

## LIFT TIG / HF TIG SET-UP GUIDE

1 SELECT PROCESS	2 MODE SELECTION	a MATERIAL SELECTION	b BASE METAL SIZE	c JOINT TYPE	d TUNGSTEN / FILLER ROD SIZE*	WELD CURRENT	AC FREQUENCY	POST FLOW	SELECT TIG CUP SIZE	SELECT GAS FLOW
HF TIG	AC ~	Aluminum	16 ga. (1.6 mm)	Butt	1/16" (1.6 mm)	65A	150 Hz	5 sec.	4, 5, 6	15 cfh (7 l/m)
			16 ga. (1.6 mm)	Fillet	1/16" (1.6 mm)	85A	150 Hz	6 sec.	4, 5, 6	15 cfh (7 l/m)
			1/8" (3.2 mm)	Butt	3/32" (2.4 mm)	135A	150 Hz	11 sec.	6, 7	17 cfh (8 l/m)
			1/8" (3.2 mm)	Fillet	3/32" (2.4 mm)	150A	150 Hz	13 sec.	6, 7	17 cfh (8 l/m)
			3/16" (4.7 mm)	Butt	1/8" (3.2 mm)	160	100 Hz	13 sec.	7, 8	17 cfh (8 l/m)
			3/16" (4.7 mm)	Fillet	1/8" (3.2 mm)	170A	80 Hz	13 sec.	7, 8	17 cfh (8 l/m)
			1/4" (6.4 mm)	Butt	1/8" (3.2 mm)	200A	80 Hz	13 sec.	7, 8	17 cfh (8 l/m)
			1/4" (6.4 mm)	Fillet	1/8" (3.2 mm)	200A	80 Hz	13 sec.	7, 8	17 cfh (8 l/m)
LIFT TIG /HF TIG	DC (-) =	Stainless Steel	16 ga. (1.6 mm)	Butt	1/16" (1.6 mm)	50A	-	5 sec.	4, 5, 6	15 cfh (7 l/m)
			16 ga. (1.6 mm)	Fillet	1/16" (1.6 mm)	60A	-	6 sec.	4, 5, 6	15 cfh (7 l/m)
			1/8" (3.2 mm)	Butt	3/32" (2.4 mm)	110A	-	11 sec.	6, 7	17 cfh (8 l/m)
			1/8" (3.2 mm)	Fillet	3/32" (2.4 mm)	150A	-	13 sec.	6, 7	17 cfh (8 l/m)
			3/16" (4.7 mm)	Butt	1/8" (3.2 mm)	170A	-	13 sec.	7, 8	17 cfh (8 l/m)
			3/16" (4.7 mm)	Fillet	1/8" (3.2 mm)	170A	-	13 sec.	7, 8	17 cfh (8 l/m)
			1/4" (6.4 mm)	Butt	1/8" (3.2 mm)	175A	-	13 sec.	7, 8	17 cfh (8 l/m)
			1/4" (6.4 mm)	Fillet	1/8" (3.2 mm)	180A	-	13 sec.	7, 8	17 cfh (8 l/m)

LIFT TIG /HF TIG	DC (-) =	Mild Steel	16 ga. (1.6 mm)	Butt	1/16" (1.6 mm)	50A	-	5 sec.	4, 5, 6	15 cfh (7 l/m)
			16 ga. (1.6 mm)	Fillet	1/16" (1.6 mm)	60A	-	6 sec.	4, 5, 6	15 cfh (7 l/m)
			1/8" (3.2 mm)	Butt	3/32" (2.4 mm)	125A	-	11 sec.	6, 7	17 cfh (8 l/m)
			1/8" (3.2 mm)	Fillet	3/32" (2.4 mm)	125A	-	13 sec.	6, 7	17 cfh (8 l/m)
			3/16" (4.7 mm)	Butt	1/8" (3.2 mm)	170A	-	13 sec.	7, 8	17 cfh (8 l/m)
			3/16" (4.7 mm)	Fillet	1/8" (3.2 mm)	200A	-	13 sec.	7, 8	17 cfh (8 l/m)

Note: LIFT TIG / HF TIG set-up guide parameters may vary depending upon welding position and joint design.

\* - If Required

## PULSE SET-UP GUIDE

1 SELECT PROCESS	2 MODE SELECTION	a MATERIAL SELECTION	b BASE METAL SIZE	HIGH CURRENT	WIDTH	FREQUENCY	LOW CURRENT	Pulse Notes Wave Balance is 30% (AC Mode Only)
LIFT TIG /HF TIG	AC Pulse ~	Aluminum	16 ga. (1.6 mm)	120A	60%	1100 Hz Pulse	55A	
			1/8" (3.2 mm)	170A	60%	1 Hz Pulse	60A	
	DC (-) = Pulse ~	Stainless Steel	16 ga. (1.6 mm)	65A	50%	11 Hz Pulse	30A	
			1/8" (3.2 mm)	125A	65%	11 Hz Pulse	50A	
			3/16" (4.7 mm)	195A	60%	11 Hz Pulse	75A	
		Mild Steel	16 ga. (1.6 mm)	85A	60%	11 Hz Pulse	40A	
1/8" (3.2 mm)	150A		60%	11 Hz Pulse	50A			

Note: Butt or Fillet Joint types can be used in Pulse mode. Set-up guide parameters may vary depending upon welding position.