



PROCESSES



MIG (GMAW)
Welding



Flux Cored (FCAW)
Welding

5/3/1
INDUSTRIAL
WARRANTY

New!



The IronMan™ 230 is a total redesign of the full-size MIG platform, outperforming the competition on arc quality, voltage control, and value. It delivers 30 to 250 amps of pure power in a heavy duty cabinet. The arc of the new IronMan is optimized to deliver a flawless weld, making spatter

and post-weld cleanup almost non-existent. Whether you are a professional or just want to weld like one, the IronMan 230 is unmatched in its class. It is equipped with many outstanding features.

- Welds 24 gauge up to 1/2 in. (13 mm) thick steel.
- Excellent aluminum welding with optional Hobart Direct Connect Spool Gun DP 3545-20.
- Twelve-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 200 amp gun and built-in running gear/cylinder rack.
- Patent pending spool hub that makes changing from 2, 10, 33 and 45 lb. wire spools a snap with a tool-less brake tension knob and automatic wire alignment.
- Built-in self-resetting thermal overload system protects the unit in the toughest applications.
- Reversible drive rolls: two grooves for two wire sizes on one drive roll. Decreases spare parts and changeover time.
- Dual-gear wire drive system with aluminum housing delivers 0 to 700 IPM wire feed speed.
- Hinged door for easy access to wire drive system for spool and drive roll changes.
- Convenient storage area is located inside the cabinet for spare tips, nozzles and drive rolls.

FEATURES

BENEFITS

Sloped front panel	Makes controls easy to see and access.
Arc performance	Excellent short arc performance with easy to control weld puddle.
Increased amperage output	Increases the ability of the machine to weld thicker material.
Increased duty cycle: rated at 175 amps @ 60% duty cycle, and wide amperage range	Higher machine output duty cycle, increasing productivity with longer welding periods. Versatile for MIG and Flux Cored, gas or gasless welding applications. Can weld at higher amps at lower duty cycle.
12-position voltage control	Simplified and accurate adjustments. Maximizes amount of control. Allows for smooth arc with high operator appeal.
Spool gun ready	Easy setup for welding aluminum with no additional interface
Optional Hobart Spool Gun DP 3545-20	Excellent for pushing soft aluminum wires.
Reversible drive rolls: two grooves for two wire sizes on one drive roll	50% less stocking of drive rolls. Standard, one-piece drive roll decreases spare parts and changeover time, reducing overall costs.
Hinged feeder panel	For greater accessibility to wire feeder panel for spool and feed roll changes, increasing productivity and operator appeal.
Infinite wire feed control	Allows for precise adjustment of penetration and weld bead shape.
Dual side-mounted cable hangers	Convenient storage for cables when not in use.
Fan-On-Demand	Cooling system operates only when needed reducing power consumption and contaminants drawn into the machine.
Comes complete with factory installed features	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.
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).



Hobart Welders An Illinois Tool Works Company

Hobart Retail Sales	Phone 800-332-3281	FAX 937-332-4161
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



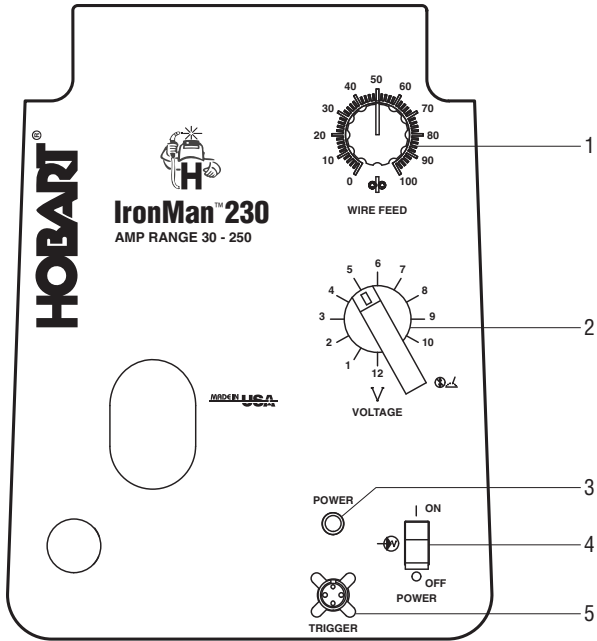
SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

INDUSTRIAL **DC** **CV** **1** Phase

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		
175 A, 25.5 V DC at 60% duty cycle 250 A, 23 V DC at 30% duty cycle	30–250 amps	38 V	0–700 IPM	37	32.5	7.4	6.3	H: 31-1/2 in. (800 mm) W: 18-7/8 in. (479 mm) D: 36-1/2 in. (927 mm)	185 lb. (84 kg)

 Certified by Canadian Standards Association to both Canadian and U.S. Standards.
Note: Operating Temperature Range: -4° to +104°F (-20° to +40°C)

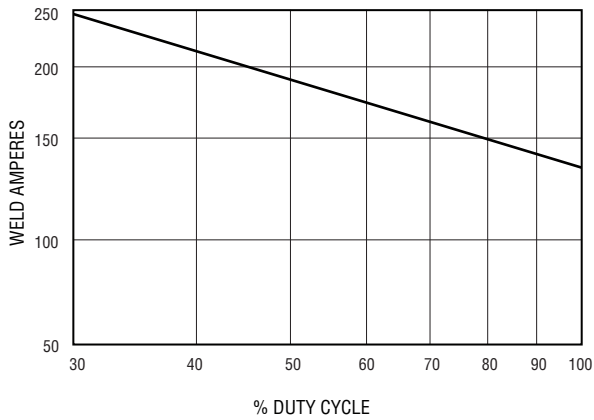
CONTROL PANEL



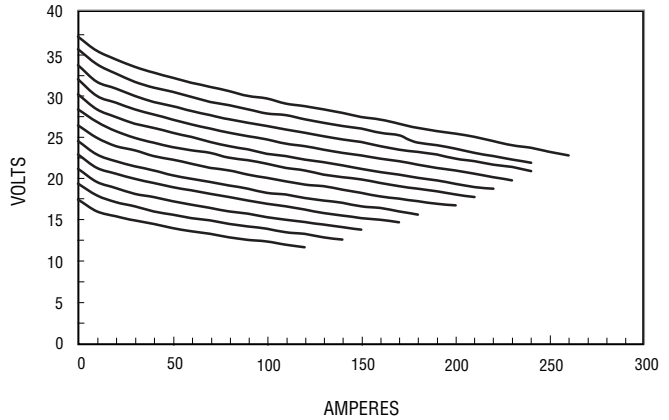
1. Wire Speed Control
2. Voltage Control
3. Power Light
4. Power Switch
5. Gun Trigger Receptacle

PERFORMANCE DATA

DUTY CYCLE CHART



VOLT/AMP CURVES



ACCESSORIES



Protective Cover #195190

Form-fitted, vinyl-laminated, polyester fabric resists stains and mildew and protects the finish of your welder.



Reversible V-Groove Drive Rolls for Mild Steel Wire

#235286

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

#235287

.023 and .045 in. (0.6–1.1 mm)

Reversible V-Knurled Drive Rolls for Flux-Cored Wire

#132958

.035 in. (0.9 mm)

#132957

.045 in. (1.2 mm)

MIG GUN AND ACCESSORIES

H200L4-15 Replacement Gun

#239173 15 ft. (4.6 m)

Gun designed to run .030–.035 in. (0.8–0.9 mm) wire.

Gun rated at 200 amps, 100% duty cycle using CO₂ gas, and 60% duty cycle using mixed gas.

Contact Tips (See chart on below)

Nozzle (See chart below)

Adapter (See chart below)



Replacement Liners (See chart below)

SPOOL GUN AND ACCESSORIES



Hobart Spool Gun DP 3545-20 #300349

Spool gun with 4 in. spool, rated at 200 A, 60% duty cycle. Includes 20 ft. cable assembly. When combined with IronMan 230, this spool gun welds with .030–.047 in. wire on 18 ga. – 1/2 in. thick aluminum.



Contact Tips (5 per package)

#199387 For .030 in. (0.8 mm) wire.

#199388 For .035 in. (0.9 mm) wire.

#199389 For .047 in. (1.2 mm) wire.



Nozzle #199386



Drive Roll (1)

#186413 For .030/.035 in. (0.8/0.9 mm) wire.

#199396 For .047 in. (1.2 mm) wire.



Push Roll (1)

#186414 For .030/.035 in. (0.8/0.9 mm) wire.

#199397 For .047 in. (1.2 mm) wire.

CONSUMABLES

Item	Hobart Package Part #*
Contact Tips	
.023/.025 in. (0.6 mm)	#770174 (5 per package)
.030 in. (0.8 mm)	#770177 (5 per package)
.035 in. (0.9 mm)	#770180 (5 per package)
.045 in. (1.2 mm)	#770183 (5 per package)
Flush Nozzle 5/8 in. (16 mm) orifice	#770405
Tip Adapter	#770403
Replacement Liners	
.023/.025 in. (0.6 mm)	#196139
.030/.035 in. (0.8/0.9 mm)	#196139
.035/.045 in. (0.9/1.2 mm)	#196140

*Available at farm and tool supply retailers.

The IronMan™ 230 comes complete with:

- Constant-voltage DC power source
- Built-in wire feeder
- 15 ft., 200 amp MIG welding gun
- Regulator/flow gauge
- 5 ft. gas hose
- 10 ft. primary input cable with plug
- Dual groove drive roll – .030/.035 in.
- 10 ft. work cable with clamp
- Dual side-mounted cable hangers
- Extra contact tips
- Built-in running gear/cylinder rack
- Weld, set-up and parts information chart

ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source and Options	Stock No.	Description	Qty.	Price
IronMan 230	#500536	200(208)/230 VAC, 60 Hz		
UPC: #715959375603; Shipping Weight: 224 lb. (102 kg); Dimensions: 41-1/2 x 21-1/4 x 36 in.; Pallet Qty: 1				
Accessories				
Protective Cover	#195190			
H200L4-15 Replacement Gun	#239173			
Hobart Spool Gun DP 3545-20	#300349			
Replacement Parts				
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		
Reversible V-Groove Drive Rolls		See chart on pg 3		
Reversible V-Knurled Drive Roll		See chart on pg 3		
Date:			Total Quoted Price:	



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