



PROCESSES



Stick (SMAW) Welding

5/3/1 WARRANTY



The STICKMATE® 205 AC Stick welding power sources have the control to get the exact heat you need — always. Also, these machines allow weld time to increase when amperage decreases.

They have the range and muscle to handle many Stick welding, hard surfacing, and cutting jobs. At the same time, they have the precision for low hydrogen and special alloy electrodes. Recommended for a variety of electrodes 1/16 – 5/32 in diameter.

The patented Accu-Set™ design provides accurate heat control with infinite amperage control. Additionally, the STICKMATE allows a higher duty cycle when amperage decreases, unlike some competitive products in the market.

Applications:

- Farms
- Ranches
- Ornamental iron
- Garages
- Hobbyists
- Maintenance
- Individuals

Comes Complete with:

- 12 ft (3.7 m) electrode cable with heavy-duty holder
- 10 ft (3 m) work cable with clamp
- Primary input cord with plug

FEATURES

BENEFITS

Accu-Set™ amperage indicator	Accu-Set is an exclusive design for accurately controlling amperage or heat output.
Infinite current control	The precise control of the STICKMATE allows the operator to adjust output by as little as 1-amp increments. Adjustments can be made while welding to achieve desired heat level, unlike the step control design on competitive products.
Increasing duty cycle	Duty cycle increases as amperage setting decreases. 100% duty cycle at 90 A, 25 V.
Max. 80 Open-circuit Voltage	Assists with arc starting and arc stability
Fully varnished magnetic coils	Varnish protects and lengthens the life of the coils inside for increased reliability.
Forced-draft cooling fan	The cooling fan runs continuously and helps to extend the life of the power source.
Hobart's 5/3/1 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.)

LIGHT INDUSTRIAL



Rated Welding Output	Welding Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output 230 V, 50 or 60 Hz	Dimensions	Net Weight	Shipping Weight
165 amps at 25 VAC, 20% duty cycle, 50/60 Hz	30–205	80	47.5	H: 18-3/4 in (476 mm) W: 12-3/4 in (323 mm) D: 17-1/2 in (445 mm)	83 lb (38 kg)	89 lb (40 kg)

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



Hobart Welders An Illinois Tool Works Company

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 Canadian Sales Phone 888-489-9353 FAX 519-421-0480
 International Sales Phone 920-735-4509 FAX 920-735-4125

Web Site www.HobartWelders.com



ELECTRODE CHARTS

ELECTRODE SELECTION CHART

ELECTRODE	AC	DC*	POSITION	PENETRATION	USAGE
6010	NO	EP	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	YES	EP	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6013	YES	EP, EN	ALL	LOW	GENERAL, EASY
7014	YES	EP, EN	ALL	MED	SMOOTH, EASY, FAST
7018	YES	EP	ALL	LOW	LOW HYDROGEN, STRONG
7018AC	YES	EP	ALL	LOW	LOW HYDROGEN, STRONG
7024	YES	EP, EN	FLAT HORIZ FILLET	LOW	SMOOTH, EASY, FASTER
Ni-CI	YES	EP	ALL	LOW	CAST IRON
308L	YES	EP	ALL	LOW	STAINLESS

*EP = ELECTRODE POSITIVE (REVERSE POLARITY)
*EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

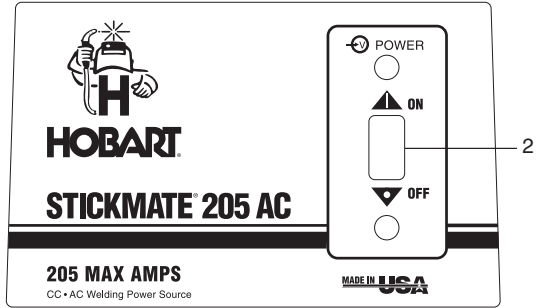
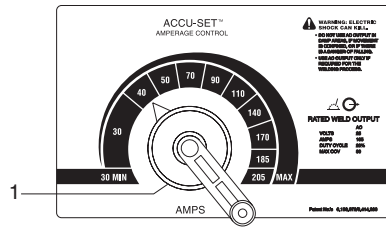
WELDING RANGE CHART

ELECTRODE AWS CLASS	DIAMETERS			
	1/16	3/32	1/8	5/32
6010	X	40-85	75-125	110-165
6011	20-35	40-85	75-125	110-165
6013	20-45	40-90	80-130	105-180
7014	35-60	80-125	110-165	150-210
7018	30-50	65-100	110-165	150-220
7018 AC*	30-50	65-100	110-165	150-220
7024	X	100-145	140-190	180-250
Ni-CI	X	50-70	65-85	100-140
308L	X	40-80	75-115	105-160

*7018 AC recommended for use with AC welders.

CONTROL PANEL

1. Amperage Adjustment Control
2. Power Switch



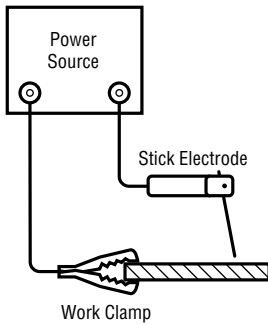
ACCESSORIES



Running Gear #043 927
Mounts easily to unit and provides convenient portability, with various mounting options to suit user preference. Includes two wheels, two feet and a handle.

BASIC EQUIPMENT SETUP

Stick (SMAW)



ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source and Options	Stock No.	Description	Qty.	Price
STICKMATE 205 AC	#500 502	230 V, 50/60 Hz, without running gear		
UPC: #715959314206; Shipping Weight: 89 lb (40 kg); Carton Dimensions: 22 x 13.25 x 27.25 in; Pallet Qty: 12; Pallet Dimensions: 40.5 x 44.5 x 43 in				
Miscellaneous				
Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and a handle.		
Stick Electrodes		See charts above		
Helmet				
Gloves				
Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle (6-50R)	#770 022 #039 778	Weldit brand available at farm and tool supply retailers Available at Hobart/Miller welding distributors		

Date:

Total Quoted Price:

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

HOBART

WELDERS

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