

# Orion Welders – 100c


## General Settings for specific metals and applications


Specifications


### Remember:


1. When in doubt, start with your energy lower then work your way up.
2. The image to the right is an example of what a blunt electrode should look like:





General Settings – 26 AWG wire/chain/jump ring					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	9 ws	Med	Off	Butt weld with 90 degree electrode angle 
24k Gold	Sharp	8 ws	Med	Off	
Silver	Sharp	10 ws	Med	Off	
Platinum	Sharp	10 ws	Med	Off	
Stainless Steel	Sharp	8 ws	Med	On	
Palladium	Sharp	8 ws	Med	On	
Titanium	Sharp	10 ws	Med	Off	
Brass	Sharp	9 ws	Med	Off	


General Settings – Earring Post					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	11 ws	Med	Off	T joint with 45 degree electrode angle 
24k Gold	Sharp	10 ws	Med	Off	
Silver	Sharp	12 ws	Med	Off	
Platinum	Sharp	12 ws	Med	Off	
Stainless Steel	Sharp	8 ws	Med	On	
Palladium	Sharp	8 ws	Med	On	
Titanium	Sharp	12 ws	Med	Off	
Brass	Sharp	11 ws	Med	Off	


General Settings – 0.5mm thick Ring					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	12 ws	Med	Off	Butt weld with 90 degree electrode angle 
24k Gold	Sharp	11 ws	Med	Off	
Silver	Sharp	17 ws	Med	Off	
Platinum	Sharp	15 ws	Med	Off	
Stainless Steel	Sharp	14 ws	Med	On	
Palladium	Sharp	14 ws	Med	On	
Titanium	Sharp	15 ws	Med	Off	
Brass	Sharp	15 ws	Med	Off	

General Settings – 1mm thick Ring					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	22 ws	Med	Off	Butt weld with 90 degree electrode angle 
24k Gold	Sharp	20 ws	Med	Off	
Silver	Semi Blunt	45 ws	Med	Off	
Platinum	Sharp	24 ws	Med	Off	
Stainless Steel	Sharp	22 ws	Med	On	
Palladium	Sharp	20 ws	Med	On	
Titanium	Sharp	26 ws	Med	Off	
Brass	Sharp	26 ws	Med	Off	

General Settings – 2mm thick Ring					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	50 ws	Long	Off	Butt weld with 90 degree electrode angle 
24k Gold	Sharp	45 ws	Long	Off	
Silver	Blunt	80 ws	Long	Off	
Platinum	Sharp	60 ws	Long	Off	
Stainless Steel	Sharp	45 ws	Long	On	
Palladium	Sharp	40 ws	Long	On	
Titanium	Sharp	55 ws	Long	Off	
Brass	Sharp	55 ws	Long	Off	

General Settings – Add Material (30 AWG laser wire)					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	13 ws	Med	Off	Wire at 45 degree angle. Electrode touching work piece next to wire. 
24k Gold	Sharp	12 ws	Med	Off	
Silver	Sharp	14 ws	Med	Off	
Platinum	Sharp	14 ws	Med	Off	
Stainless Steel	Sharp	10 ws	Med	On	
Palladium	Sharp	10 ws	Med	On	
Titanium	Sharp	14 ws	Med	Off	
Brass	Sharp	13 ws	Med	Off	

General Settings – Add Material (24 AWG wire)					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	17 ws	Med	Off	Wire at 45 degree angle. Electrode touching work piece next to wire. 
24k Gold	Sharp	16 ws	Med	Off	
Silver	Sharp	18 ws	Med	Off	
Platinum	Sharp	18 ws	Med	Off	
Stainless Steel	Sharp	14 ws	Med	On	
Palladium	Sharp	14 ws	Med	On	
Titanium	Sharp	18 ws	Med	Off	
Brass	Sharp	17 ws	Med	Off	

General Settings – Retip Prong (26 AWG wire)					
Metal	Tip Shape	Energy	Length	Agitation	Notes
14k Gold	Sharp	9 ws	Med	Off	Butt weld with 90 degree electrode angle 
24k Gold	Sharp	8 ws	Med	Off	
Silver	Sharp	10 ws	Med	Off	
Platinum	Sharp	10 ws	Med	Off	
Stainless Steel	Sharp	8 ws	Med	On	
Palladium	Sharp	8 ws	Med	On	
Titanium	Sharp	10 ws	Med	Off	
Brass	Sharp	9 ws	Med	Off	

The above method will allow the user to attach the wire to the prong tip. If the user desires to add metal to the tip without the wire staying attached, use a 30 AWG wire and position the electrode and 30 AWG wire as seen in the picture to the right. This method will allow the user to add a little bit of metal at a time, covering the top of the prong with every weld.

Wire at 45 degree angle. Electrode touching work piece next to wire.



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