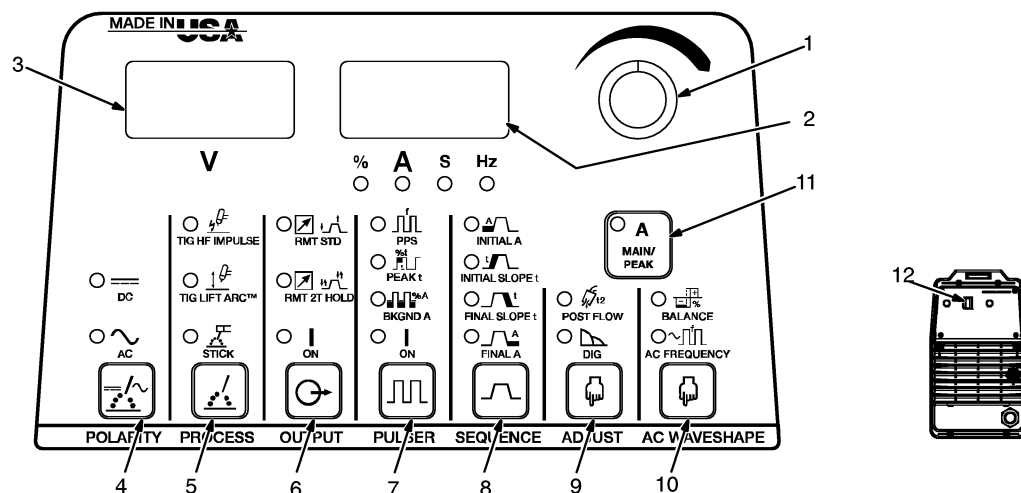


Dynasty Hidden Menu Guide

- **Resetting Unit to Factory Defaults** – Lockout feature must be off. Turn unit on while holding Process, Output, and Adjust switch pads for each memory/process setting. (See Owner’s Manual for factory default settings and diagram).
- **Accessing Programmable TIG Start Polarity, Amperage, and Time Modes** – Turn unit on while holding Process and Main Amperage switch pads. – Ensure all procedures and parameters are established for each memory before accessing (See Owner’s Manual for details).
- **Reconfiguring RMT 2 HOLD for 2T, Spot, 4T, 4T Momentary, or mini logic** – Turn unit on while holding Process and Output switch pads (See Owner’s Manual for details).
- **Arc Time/Counter Display** – Turn unit on while holding Output and Main Amperage switch pads. Arc Time is displayed first for 5 seconds. The first 4 numbers = hours / the last 2 numbers = minutes. After 5 seconds, the arc count is displayed for 5 seconds (See Owner’s Manual for details).
- **Lockout Functions** – Turn unit on while holding Adjust and Main Amperage switch pads. 1–4 lockout levels: 1– No Remote Amperage/RMT Std or 2T Hold Available/On Function if Lift Arc was active/ 2– Same as above plus Polarity and Process Selection/ 3– Same as above plus +/- 10% adjustment on preset amps/Pulser ON/OFF 4– Same as above plus Remote Amperage Control (See Owner’s Manual for details).
- **Dynasty 200 (only) – Preflow Adjust** – Turn power on while holding Process and Adjust switch pads (See Owner’s Manual for details).
- **HELP Displays** – If 0, 1, 2, 4, 6, 7, 8, or 9 are displayed, contact a Factory Authorized Service Agent. Displays 3 and 5 indicate an overheating condition. The unit shuts down, but fan runs to cool unit. Continue operation when unit has cooled. Display 10 indicates that the torch trigger is depressed. Release trigger to continue. Display 12 indicates an improper set-up. You are trying to make an adjustment that is not allowed.
- Using a 1/8th or 3/32nd 2% thoriated tungsten, show the customer the arc difference by adjusting the AC balance while welding on aluminum. Start with the balance at 68 and slowly adjust upward/downward. Begin with the frequency at 60Hz to show the comparison between a phase control machine and then move to 120Hz. By adjusting the balance and frequencies you can see the differences between more cleansing and arc shaping to direct the arc to the root where needed yet reduce penetration on thinner aluminum as required.



This guide is for reference only, and is not a substitute for the Owner’s Manual. Carefully read and follow all safety information in the Owner’s Manual and on all Safety Labels. Call your distributor if you do not understand the safety information.



- | | | |
|-----------------------------|---------------------|-------------------------------|
| 1 Weld Process (TIG) Button | 5 Process Control | 9 Adjust Control |
| 2 Amperage Meter | 6 Output Control | 10 AC Waveshape Control |
| 3 Voltage Meter | 7 Pulser Control | 11 Amperage/Spot Time Control |
| 4 Polarity Control | 8 Sequencer Control | 12 Power Switch |

Dynasty User/Demo Guide



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- **Low OCV Stick** reduces open-circuit voltage to approximately 13 volts when the welder is not in use. This built in circuitry eliminates the need for add-on voltage reducers.
- **Auto-Line** automatically connects to 120–460 VAC, single or three-phase power with no hands on linking. This also allows the unit to adapt to voltage spikes with minimal loss of output and reduces initial set up time.
- **Lift-Arc AC or DC** enables operator to weld in either AC/DC with only 5–10 volts and reduce the risk of tungsten inclusions **even on aluminum without high frequency**. Most competitive models use a minimum of 54 volts, which can quickly ruin your tungsten, increase contamination, and sticky starts.
- **Arc Hour/Cycle Counter** customer the opportunity to track these important details that could help justify additional resource requirements. This can also help when trying to figure cost of a project or when maintaining a maintenance schedule.
- **Parameter Protection Lockout** can help reduce downtime by controlling the range and/or options available to the operator. This can also be beneficial when verifying code work parameters or multi-operator production work.
- **200 amps at 250 Hz available in AC** frequency control. Some competitors lose amperage output when increasing the frequency, which can lead to welds outside the expected parameters if they think they are getting 100% output at a higher frequency. In reality they may only get 170 amps above 85Hz from competitive 200 amp units.
- **AC Balance control** has a range of 30–99 %. This range is wider than some competitors who have 35–85%. The wider range allows greater versatility when adjusting the balance control.
- **25% more power efficient** than some competitors at 150 amps, 17 volts. This saves money over time.
- **Wider amperage range** – 5–200 amps combined with AC frequency control allows the Dynasty 200 to weld thicker material on AC. In DC the Dynasty offers the better low –end control on stainless or carbon steel (1–200 amps).
- **AC Pulse control** range of 0.2 – 500 PPS allows a greater range to reduce heat input and gain greater control of the weld puddle than some competitors whose range may be only .25 – 2.5 PPS.
- **Adaptive Hot Start** provides exceptional arc starts for all STICK applications
- Using a 1/8th or 3/32nd 2% thoriated or lanthanated tungsten show the customer the arc difference by adjusting the AC balance while welding on aluminum. Start with the balance between 68–74 and slowly adjust. Begin with the frequency at 60 Hz to show the comparison to a phase control machine and then move to 120 Hz. By adjusting the balance and frequencies you can see the differences between more cleansing and arc shaping to direct the arc to the root where needed yet reduce the penetration on thinner material where applicable.