

ACCUPOCKET 150/400 TIG

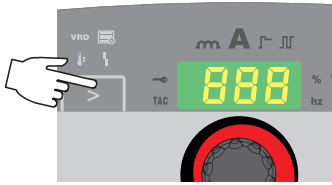
Quick reference

SAFETY



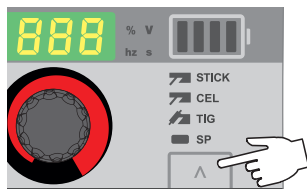
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online.

WELDING SETTINGS



Setting values:

- ⇒ **m** Arc-force dynamic: 0 - 100 | factory setting = 20
- ⇒ **A** Welding current: 10 - 140 A (STICK), 3 - 150 A (TIG)
- ⇒ **⌋** SoftStart / HotStart function: 0 - 200% | factory setting = 130%
- ⇒ **⌋⌋** TIG pulsing: OFF / 0.5 - 10 Hz Factory setting = OFF



Available welding processes:

- ⇒ **STICK** MMA welding
- ⇒ **CEL** MMA welding with Cel electrode
- ⇒ **TIG** TIG welding
- ⇒ **SP** Reserved for special programs



42,0426,0247,EN 002-08082017

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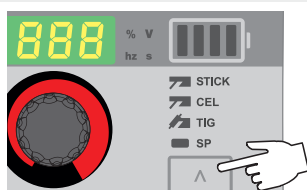
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ACCESSING THE SETUP MENU



Setup menu - MMA welding



Setup menu - Cel electrodes



Setup menu - TIG



CHANGING WELDING PARAMETERS

Turn and press the adjusting dial to select and change parameters.

PARAMETERS FOR MMA WELDING

Ht_i	Starting current duration: 0.1 - 1.5 seconds 0.5 seconds*
ASt	Anti-stick: On*/OFF
U_{co}	Break voltage: 25 - 80 V 45 V*
SOF	Software version
t_{sd}	Automatic switch-off: 300 - 900* seconds / OFF
FAC	Factory setting

* factory setting

PARAMETERS FOR TIG WELDING

t_{ri}	Mode: OFF/2-step*/4-step
1-5	Starting current: 1 - 200% 50%*
1-2	Reduced current: 1 - 200% 50%*
1-E	Final current: 1 - 100% 50%*
GP_o	Gas post-flow time: 0.2 - 9.9* seconds
CS_s	Comfort Stop sensitivity: 0.3 - 2.0 V / OFF*
U_{co}	Break voltage: 12 - 35 volts 15 volts*
t_{ARC}	Tacking function: OFF* / 0.1 - 5.0 seconds
SOF	Software version
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Setup menu - TIG



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