



### PROCESSES



MIG (GMAW)  
Welding



Flux Cored (FCAW)  
Welding

## 5/3/1 INDUSTRIAL WARRANTY



The IronMan™ 210 is a powerful welding package that is versatile and easy to use. It is equipped with many outstanding features.

- Welds 22 gauge up to 3/8 in steel.
- Excellent aluminum welding with optional Spoolmate 3035 spool gun.
- Six-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 gun and built-in running gear/cylinder rack.
- Handles wire spools up to 12 in — 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

<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>6-position voltage control</b>	Simplified and accurate adjustments. Maximizes amount of control. Allows for smooth arc with high operator appeal.
<b>Reversible drive rolls: two grooves for three 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>Low amperage draw</b>	Amperage draw of 25 amps at rated load of 230 V input saves energy.
<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.)

INDUSTRIAL



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		
150 A, 23 V DC at 40% duty cycle	30–210 amps	33 V	90–750 IPM	29	25	5.8	4.9	H: 31-1/4 in (794 mm) W: 18-7/8 in (479 mm) D: 36-1/2 in (927 mm)	146 lb (66 kg)

Certified to both the Canadian and U.S. Standards for welding equipment.



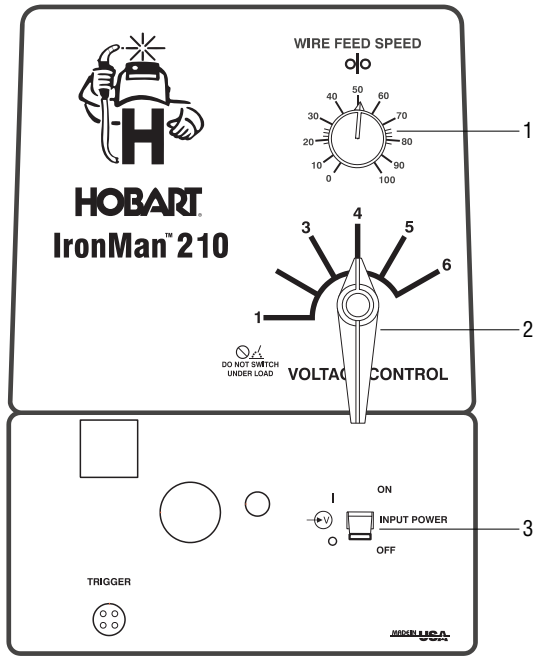
**Hobart Welders** An Illinois Tool Works Company

U.S. Distributor Sales Phone 920-735-4576 FAX 800-637-2315  
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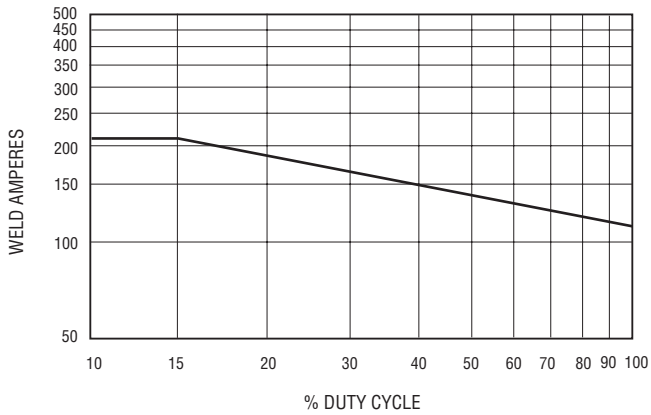
## CONTROL PANEL



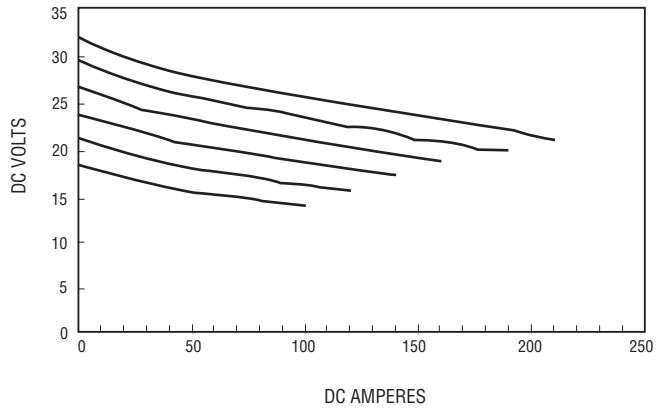
1. Wire Speed Control
2. Voltage Control
3. Power Switch

## PERFORMANCE DATA

**DUTY CYCLE CHART**



**VOLT/AMP CURVES**



## ACCESSORIES

**Dual Bottle Rack Kit #042 758**

**M-10 Replacement Gun #195 605**

10 ft (3 m) cable. Gun is designed to run .030–.035 in (0.8–0.9 mm) wire.



**Spoolmate™ 3035 #195 016**

Includes 20 ft (6 m) cable. When combined with the IronMan™ 210, this spool gun welds .023, .030 and .035 in (0.6, 0.8 and 0.9 mm) wires on 14 gauge to 1/4 in thick aluminum. **#207 642 Switch and Gas Diverter required.**

**25 ft Extension Cable Kit #194 996**

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

## CONSUMABLES (Order from Hobart Service Parts.)

### M-10 Gun Consumables

**M-10/15 Consumable Kit #193 973**

Convenient organizer box with consumables guide and restocking chart. Contains:  
 3 – .025 in (0.6 mm) contact tips (**#087 299**)  
 5 – .030 in (0.8 mm) contact tips (**#000 067**)  
 5 – .035 in (0.9 mm) contact tips (**#000 068**)  
 1 – Tip adapter (**#169 716**)  
 2 – Shock washers (**#169 717**)  
 3 – O-rings (**#170 471**)  
 1 – 1/2 in (13 mm) diameter orifice nozzle (**#169 715**)



#### 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)



**Contact Tip Adapter #169 716**



#### Replacement Liners

**#194 010** .023/.025 in (0.6 mm)  
**#194 011** .030/.035 in (0.8/0.9 mm) Standard  
**#194 012** .035/.045 in (0.9/1.1 mm)



**Nozzle #169 715** Standard flush  
 1/2 in (13 mm) diameter orifice.

#### Spot Nozzles

**#176 237** Flat  
**#176 239** Inside corner  
**#176 241** Outside corner

#### Reversible V-Groove Drive Rolls for Mild Steel Wire

**#202 925**  
 .023 and .030/.035 in (0.6 and 0.8/0.9 mm)  
**#407 230-004**  
 .023 and .045 in (0.6 and 1.1 mm)

#### Reversible V-Knurled Drive Rolls

**#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™ 3035 Consumables

#### Contact Tips

**#199 730** For .023 in (0.6 mm) wire  
**#186 419** For .030 in (0.8 mm) wire  
**#186 406** For .035 in (0.9 mm) wire

**Nozzle #186 405**

#### Drive Rolls

**#199 731** .023 in (0.6 mm)  
**#186 413** .030–.035 in (0.8–0.9 mm)

#### Push Rolls

**#199 732** .023 in (0.6 mm)  
**#186 414** .030–.035 in (0.8–0.9 mm)

**The IronMan™ 210 comes complete with:**

- Constant-voltage DC power source
- Built-in wire feeder
- 10 ft, M-10 MIG welding gun
- Regulator/flow gauge
- 5 ft gas hose
- Sample spool of solid welding wire
- 7 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	Stock No.	Description	Qty.	Price
<b>IronMan™ 210</b>	<b>#500 304</b>	200(208)/230 VAC, 60 Hz		
UPC: #715959245302; Shipping Weight: 185 lb (84 kg); Dimensions: 41-1/2 x 21-1/4 x 36 in; Pallet Qty: 1				
<b>Accessories</b>				
Dual Bottle Rack Kit	<b>#042 758</b>			
M-10 Replacement Gun	<b>#195 605</b>	10 ft (3 m)		
Spoolmate™ 3035 Spool Gun	<b>#195 016</b>	<b>Requires #207 642 Switch and Gas Diverter Kit</b>		
Switch and Gas Diverter Kit	<b>#207 642</b>	Required for Spoolmate 3035 Spool Gun		
<b>M-10 Consumables (Order from Hobart Service Parts)</b>				
M-10/15 Consumable Kit	<b>#193 973</b>			
Contact Tips	<b>#087 299</b> <b>#000 067</b> <b>#000 068</b> <b>#000 069</b>	.023/.025 in (0.6 mm) .030 (0.8 mm) .035 (0.9 mm) .045 (1.1 mm)		
Contact Tip Adapter	<b>#169 716</b>			
Replacement Liners	<b>#194 010</b> <b>#194 011</b> <b>#194 012</b>	.023/.025 in (0.6 mm) .030/.035 in (0.8/0.9 mm) standard .035/.045 in (0.9/1.1 mm)		
Nozzles	<b>#169 715</b> <b>#176 237</b> <b>#176 239</b> <b>#176 241</b>	Standard flush Flat Inside corner Outside corner		
Drive Rolls		See page 3		
<b>Spoolmate 3035 Consumables (Order from Hobart Service Parts)</b>				
Contact Tips	<b>#199 730</b> <b>#186 419</b> <b>#186 406</b>	.023 (0.6 mm) .030 (0.8 mm) .035 (0.9 mm)		
Nozzle	<b>#186 405</b>			
Drive Rolls	<b>#199 731</b> <b>#186 413</b>	.023 (0.6 mm) .030–.035 (0.8–0.9 mm)		
Push Rolls	<b>#199 732</b> <b>#186 413</b>	.023 (0.6 mm) .030–.035 (0.8–0.9 mm)		
<b>Date:</b>			<b>Total Quoted Price:</b>	



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