used for setting the pulse frequency in Hertz(Hz.)
8- Base- Current; In Pulse TIG (GTAW) welding mode; used for setting the TIG (GTAW) back-ground current.
9- Down-Slope; In TIG (GTAW) welding mode; used for setting the time (in sec.) for the welding current to the crater current.
10- Crater Current; In TIG (GTAW) welding mode; used for setting the crater current at the end of down-slope .
11- 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.
12- 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.