



### PROCESSES



MIG (GMAW)  
Welding



Flux Cored (FCAW)  
Welding

## 5/3/1 INDUSTRIAL WARRANTY



The IronMan™ 210 is a powerful welding package that is versatile and easy to use. It is equipped with many outstanding features.

- Welds 22 gauge up to 3/8 in. thick steel.
- Excellent aluminum welding with optional Hobart Spool Gun 3035-20.
- Six-tap voltage control allows for a smooth, easy-to-control arc.
- Infinite wire feed speed control for precise adjustment of penetration and weld bead shape.
- Comes complete with gun and built-in running gear/cylinder rack.
- Handles wire spools up to 12 in. (30.5 cm) diameter.
- Built-in thermal overload protects the unit.
- Reversible drive rolls: two grooves for three wire sizes on one drive roll. Decreases spare parts and changeover time.
- Hinged door for easy access to wire drive system for spool and drive roll changes.

### FEATURES

### BENEFITS

<b>Sloped front panel</b>	Makes controls easy to see and access.
<b>Arc performance</b>	Excellent short arc performance with easy to control weld puddle.
<b>6-position voltage control</b>	Simplified and accurate adjustments. Maximizes amount of control. Allows for smooth arc with high operator appeal.
<b>Reversible drive rolls: two grooves for three wire sizes on one drive roll</b>	50% less stocking of drive rolls. Standard, one-piece drive roll decreases spare parts and changeover time, reducing overall costs.
<b>Hinged feeder panel</b>	For greater accessibility to wire feeder panel for spool and feed roll changes, increasing productivity and operator appeal.
<b>Infinite wire feed control</b>	Allows for precise adjustment of penetration and weld bead shape.
<b>Low amperage draw</b>	Amperage draw of 25 amps at rated load of 230 V input saves energy.
<b>Comes complete with factory installed features</b>	Ready to set up and weld: comes complete with wire feeder, running gear, cylinder rack, regulator/flow gauge, MIG gun, cable and clamp, extra tips.
<b>Hobart's 5/3/1 Industrial Warranty</b>	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	Open Circuit Voltage	Wire Feed Speed Range	Amperes Input at Rated Load				Dimensions	Net Weight
				200 V	230 V	KVA	KW		
150 A, 23 V DC at 40% duty cycle	30-210 amps	33 V	90-750 IPM	29	25	5.8	4.9	H: 31-1/4 in. (794 mm) W: 18-7/8 in. (479 mm) D: 36-1/2 in. (927 mm)	146 lb. (66 kg)

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



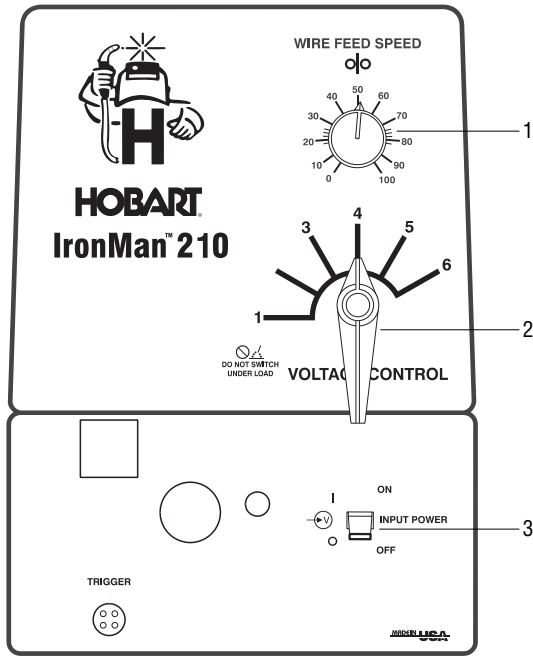
**Hobart Welders** An Illinois Tool Works Company

U.S. Distributor Sales Phone 920-735-4576 FAX 800-637-2315  
 Hobart Retail Sales Phone 800-332-3281 FAX 937-332-4161  
 Canadian Sales Phone 888-489-9353 FAX 519-421-0480  
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Web Site [HobartWelders.com](http://HobartWelders.com)



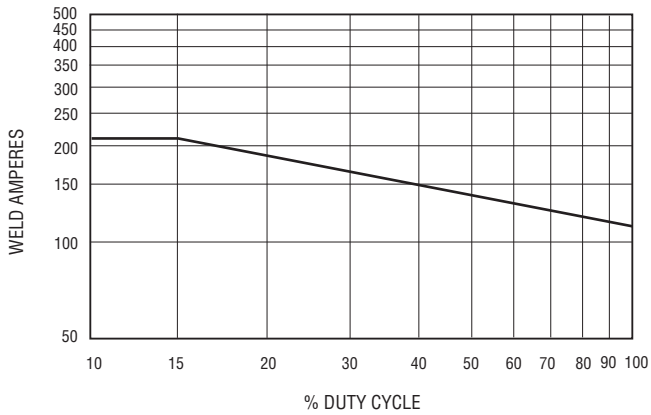
## CONTROL PANEL



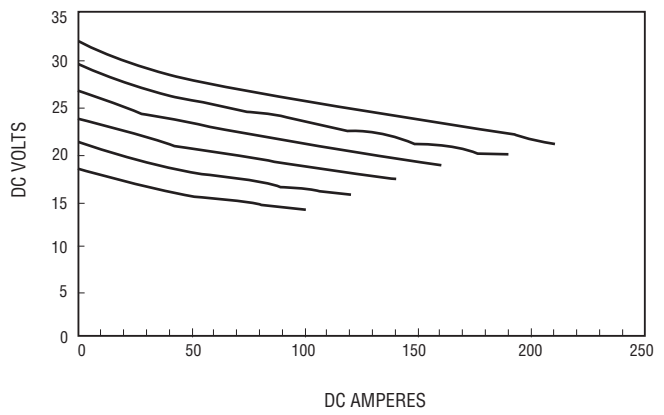
1. Wire Speed Control
2. Voltage Control
3. Power Switch

## PERFORMANCE DATA

**DUTY CYCLE CHART**



**VOLT/AMP CURVES**



## ACCESSORIES



### Reversible V-Groove Drive Rolls for Mild Steel Wire

#202925

.023 and .030/.035 in. (0.6 mm and 0.8/0.9 mm)

#407230-004

.023 and .045 in. (0.6–1.1 mm)

### Reversible V-Knurled Drive Rolls

#193330

.030 and .035 in. (0.8 and 0.9 mm)

#193331

.039–.045 in. and .052–1/16 in.  
(1.0–1.1 and 1.3–1.6 mm)

## MIG GUN AND ACCESSORIES

### M-10 Replacement Gun #195605

10 ft. (3 m) cable. Gun is designed to run .030–.035 in. (0.8–0.9 mm) 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)

## SPOOL GUN AND ACCESSORIES



### Hobart Spool Gun 3035-20 #300143

Welds 14 gauge up to 1/4 in. (6.3 mm) thick aluminum with the IronMan 210.

Comes Complete With:

- 20 ft. (6.1 m) cable and gas hose
- 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



### Contact Tips (5 per package)

#199730 For .023 in. (0.6 mm) wire

#186419 For .030 in. (0.8 mm) wire

#186406 For .035 in. (0.9 mm) wire



### Nozzle #186405



### Drive Roll (1)

#199731 For .023 in.

(0.6 mm) wire.

#186413 For .030/.035 in.

(0.8/0.9 mm) wire.



### Push Roll (1)

#199732 For .023 in.

(0.6 mm) wire.

#186414 For .030/.035 in.

(0.8/0.9 mm) wire.

## CONSUMABLES

Item	Hobart Package Part #*	Miller Package Part #**
<b>Contact Tips</b>		
.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)
.045 in. (1.2 mm)	#770183 (5 per package)	#000 069 (10 per package)
<b>MIG Nozzle (Standard)</b>	#770404	#169 715
<b>Gasless Flux Cored Nozzle</b>	#770487	#226 190
<b>Tip Adapter</b>	#770402	#169 716
<b>Replacement Liners</b>		
.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.

**The IronMan™ 210 comes complete with:**

- Constant-voltage DC power source
- Built-in wire feeder
- 10 ft. M-10 MIG welding gun
- Regulator/flow gauge
- 5 ft. gas hose
- Sample spool of solid welding wire
- 7 ft. primary input cable with plug
- Dual groove drive roll — .023 and .030/.035 in.
- 10 ft. work cable with clamp
- Extra contact tips
- Built-in running gear/cylinder rack
- Weld, set-up and parts information chart

**ORDERING INFORMATION AND SYSTEM CHECKLIST**

Power Source	Stock No.	Description	Qty.	Price
<b>IronMan™ 210</b>	<b>#500304</b>	200(208)/230 VAC, 60 Hz		
UPC: #715959245302; Shipping Weight: 185 lb. (84 kg); Dimensions: 41-1/2 x 21-1/4 x 36 in.; Pallet Qty: 1				
<b>Accessories</b>				
M-10 Replacement Gun	<b>#195605</b>	10 ft. (3 m). Comes standard with unit		
Hobart Spool Gun 3035-20	<b>#300143</b>			
<b>M-10 Consumables (Order from Hobart Service Parts)</b>				
Contact Tips		See chart on pg 3		
Contact Tip Adapter		See chart on pg 3		
Replacement Liners		See chart on pg 3		
Nozzles		See chart on pg 3		
Drive Rolls		See chart on pg 3		
<b>Spool Gun 3035-20 Consumables (Order from Hobart Service Parts)</b>				
Contact Tips	<b>#199730</b>	.023 in. (0.6 mm)		
	<b>#186419</b>	.030 in. (0.8 mm)		
	<b>#186406</b>	.035 in. (0.9 mm)		
Nozzle	<b>#186405</b>			
Drive Rolls	<b>#199731</b>	.023 in. (0.6 mm)		
	<b>#186413</b>	.030-.035 in. (0.8-0.9 mm)		
Push Rolls	<b>#199732</b>	.023 in. (0.6 mm)		
	<b>#186413</b>	.030-.035 in. (0.8-0.9 mm)		
<b>Date:</b>			<b>Total Quoted Price:</b>	



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