



PROCESSES



MIG (GMAW)
Welding



Flux Cored (FCAW)
Welding

5/3/1 INDUSTRIAL WARRANTY

MADE IN **USA**



Built with Hobart quality and durability, the Handler 140 is a wire welding package with industrial performance capable of operating on standard 115/120 volts, 20 amp home circuits.

The broad output range of 25–140 amps allows you to weld 24 gauge up to 1/4 in. steel. It is also capable of running the following wires: mild steel or stainless steel .023–.035 in. (0.6–0.9 mm), flux cored .030–.035 in.

(0.8–0.9 mm), and aluminum .030 in. (0.8 mm). Four output voltage settings with wire feed tracking make the unit easy to set and adjust for different materials and thicknesses. Supplied with a sample spool of wire and adaptable for using 4 or 8 in. (102 or 203 mm) spools.

Comes complete with:

- Rugged constant-voltage DC welder power source
- Durable built-in wire feeder
- Built-in gas solenoid valve
- Dual-gauge regulator and gas hose
- Comfortable 10 ft H10 MIG torch
- 10 ft. work lead with clamp
- Spare .030 in. (0.8 mm) contact tips
- Sample spool of .030 in. (0.8 mm) self-shielded flux cored welding wire
- Weld set-up and information chart
- Power cord with plug
- Owner's Manual with parts lists, installation, operation, maintenance and MIG welding guidelines

FEATURES

BENEFITS

Excellent arc performance	Stable arc with improved performance on thin gauge material.
Proven built-in wire feeder with quick-release tension lever	Provides positive feed with adjustable tension. Easy access for threading wire.
Replaceable, built-in contactor	Eases use and excellent safety feature which makes wire electrically "cold" when not welding.
Four output voltage settings with wire feed tracking	Provides a broader operating window for each wire with quick and easy adjustment for different materials and thicknesses.
Convenient polarity changeover with tip holder	Access makes it quick and easy to change polarity for solid or tubular wire plus includes convenient storage holes for spare tips.
Quick-change, dual-groove drive roll	Easy to change from one wire size to another .023/.025 in. (0.6 mm) or .030–.035 in. (0.8–0.9 mm).
Sloped control panel	Makes controls quickly visible and accessible.
Short circuit protection	Protects unit against current overload.
Self-resetting thermal overload	Protects power transformer to ensure reliability.
Self-resetting motor protection	Protects wire feed system from overload, no fuses to change or circuit breaker buttons to press.
Hobart's 5/3/1 Industrial Warranty	Five-year warranty on transformers, stabilizers and generators; three years on electronics (drive motors, rectifiers); and one year on guns (MIG and plasma torches).

SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

INDUSTRIAL



Rated Output	Current Range	Max. Open Circuit Voltage	Wire Feed Speed Range	Amps Input at Rated Load, 60 Hz			Dimensions	Net Weight	Shipping Weight
				115 V	KVA	KW			
90 A, 19 VDC at 20% Duty Cycle	25–140 A	28 V	40–700 IPM, 50–740 IPM at no load	20	2.9	2.5	H: 12-3/8 in. (315 mm) W: 10-5/8 in. (270 mm) D: 19-1/2 in. (495 mm)	57 lb. (26 kg)	66 lb. (30 kg)
63 A, 21 VDC at 20% Duty Cycle*				15*	2.20*	1.77*			

*CSA rating.

Certified by Canadian Standards Association to both Canadian and U.S. Standards.



Hobart Welders An Illinois Tool Works Company

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U.S. Distributor Sales Phone 920-735-4576 FAX 800-637-2315
Canadian Sales Phone 888-489-9353 FAX 519-421-0480
International Sales Phone 920-735-4509 FAX 920-735-4125

Web Site HobartWelders.com



HANDLER 140 WELDING GUIDE

Welding Guide for 115 Volt Wire Welding Package

Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting / Number on right of slash is Wire Feed Setting.

Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas 20-30 cfh Flow Rate	Diameter of Wire Being Used	Recommended Voltage and Wire Speed Settings for thickness of metal being welded.						
				24 ga. .024 in. (0.6 mm)	20 ga. .036 in. (0.8 mm)	18 ga. .048 in. (1.2 mm)	16 ga. .060 in. (1.6 mm)	11 ga. 1/8 inch (3.2 mm)	3/16 inch (4.8 mm)	1/4 inch (6.4 mm)
Steel	Flux Cored E71T-11 (DCEN)	No Shielding Gas Required Good for Windy or Outdoor Applications	.030" (0.8 mm)	---	---	1/30	2/30	3/40	4/45	---
			.035" (0.9 mm)	---	---	---	2/20	3/20	4/35	4/50*
Steel	Solid Wire ER70S-6 (DCEP)	C ₂₅ Gas Mixture 75% Argon / 25% CO ₂ Produces less Spatter Better Bead Appearance	.024" (0.6 mm)	1/25	2/30	3/40	3/50	4/70	---	---
			.030" (0.8 mm)	---	2/20	2/30	3/35	4/40	---	---
			.035" (0.9 mm)	---	---	3/25	3/30	4/40	---	---
Steel	Solid Wire ER70S-6 (DCEP)	100% CO ₂	.024" (0.6 mm)	---	2/30	3/30	3/40	4/40	---	---
			.030" (0.8 mm)	---	---	3/20	4/30	4/35	---	---
			.035" (0.9 mm)	---	---	---	4/25	4/30	---	---
Stainless Steel	Stainless Steel (DCEP)	Tri-Mix 90% He/7.5% Ar/2.5% CO ₂	.024" (0.6 mm)	---	---	2/30	3/40	4/50	---	---
			.030" (0.8 mm)	---	---	2/15	3/10	4/30	---	---
Aluminum	Aluminum** (DCEP)	100% Argon**	.030" (0.8 mm)	---	---	---	3/90**	4/90**	---	---

CHANGING POLARITY

DCEN
Electrode Negative
For Flux Cored Wire

DCEP
Electrode Positive
For Solid Wire

217618

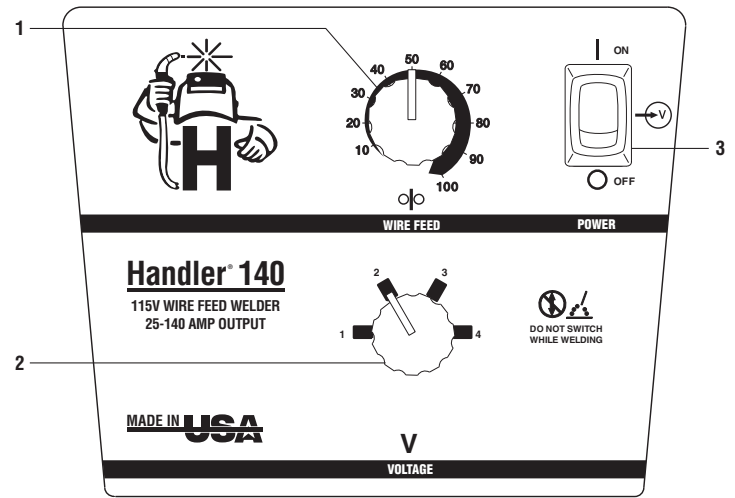
Match feedroll groove to diameter of wire being used. Set Tension Knob Setting to 3 at start. Adjust tension per instructions in the manual.

CAUTION! Do not change Voltage switch position while welding. See owners manual for more information.

Wire Speed listed is a starting value only. Wire Speed setting can be fine-tuned while welding. Wire Speed also depends on other variables such as stick out, travel speed, weld angle, cleanliness of metal, etc.

*Multiple passes required. **Aluminum wire is soft so feedability is not as good. Make sure that hub tension is not too tight and keep the torch straight as possible. A "push angle" for the torch is recommended.

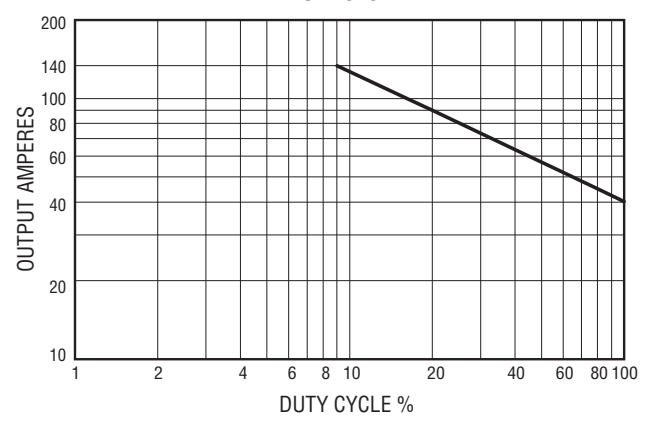
CONTROL PANEL



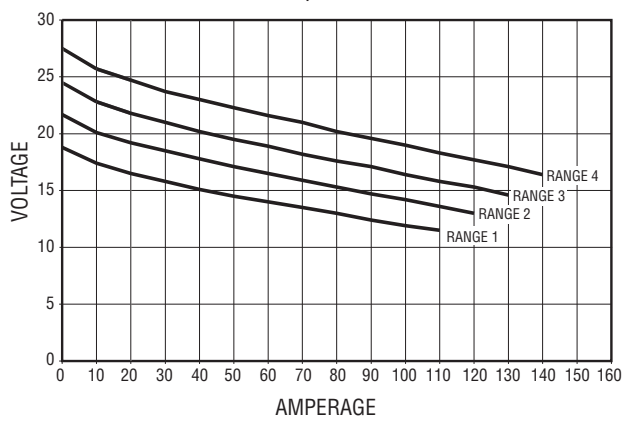
1. Wire Speed Control
2. Voltage Switch
3. Power Switch

PERFORMANCE DATA

DUTY CYCLE



VOLT/AMP CURVE



OPTIONS/ACCESSORIES



Small Running Gear/Cylinder Rack #194776
Durable construction. For gas cylinders no larger than 7 in. (178 mm) diameter, maximum weight 75 lb. (34 kg).

Purchase #500505 and receive the Handler 140 and #194776 cart packaged together.



Running Gear/Cylinder Rack #770187
Heavy-duty construction. For gas cylinders no larger than 7 in. (178 mm) diameter, maximum weight 100 lb. (45 kg).



Protective Cover #195186
Weather-resistant nylon resists stains and mildew, and protects the finish of your welder.



Spool Gun 3035-20 #300143

Comes Complete With:

- 20 ft. (6.1 m) cable and gas hose
- Threaded nozzle and contact tips
- Spool gun conversion kit consisting of control switch and gas diverter valve
- Enclosed wire spool compartment with internal spool hub tension adjustment for 4 in. (102 mm) rolls of wire
- For .030–.035 in. (0.8–0.9 mm) aluminum, steel and stainless steel
- Rated 150 amps, 60% duty cycle.



SGA 100 Spool Gun Control #043856

Required to connect spool gun to the Handler® 135, 140, 175, 180 or 187. Allows you to connect a spool gun to virtually any similar MIG welder—Hobart or other brands.

Includes 10 ft. (3 m) 115 VAC power cable and plug, 6 ft. (1.8 m) interconnecting cable, and 5 ft. (1.5 m) gas hose.

H10 Replacement MIG Torch #195957

For .030–.035 in. (0.8–0.9 mm) wire. Includes 10 ft. (3 m) cable.



Drive Rolls

Dual-Groove, V-Smooth #237338

For .023/.025 in. (0.6 mm) and .030–.035 in. (0.8–0.9 mm) wire.

Dual-Groove, V-Knurled #202926

For .030–.035 in. (0.8–0.9 mm) and .045 in. (1.2 mm) flux cored wire.



Contact Tips

(See chart on below)



MIG Nozzle

(See chart below)

Protects tip adapter and focuses gas coverage.



Gasless

Flux Cored Nozzle

(See chart below)

For use with self-shielding flux cored wires. Improves visibility, eases access in

tight corners, protects tip adapter/gas diffuser from spatter and from shorting to the work piece. Usable with H9, H10, M10, and M15 torches.



Tip Adapter

(See chart below)



Replacement Liners

(See chart below)

CONSUMABLES

Item	Hobart Package Part #*	Miller Package Part #**
Contact Tips		
.023/.025 in. (0.6 mm)	#770174 (5 per package)	#087 299 (10 per package)
.030 in. (0.8 mm)	#770177 (5 per package)	#000 067 (10 per package)
.035 in. (0.9 mm)	#770180 (5 per package)	#000 068 (10 per package)
MIG Nozzle (Standard)	#770404	#169 715
Gasless Flux Cored Nozzle	#770487	#226 190
Tip Adapter	#770402	#169 716
Replacement Liners		
.023/.025 in. (0.6 mm)	#196139	#194 010
.030/.035 in. (0.8/0.9 mm)	#196139	#194 011
.035/.045 in. (0.9/1.2 mm)	#196140	#194 012

*Available at farm and tool supply retailers.

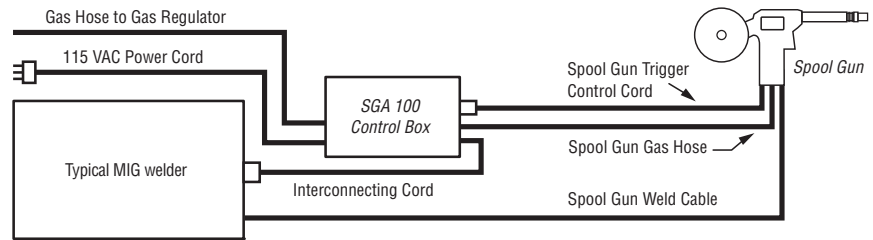
**Available at Hobart/Miller welding distributors.

TYPICAL INSTALLATION FOR SPOOL GUN TO WELDER REQUIRING AN SGA SPOOL GUN ADAPTER

For Handler® 140, combine Spool Gun 3035-20 with SGA 100 to weld 14 gauge to 1/8 in. aluminum.

To weld aluminum with comparable, competitive power sources, the spool gun may also be used with the SGA unit.

Note: Refer to SGA Owner's Manual for complete installation instructions.



ORDERING INFORMATION AND SYSTEM CHECKLIST

Equipment and Options	Stock No.	Description	Qty.	Price
Handler 140	#500500	115 VAC, 60 Hz with gas valve, regulator and hose		
UPC: #715959314183; Shipping Weight: 66 lb. (30 kg); Carton Dimensions: 24 x 11-1/2 x 18 in. (610 x 292 x 457 mm); Pallet Qty: 12; Pallet Dimensions: 48 x 36 x 39 in. (1219 x 914 x 991 mm)				
Handler 140 with small running gear/cylinder rack	#500505	115 VAC, 60 Hz with gas valve, regulator and hose Packaged with #194 776 cart		
UPC: #715959319973; Shipping Weight: 93 lb. (42.3 kg); Carton Dimensions: 31-1/2 x 16-1/2 x 15-1/2 in. (800 x 419 x 394 mm); Pallet Qty: 6; Pallet Dimensions: 34 x 34 x 48-1/2 in. (864 x 864 x 1232 mm)				
Accessories				
Small Running Gear/ Cylinder Rack	#194776			
Running Gear/Cylinder Rack	#770187			
Protective Cover	#195186			
Spool Gun 3035-20	#300143	Includes 20 ft. (6.1 m) cable		
SGA 100 Spool Gun Control	#043856			
H10 MIG Torch	#195957	10 ft. (3 m), .030-.035 in. (0.8-0.9 mm)		
Dual-Groove Drive Rolls	#237338	V-Smooth 0.023/.025 in. (0.6 mm) and .030-.035 in. (0.8-0.9 mm)		
	#202926	V-Knurled .030-.035 in. (0.8-0.9 mm) and .045 in. (1.2 mm)		
Contact Tips		See chart on page 3		
Nozzles		See chart on page 3		
Tip Adapter		See chart on page 3		
Replacement Liners		See chart on page 3		
Other				
Date:			Total Quoted Price:	

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W E L D E R S

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