

IronMan™ 230

Complete Single-Phase MIG Welding Package



243749
May 2020

230 V

Spool Gun Ready



500536

Quick Specs

Welding Amp Range

30–250 A

Rated Output

175 A at 25.5 VDC, 60% duty cycle

Mild Steel Thickness Range

24 ga.–1/2 in.



5/3/1
INDUSTRIAL
WARRANTY

Outperforms the competition on arc quality, voltage control and value.

Whether you're a professional or just want to weld like one, the IronMan 230 is unmatched in its class. It delivers 30 to 250 amps of pure power with an arc optimized to deliver a flawless weld, making spatter and post-weld cleanup almost nonexistent. Weld as thin as 24 gauge up to 1/2 inch (13 mm) mild steel.

The dual-gear wire drive system with aluminum housing delivers 0 to 700 ipm wire feed speed.

Reversible drive roll (two grooves for two wire sizes on one drive roll) decreases spare parts and changeover time.

Easy to set and adjust for different materials and thicknesses — features twelve output voltage settings for finer control, less spatter and cleaner welds.

Applications

- Maintenance/repair
- Auto body
- Manufacturing
- Construction
- Farm/ranch
- Metal art

Includes

- 15 ft. (4.6 m) M-25 MIG gun
- 10 ft. (3 m) work cable with clamp
- Power cord with plug
- Regulator/flow gauge with 5 ft. (1.5 m) gas hose
- Dual-groove .030/.035 in. drive roll
- .030 and .035 in. contact tips
- Dual side-mounted cable hangers
- Built-in running gear/cylinder rack

Features	Benefits
Twelve voltage settings with infinite wire feed speed	Offers easier fine control of the output parameters for improved arc performance with less spatter for a better bead appearance and less clean up.
Spool gun ready	Spool guns enhance feedability and reduce “bird-nesting” associated with soft aluminum wires. No additional control box or adapter is required to connect the DP 3545-20 spool gun.
Reversible drive roll (two grooves for two wire sizes on one drive roll)	50 percent less stocking of drive rolls. Standard, one-piece drive roll decreases spare parts and changeover time, reducing overall costs.
Spool hub assembly accommodates 2, 10, 33 and 45-pound spools	Changing wire spools is a snap with the toolless brake tension knob and automatic wire alignment.
Hinged door panel	Provides easy access for spool and drive roll changes, increasing productivity and operator appeal.
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.
Hobart 5/3/1 industrial warranty	Five-year warranty on transformers, stabilizers and main rectifiers; three years on generators, PC boards and drive systems; and one year on guns (MIG, plasma and TIG torches).



Hobart Welding Products

An ITW Welding Company
Sales: 800-626-9420
Service: 800-332-3281

HobartWelders.com



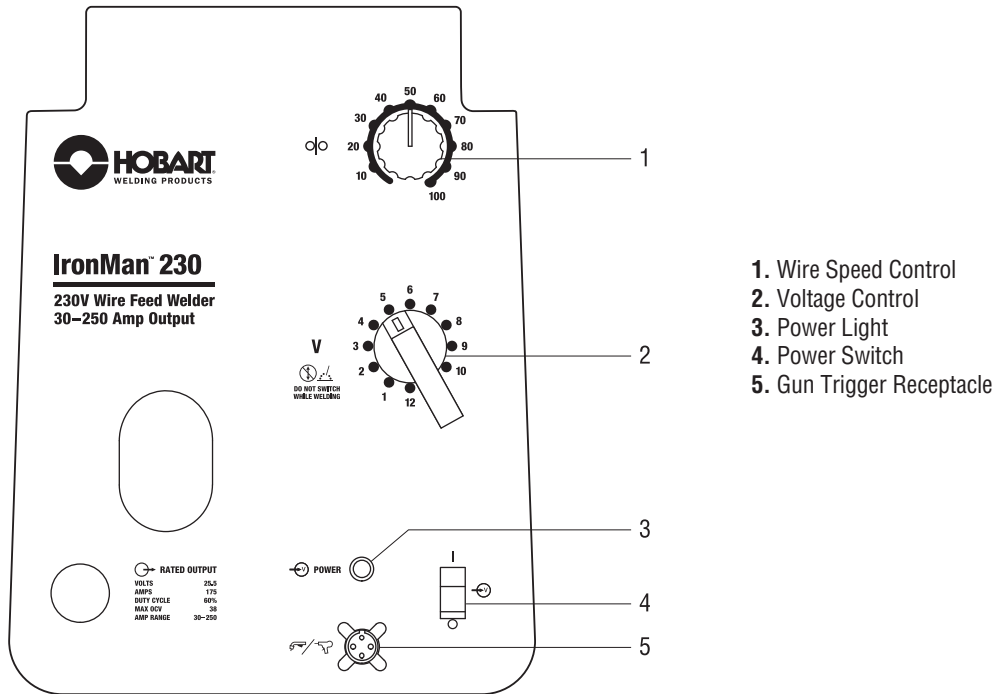
Specifications (Subject to change without notice.)



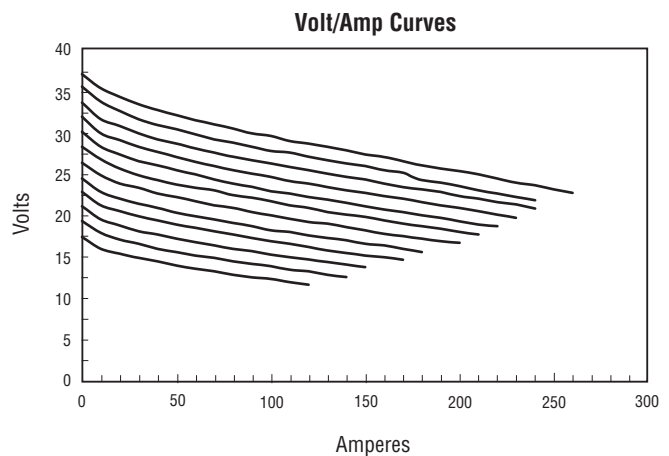
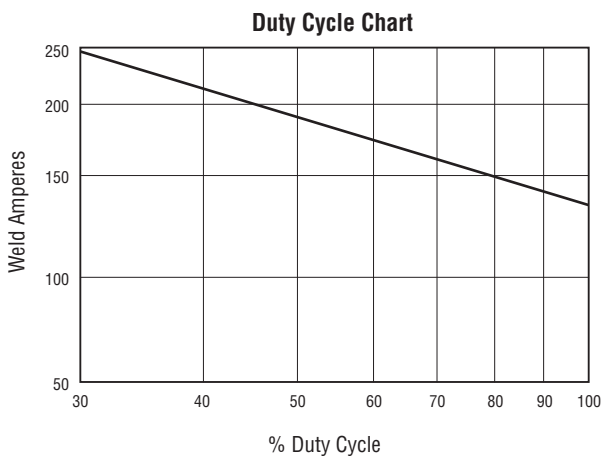
Welding Amp Range	Rated Output	Amperes Input at Rated Load				Open Circuit Voltage	Wire Feed Speed Range	Dimensions	Net Weight
		200 V	230 V	KVA	KW				
30-250 A	175 A at 25.5 VDC, 60% duty cycle	37	32.5	7.4	6.3	38 VDC	0-700 ipm (0-17.8 m/min.)	H: 31.5 in. (800 mm) W: 18.875 in. (479 mm) D: 36.5 in. (927 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



Performance Data



Accessories



Protective Cover 770589
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

M-25 Replacement MIG Gun 169598
Comes in 15 ft. (4.6 m) length with liner for .030–.035 in. (0.8–0.9 mm) wire. Gun rated at 250 amps at 100 percent duty cycle using CO₂ gas, and 60 percent duty cycle using mixed gas.

Contact Tips (See chart on below)

Nozzles (See chart below)

Adapter (See chart below)



Replacement Liners (See chart below)

Spool Gun and Accessories



DP 3545-20 Spool Gun 300349
Spool gun with 4-inch spool and 20-foot cable assembly. Rated at 200 amps at 60 percent duty cycle. When combined with IronMan 230, this spool gun welds with .030–.047 inch wire on 18-gauge to 1/2-inch 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	
1/2 in. (12.7 mm) orifice flush	770544
5/8 in. (16 mm) orifice flush	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

Typical Installation for Optional DP 3545-20 Spool Gun to IronMan™ 230

It's quick and easy to install the DP 3545-20 spool gun on the IronMan 230. Just plug the power pin of the spool gun into the feedhead, attach the trigger lead and flip the switch on the inside panel for spool gun operation. Install the correct wire and gas for the job and it's ready to go.

