

# Orion 200i

## 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.



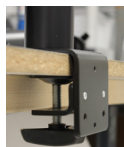
3. Plug the foot pedal cable into the Trigger Pedal port located on the back of the welder. Use of foot pedal is optional.



4. Choose your preferred hand piece attachments and plug them into the + terminals on the front of the welder.

### Step 2

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



1. Attach the microscope mount to the work bench and insert the extender arm, then insert the microscope arm. \*See other mounting options on included mounting document.



2. Screw the LCD touch screen to the top of the microscope arm. Attach the Stylus holder below the LCD Screen (There are 3 holes to choose from, we recommend the bottom 2).



3. Attach the LCD cable into the back of the Welder then into the back of the LCD Screen. Now turn on the welder and view the 9" touch screen interface.



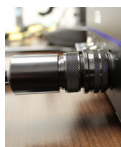
4. Plug the microscope cable into the "Microscope" port located on the back of the welder. \*See HDMI port warning in step one.

### Step 3

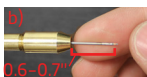
Stylus Setup \*for additional info see page 14 of the user manual



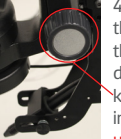
1. With the slit on the Stylus plug facing up, lightly push the plug into the port and screw the connector on the plug clockwise 3 or 4 turns.



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. Tighten the stylus into the stylus holder & 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

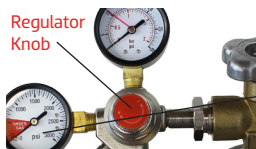
Gas Setup \*for additional info see page 12 of the user manual



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

Save Arc Tab Tack Tab Advanced Tab Tutorials Settings

Load

Agitation Slope

Spot Size

Spot Depth

Energy Bar

Approximate Spot Size

Diameter 2.9 mm

Depth 1.3 mm

Zoom 1X

Times 3:24:13 PM, 7/2/2012

Trigger

Speed/Rate

Increase Energy

Decrease Energy

95 Ws

Ultra

40 ms

Sustained

Standard

Sleep

Energy

Range

Length

Agitation

Ignition

Play

Pause

## Step 6

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



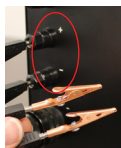
1. Use the provided stylus to select 25Ws energy, max time on the weld time bar, no agitation, trigger on touch, then hit play.



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](http://www.OrionWelders.com).



OrionWelders.com