

# HOBART®

HOBART BROTHERS CO.  
TROY, OHIO USA

**5/3/1**  
INDUSTRIAL  
WARRANTY

# IronMan™ 230



243749  
March 2017

## Complete Single-Phase MIG Welding Package



**230 Volt**

**Spool Gun Ready!**

**500536**

**Includes:**

- 15 ft., 250-amp MIG welding gun
- Regulator/flow gauge
- 5 ft. gas hose
- Primary input cable with plug
- Dual-groove drive roll — .030/.035 in.
- 10 ft. work cable with clamp
- Dual side-mounted cable hangers
- .030 and .035 in. contact tips
- Built-in running gear/cylinder rack
- Weld, set-up and parts information chart

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 IronMan is optimized to deliver a flawless weld, making spatter and post-weld cleanup almost nonexistent. Whether you're 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 direct-connect Hobart DP 3545-20 spool gun.
- 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.
- Spool hub that makes changing from 2, 10, 33 and 45 lb. wire spools a snap with a toolless 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
<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>175 amps @ 60% duty cycle, and wide amperage range</b>	High 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.
<b>12-position voltage control</b>	Simplified and accurate adjustments. Maximizes amount of control. Allows for smooth arc with high operator appeal.
<b>Spool gun ready</b>	Easy setup for welding aluminum with no additional interface
<b>Reversible drive rolls: two grooves for two 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>Dual side-mounted cable hangers</b>	Convenient storage for cables when not in use.
<b>Fan-On-Demand™</b>	Cooling system operates only when needed reducing power consumption and contaminants drawn into the machine.
<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).

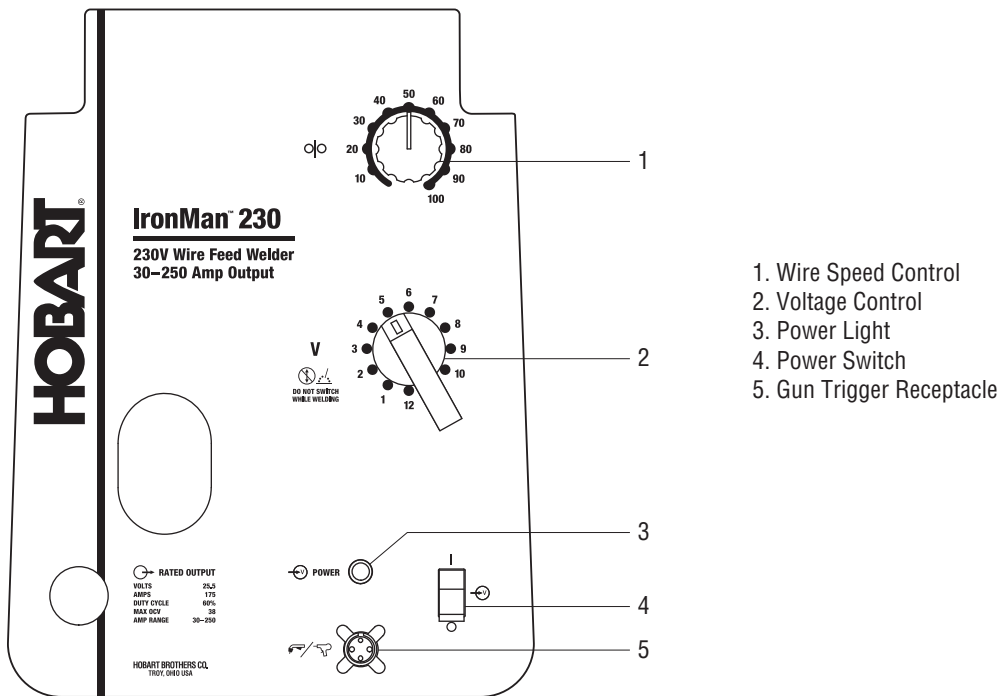
# Specifications (SUBJECT TO CHANGE WITHOUT NOTICE.)



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	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)

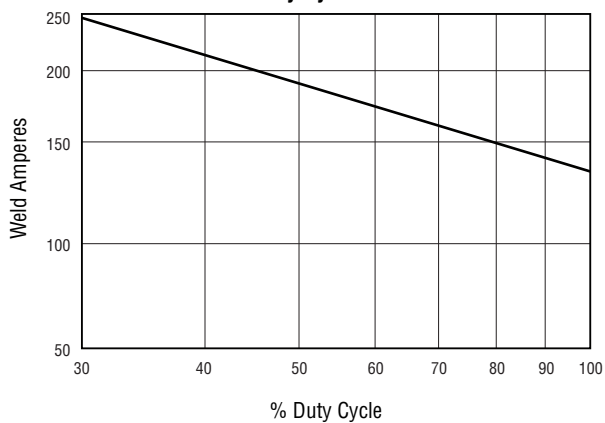
Certified by Canadian Standards Association to both Canadian and U.S. Standards.  
 Note: Operating Temperature Range: -4° to +104°F (-20° to +40°C)

## Control Panel

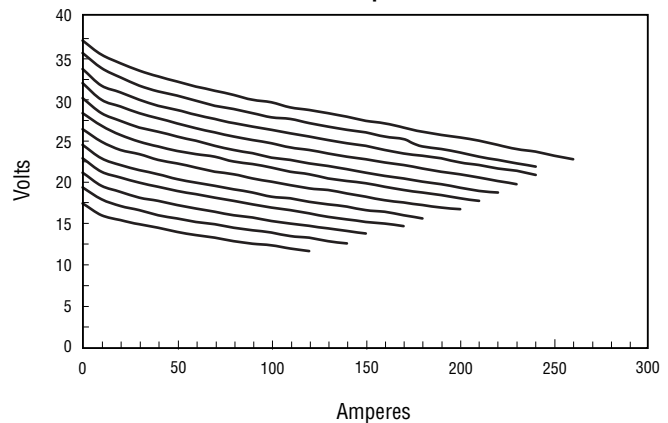


## Performance Data

**Duty Cycle Chart**



**Volt/Amp Curves**



## 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, 250 A, 15 ft. (4.6 m) Replacement Gun 169173

Gun designed to run .030–.035 in. (0.8–0.9 mm) wire. Gun rated at 250 amps, 100% duty cycle using CO<sub>2</sub> gas, and 60% 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



**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 #
<b>Contact Tips</b>	
.023/.025 in. (0.6 mm)	<b>770174 (5 per package)</b>
.030 in. (0.8 mm)	<b>770177 (5 per package)</b>
.035 in. (0.9 mm)	<b>770180 (5 per package)</b>
.045 in. (1.2 mm)	<b>770183 (5 per package)</b>
<b>Flush Nozzle</b>	
1/2 in. (12.7 mm) orifice flush	<b>770544</b>
5/8 in. (16 mm) orifice flush	<b>770405</b>
<b>Tip Adapter</b>	<b>770403</b>
<b>Replacement Liners</b>	
.023/.025 in. (0.6 mm)	<b>196139</b>
.030/.035 in. (0.8/0.9 mm)	<b>196139</b>
.035/.045 in. (0.9/1.2 mm)	<b>196140</b>

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