



TIG200PACDC SET-UP-GUIDE

Note:

This set-up information is intended to act as a guide only. Please refer to operating manual for further information.

MATERIAL	MATERIAL THICKNESS		FUNCTION SELECTION	AMPERAGE	PULSE	WAVEFORM SELECTION	TUNGSTEN COLOR	TUNGSTEN DIA.		FILLER METAL	FILLER METAL DIA.		PRE FLOW	POST FLOW	TORCH CUP SIZE			GAS FLOW RATE	AC balance
	inch	mm						inch	mm		inch	mm			sec	sec	no.		inch
Aluminum	1/25	1.0	AC	47-60	/	Square wave	Green,Purple	1/16	1.6	4043	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	15	25
Aluminum	1/16	1.6	AC	55-75	/	Square wave	Green,Purple	1/16	1.6	4043	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	15	25
Aluminum	3/32	2.4	AC	70-100	/	Square wave	Green,Purple	1/16	1.6	4043	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	15	25
Aluminum	1/8	3.2	AC	90-140	/	Square wave	Green,Purple	3/32	2.4	4043	3/32	2.4	0.4	6	#6 #7	3/8-7/16	13N10,13N11	17	25
Aluminum	3/16	4.8	AC	125-180	/	Square wave	Green,Purple	3/32	2.4	4043	3/32	2.4	0.4	6	#7 #8	7/16-1/2	13N11,13N12	21	25
Steel	1/16	1.6	DC-	45-80	/	/	Gray,Red,White,Purple	1/16	1.6	ER70S-2	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	12	/
Steel	3/32	2.4	DC-	70-110	/	/	Gray,Red,White,Purple	1/16	1.6	ER70S-2	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	12	/
Steel	1/8	3.2	DC-	75-125	/	/	Gray,Red,White,Purple	1/16	1.6	ER70S-2	3/32	2.4	0.4	6	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	12	/
Steel	3/16	4.8	DC-	110-200	/	/	Gray,Red,White,Purple	3/32	2.4	ER70S-2	1/8	3.2	0.4	6	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	14	/
Stainless Steel	1/16	1.6	DC-	50-90	/	/	Gray,Red,White,Purple	1/16	1.6	ER308/308L	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	12	/
Stainless Steel	3/32	2.4	DC-	80-120	/	/	Gray,Red,White,Purple	1/16	1.6	ER308/308L	1/16	1.6	0.4	5	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	12	/
Stainless Steel	1/8	3.2	DC-	85-140	/	/	Gray,Red,White,Purple	1/16	1.6	ER308/308L	3/32	2.4	0.4	6	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	12	/
Stainless Steel	3/16	4.8	DC-	125-200	/	/	Gray,Red,White,Purple	3/32	2.4	ER308/308L	1/8	3.2	0.4	6	#4 #5 #6	1/4-3/8	13N08,13N09,13N10	14	/

