

# Setup Procedure for Dynasty 350 for Gas Tungsten Arc Welding

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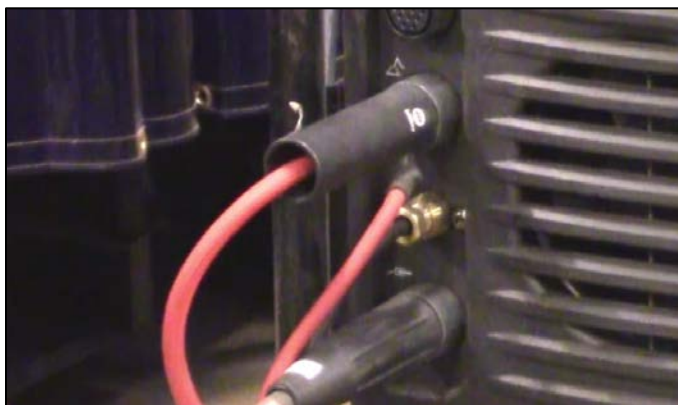
A handout containing the highlights of the videos titled *Setup Procedure for Dynasty 350 (GTAW)*

## Setting up the Dynasty 350

1. Connect the workpiece connection and electrode lead, and hose for water supply.



CAPTION 1. A CLOSE-UP PHOTO OF THE WORKPIECE CONNECTION .



CAPTION 2. THE ELCTRODE LEAD CONNECTION (LOCATED ABOVE THE WORKPIECE CONNECTION)



CAPTION 3. THE CONNECTED HOSES FOR WATER SUPPLY.

2. Connect wireless remote control communication for the gas pedal. Make sure to turn it only on the yellow part of the device .



CAPTION 4. THE WIRELESS REMOTE CONTROL COMMUNICATION DEVICE FOR THE GAS PEDAL.

3. Get foot pedal out.
4. Gently open the valve for the gas tank. When the needle moves, open the valve the whole way.



CAPTION 5. THE INSTRUCTOR TURNS THE VALVE ON THE GAS TANK.

5. Turn the power on.
6. Once it's booted up, set the following settings (The settings you need to have may vary from what is shown in the video. Talk to your instructor for assistance.):
  - a. Polarity
  - b. Process
  - c. Output
  - d. Pulser
  - e. Sequencer
  - f. Gas/Dig
  - g. AC Wave Shape



CAPTION 6. A CLOSE-UP OF THE DYNASTY 350. (FROM LEFT TO RIGHT OF THE PHOTO: POLARITY, PROCESS, OUTPUT, PULSER, SEQUENCER, GAS/DIG, AC/WAVE SHAPE)

## Check if Shielding Gas is flowing at the proper rate

1. Hold down the Gas/Dig button.



CAPTION 7. THE INSTRUCTOR HOLDS DOWN THE GAS/DIG BUTTON.

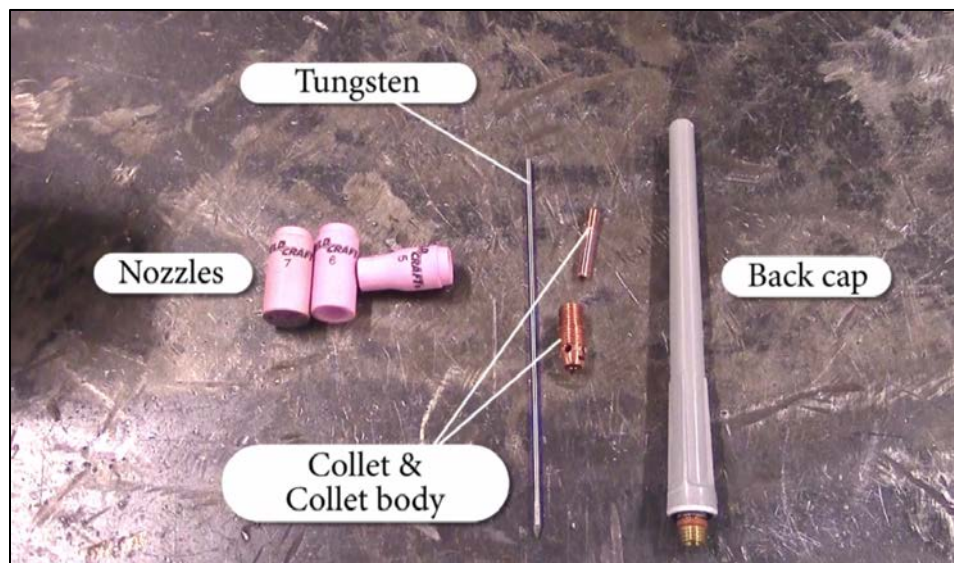
2. When it starts to purge, turn on your gas. Proper flow rate is between 17-20 cubic feet per hour.



CAPTION 8. THE FLOW RATE OF THE SHIELDING GAS IS SET ON THE GAS TANK.

## Putting the torch head together

1. Screw collet body in, sized to match the tungsten.
2. Insert the collet, slit-end down.
3. Insert the tungsten.
4. Screw the back cap in.
5. Thread the nozzle in.



CAPTION 9. THE PARTS OF THE TORCH HEAD (FROM LEFT TO RIGHT, TOP TO BOTTOM: NOZZLES, TUNGSTEN, COLLET AND COLLET BODY, AND BACK CAP)



## Looking for other learning materials?

The [Gas Tungsten Arc Welding iTunes U course](#) has videos and other learning materials for you to view. You can [download iTunes for free](#) to view the course and course materials. Closed-captioned videos are available at [T4E's YouTube page](#).

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