

Orion 250s Quick Start Guide



Follow the steps below to begin welding right away.

Step 1

Welder Setup *for additional info see page 8 of the user manual



1. Place the welder in a desired workspace. ***Orion HDMI ports are not compatible with any other HDMI ports. Connecting them to other devices may damage the welder and/or the other devices.**



2. Attach the power cable to the back of the welder then into the wall.



3. Plug the foot pedal into any of the three "Foot Pedal/Microscope" ports on the welder. Use of foot pedal is optional.



4. Choose your preferred hand piece attachments and plug them into the front of the welder. ***a) Arc Welding. b) Tack Welding.**

Step 2

Microscope Setup *for additional info see page 9 of the user manual



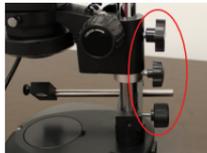
1. Place the microscope next to the welder. ***Orion HDMI ports are not compatible with any other HDMI ports. Connecting them to other devices may damage the welder and/or the other devices.**



2. Plug microscope cable into either of the 3 "Foot Pedal/Microscope" ports on the welder then into the port on the microscope light ring.



3. Attach the power cable into the back of the microscope then into the wall. Now turn on the microscope and adjust the brightness with the dial on the side.



4. Adjust the microscope head and stylus holder up and down by loosening their respective knobs. Once they are in a desired position, tighten their knobs.

Step 3

Stylus Setup *for additional info see page 14 of the user manual



1. With the slit on the Stylus plug facing up, lightly push the plug into the port and screw the connector on the plug clockwise 3 or 4 turns.



2. Now push in the end of the plug and screw the connector 3 or 4 turns again. Repeat this process until the plug is securely fastened.



3. a) Pull to remove the stylus hull then unscrew the collet to insert the electrode. b) The electrode should stick out between 0.6 and 0.7 in. c) Tighten the collet and slide the stylus hull back on.



4. Place the stylus in the stylus holder then adjust the microscope head up or down with the adjustment knob until the stylus is in focus. ***Place a finger under to electrode to help with focusing.**

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Step 4

Gas Setup *for additional info see page 12 of the user manual



1. Screw the regulator onto the Argon Gas tank. Ensure the connection is tight and there are no leaks.



2. Attach the thicker end of tubing to the regulator, then the thinner end to the back of the welder.



Regulator Knob

3. First, unscrew the regulator knob, then turn the gas tank on. (make sure there is gas tank pressure.)



Tank Pressure



Pressure to Welder

4. Slowly turn the regulator knob clockwise until the pressure to welder is at 10 cuft/hr (do not exceed 10 psi).

Step 5

Touch Screen *for additional info see page 15 of the user manual

Settings Tab, Energy Bar, Trigger Option, Weld Time Bar, Gas Indicator, Microscope Indicator, Foot Pedal Indicator, Arc Tab, Tack Tab, Load, Save, Settings, Arc, Tack, orion 250s, Current Setting: Unsaved..., Metal: Generic, Spot Width: 2.34mm, Spot Depth: 0.78mm, Total Energy: 25.0 Ws, Trigger Type: Auto Trigger, Foot Pedal, Agitation: None, Sloped, Sustained, Agitation Option, Weld Time/Duration: 15 ms, Undo, Sleep, Pause and Play

Step 6

First Welds *for additional info see www.OrionWelders.com for instructional videos



1. Use the provided stylus to select 25Ws energy, max time on the weld time bar, no agitation, trigger on touch, then hit play.



2. Lightly touch the electrode in the 25Ws box on the provided weld plate. Maintain contact & keep hands steady by resting them on the table.



3. Use the provided stylus to select the tack tab then choose 60Ws energy, max time on the weld time bar, trigger with Foot Pedal then hit play.



4. Plug the Alligator clips into the Tack ports then line up the work pieces and step on the foot pedal.



*For immediate access to videos, tutorials, and other Orion related material; scan this QR code with any smart phone or go to www.OrionWelders.com.

