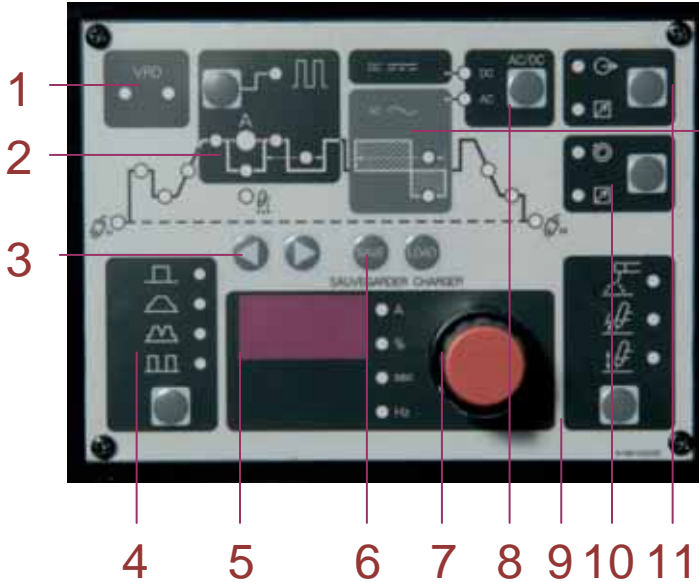


STANDARD FACEPLATE ON THE 185, 200 & 300 ACDC MODELS



1. VRD - (Voltage Reduction Device) lights indicate on or off.
2. Pulse Function - Pressing this button enables the TIG current pulse functions.
3. Scroll buttons – used to select the parameter to be set. The LED's show which function is being adjusted on the weld sequence graph.
4. TIG Mode Functions - Pressing this button scrolls through the output TIG function modes (Standard, Slope, Slope w/repeat, Spot).
5. Digital LED display – welding amperage and parameter values are displayed in this window. Internal warnings such as over temperature, low or high input voltage applied are signaled to the operator by a warning sound and error message on the screen.
6. Save/Load Buttons - By using the Save & Load buttons the operator can easily save up to 5 welding parameter programs.
7. Control knob – allows the operator to adjust the output amperage within the entire range of the power source, also used to set each parameter value.
8. AC/DC Button - Selects between AC or DC welding output.
9. Process functions – pressing this button scrolls through the output process modes (Stick, Lift & HF Start TIG).
10. Remote current function - pressing this button enables remote current.
11. Remote contactor function – pressing this button enables remote contactor on or off.
12. Adjustable AC Wave Balance Control.

12. Effect of Wave Balance Adjustment on AC/GTAW-Complete Welding Control

The ArcMaster® AC/DC Series of power sources' AC output is manually adjusted for balance control. This control of the wave form changes the amount of time spent on DCEP ('cleaning') and DCEN ('penetration') parts of each cycle, increasing arc stability. The DCEP cycle insures that the aluminum oxide is thoroughly removed allowing the DCEN cycle a thorough penetration of the base metal. Both cycles enhance weld quality and significantly improve performance.

When a conventional system changes its wave balance, there can be as much as a 50% increase in amperage draw. Thermal Arc's Pro-Wave amperage draw is unaffected by any adjustments. Pro-Wave increases efficiency and reduces tungsten spitting, and enables the use of a smaller diameter tungsten electrodes to operate at higher current levels. Figures 1 & 2 show the difference in the TIG torch electrode and heat and cleaning variations.

