



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 steel.
- Excellent aluminum welding with optional Spoolmate 3545 spool gun.
- 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 Spoolmate 3545 spool gun	Excellent for pushing soft aluminum wires. (Adapter required for serial numbers prior to #LA135883)
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 200 V 230 V KVA KW	Dimensions	Net Weight
200 A, 24 V DC at 60% duty cycle	30–250 amps	35 V	90–750 IPM	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 to both the Canadian and U.S. Standards for welding equipment.



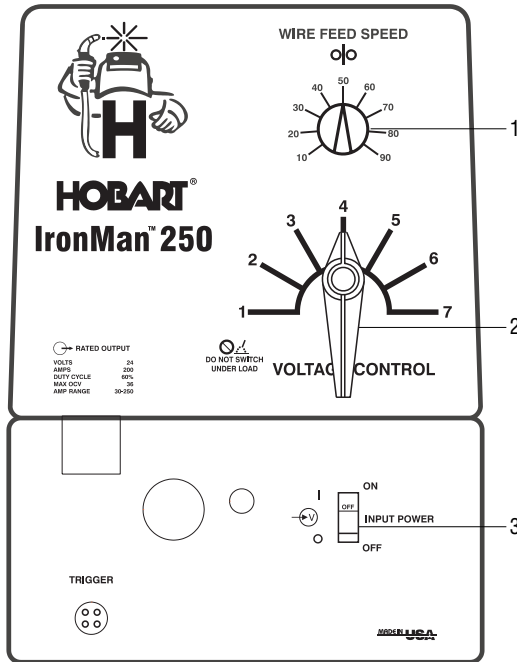
Hobart Welders An Illinois Tool Works Company

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



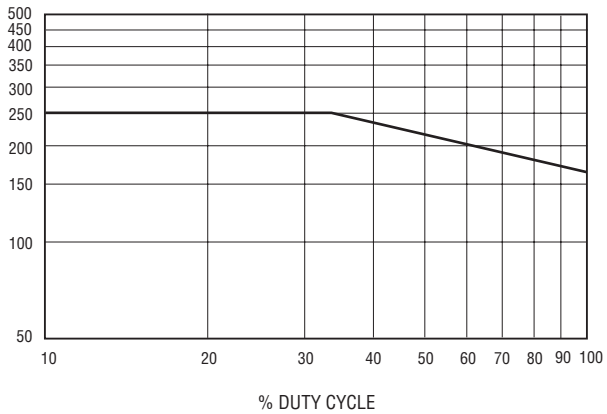
CONTROL PANEL



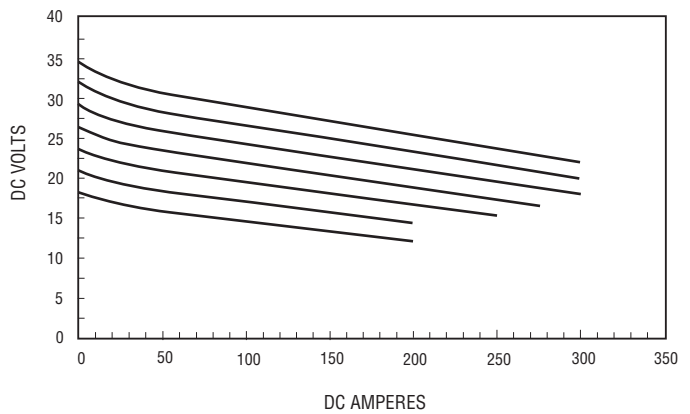
1. Wire Speed Control
2. Voltage Control
3. Power Switch

PERFORMANCE DATA

DUTY CYCLE CHART



VOLT/AMP CURVES



ACCESSORIES AND OPTIONS

Dual Bottle Rack Kit #042 758

M-25 Replacement Gun

#169 596 12 ft (3.7 m)
Gun designed to run .030–.035 in (0.8–0.9 mm) wire.

#169 599 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.



Spoolmate™ 3545 #195 015

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. **#207 642 Switch and Gas Diverter Kit** required.

25 ft Extension Cable Kit #194 996

Extends Spoolmate gun an additional 25 ft (7.6 m) from power source.

REPLACEMENT PARTS (Order from Hobart Service Parts.)

M-25 Consumable Kit #193 975

Convenient organizer box with consumables guide and restocking chart.

- Replacement consumables: .035 and .045 in (0.9 and 1.1 mm) contact tips (5 each); .625 in orifice nozzle (standard) (1)
- Maintenance components: tip adapters (2); nozzle adapter (1); shock washers (2); O-rings (3)



Contact Tips

- #087 299** .023/.025 in (0.6 mm)
- #000 067** .030 in (0.8 mm)
- #000 068** .035 in (0.9 mm)
- #000 069** .045 in (1.1 mm)
- #187 117** .035 in (0.9 mm) Heavy-duty tip
- #187 118** .045 in (1.2 mm) Heavy-duty tip



Contact Tip Adapter #169 728



Replacement Liners

- #194 010** .023/.025 in
- #194 011** .030–.035 in (Standard)
- #194 012** .035–.045 in



Nozzles

Note: Flush or stickout nozzles should be used for the short-circuit process. Recessed nozzles should be used for the spray arc process.

- #200 258** Standard
1/2 in (13 mm) diameter orifice. Nozzle flush with contact tip.
- #169 726**
5/8 in (16 mm) diameter orifice. Nozzle flush with contact tip.
- #169 727**
5/8 in (16 mm) diameter orifice. Contact tip sticks out of nozzle 1/8 in (3.2 mm).
- #169 724**
1/2 in (13 mm) diameter orifice. Contact tip recessed 1/8 in (3.2 mm) into nozzle.
- #169 725**
5/8 in (16 mm) diameter orifice. Contact tip recessed 1/8 in (3.2 mm) into nozzle.

Reversible V-Groove Drive Rolls for Mild Steel Wire

#202 925

.023 and .030/.035 in (0.6 and 0.8 mm)

#407 230-004

.023 and .045 in (0.6 and 1.1 mm)

Reversible V-Knurled Drive Roll

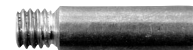
#193 330

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

#193 331

.039–.045 and .052–1/16 in (1.0–1.1 and 1.3–1.6 mm)

Spoolmate™ 3545 Consumables



Contact Tips (5 per package)

- #199 387** For .030 in (0.8 mm) wire.
- #199 388** For .035 in (0.9 mm) wire.
- #199 389** For .047 in (1.2 mm) wire.



Nozzle #199 386



Drive Roll (1)

- #186 413** For .030/.035 in (0.8/0.9 mm) wire.
- #199 396** For .047 in (1.2 mm) wire.



Push Roll (1)

- #186 414** For .030/.035 in (0.8/0.9 mm) wire.
- #199 397** For .047 in (1.2 mm) wire.

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	#500 408	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				
Dual Bottle Rack Kit	#042 758			
M-25 Replacement Gun	#169 596 #169 599	12 ft (3.7 m) 15 ft (4.6 m)		
Spoolmate 3545 Spool Gun	#195 015	Requires #207 642 Switch and Gas Diverter Kit		
Switch and Gas Diverter Kit	#207 642	Required for Spoolmate 3545 Spool Gun		
Replacement Parts (Order from Hobart Service Parts)				
M-25 Consumable Kit	#193 975			
Contact Tips	#087 299 #000 067 #000 068 #000 069 #187 117 #187 118	.023/.025 in (0.6 mm) .030 (0.8 mm) .035 (0.9 mm) .045 (1.1 mm) .035 (0.9 mm) Heavy-duty tip .045 (1.2 mm) Heavy-duty tip		
Contact Tip Adapter	#169 728			
Replacement Liners	#194 010 #194 011 #194 012	.023/.025 in .030 – .035 in (Standard) .035 – .045 in		
Nozzles	#200 258 #169 726 #169 727 #169 724 #169 725	1/2 in (13 mm). Nozzle flush to tip. Standard 5/8 in (16 mm). Nozzle flush to tip 5/8 in (16 mm). Tip sticks out 1/8 in (3.2 mm) 1/2 in (13 mm). Tip recessed 1/8 in (3.2 mm) 5/8 in (16 mm). Tip recessed 1/8 in (3.2 mm)		
Reversible V-Groove Drive Rolls for Mild Steel	#202 925 #407 230-004	.023 and .030/.035 in (0.6 and 0.8/0.9 mm) .023 and .045 in (0.6 and 1.1 mm)		
Reversible V-Knurled Drive Roll	#193 330 #193 331	.030 and .035 in (0.8 and 0.9 mm) .039 – .045 and .052 – 1/16 in (1.0 – 1.1 and 1.3 – 1.6 mm)		
Date:			Total Quoted Price:	



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