



PROCESSES



MIG (GMAW)
Welding



Flux Cored (FCAW)
Welding

5/3/1 INDUSTRIAL WARRANTY



The IronMan™ 250 is a powerful welding package that is versatile and easy to use. It is equipped with many outstanding features.

- Welds 22 gauge up to 1/2 in. (13 mm) thick steel.
- Excellent aluminum welding with optional Hobart Spool Gun 3545-20.
- Seven-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 250 amp gun and built-in running gear/cylinder rack.
- Handles wire spools up to 45 lb. — wire feed speed adjusts from 90 to 750 IPM.
- 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

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 machine output for higher productivity.
Increased duty cycle: rated at 200 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.
7-position voltage control	Simplified and accurate adjustments. Maximizes amount of control. Allows for smooth arc with high operator appeal.
Optional Hobart Spool Gun 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.
Low amperage draw	Amperage draw of 35 amps at rated load of 230 V input saves energy.
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).

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 A, 24 V DC at 60% duty cycle	30–250 amps	35 V	90–750 IPM	200 V 230 V KVA KW 40 35 8 6.8	H: 31-1/4 in. (794 mm) W: 18-7/8 in. (479 mm) D: 36-1/2 in. (927 mm)	195 lb. (88 kg)

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



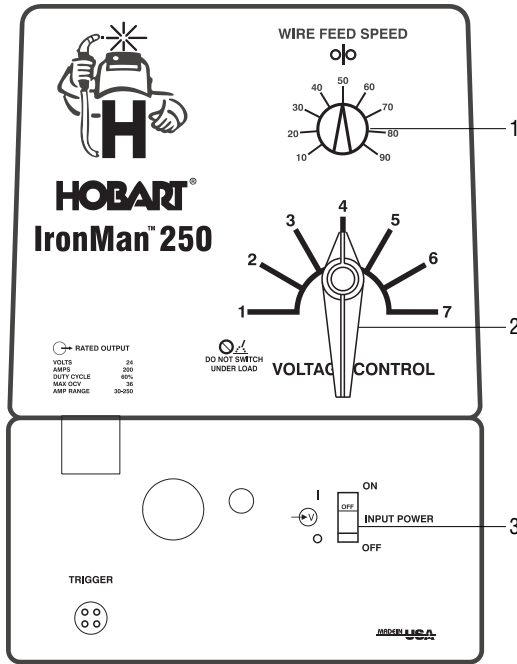
Hobart Welders An Illinois Tool Works Company

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
 International Sales Phone 920-735-4509 FAX 920-735-4125

Web Site HobartWelders.com



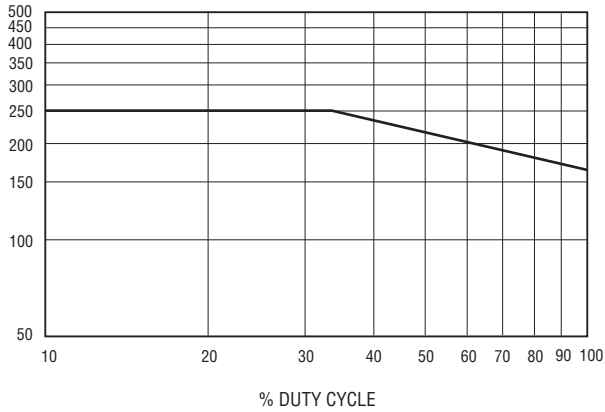
CONTROL PANEL



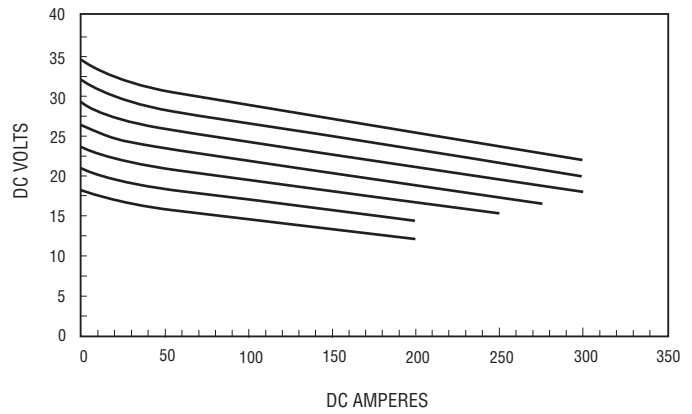
1. Wire Speed Control
2. Voltage Control
3. Power Switch

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-25 Replacement Gun

#169596 12 ft. (3.7 m)

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

#169599 15 ft. (4.6 m)

Gun designed to run .035–.045 in. (0.9–1.2 mm) wire.

Both guns are rated at 250 amps, 100% duty cycle using CO₂ gas, and 250 amps, 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 3545-20 #300144

1 lb. spool gun rated at 200 A, 60% duty cycle. Includes 20 ft. cable assembly. When combined with Ironman 250, this spool gun welds with .030–.047 in. wire on 14 ga–3/8 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 #*	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)
.045 in. (1.2 mm)	#770183 (5 per package)	#000 069 (10 per package)
Flush Nozzle 5/8 in. (16 mm) orifice	#196138 (2 per package)	#169 726
Tip Adapter	#770403	#169 728
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.

The IronMan™ 250 comes complete with:

- Constant-voltage DC power source
- Built-in wire feeder
- 12 ft., 250 amp MIG welding gun
- Regulator/flow gauge
- 5 ft. gas hose
- Sample spool of solid welding wire
- 10 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 and Options	Stock No.	Description	Qty.	Price
IronMan 250	#500408	200(208)/230 VAC, 60 Hz		
UPC: #715959221498; Shipping Weight: 230 lb. (104 kg); Dimensions: 41-1/2 x 21-1/4 x 36 in.; Pallet Qty: 1				
Accessories				
M-25 Replacement Gun	#169596	12 ft. (3.7 m)		
	#169599	15 ft. (4.6 m)		
Hobart Spool Gun 3545-20	#300144			
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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