

# Stickmate® 160i and 210i

## DC Stick (SMAW) Welding Power Source



279109  
February 2018



**160i: 500570 (shown)**  
**210i: 500571**

### Quick Specs



#### Welding Amp Range

Stickmate 160i: 20–80 A (120 V)  
20–160 A (240 V)  
Stickmate 210i: 25–210 A (240 V)



#### Maximum Mild Steel Thickness

Stickmate 160i: 1/8 in. (120 V)  
3/8 in. (240 V)  
Stickmate 210i: 1/2 in. (240 V)

### Works the first time. Every time.

From the brand you know comes the most dependable, portable, powerful stick welder — even if you don't use it every day.

Easy, quick and reliable arc starts with Hot Start™ technology. Preferred DC output for the stick welding process means fewer arc outages, less sticking, less spatter and best arc control.

Nearly 100 pounds lighter means you can work smarter not harder by bringing the welder to the work. Its portability makes it easier to carry and store.

More powerful — up to 85 more amps — compared to leading competitive machine so you can weld thicker materials.

#### Applications

- DIY
- Metal art
- Farm/ranch
- Maintenance/repair

#### Includes

- 10 ft. (3 m) electrode cable with heavy-duty holder
- 10 ft. (3 m) work cable with clamp
- 6.5 ft. (2 m) power cord with MVP™ adapters for 120 V and 240 V (160i model) **OR** 240 V plug (210i model)

Features	Benefits
<b>Hot Start™ technology</b>	Provides easy, quick and reliable arc starts.
<b>Infinite amperage control</b>	Precise and accurate amperage control and heat output. Adjust output by as little as one-amp increments.
<b>Adjustable shoulder strap</b>	Easy to carry and move.
<b>High weld output</b>	Up to 210 amps with Stickmate 210i allows you to weld thicker materials.
<b>Dual-voltage capability with MVP adapters (Stickmate 160i model only)</b>	Allows connection to 120 or 240 V receptacles without tools — choose the adapter cord with the right plug that fits the receptacle, and connect it to the power cord with the L6-30R twist lock. <i>Note: Stickmate 210i model is 240 V only.</i>
<b>Hobart 5/3/1 industrial warranty</b>	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).

### Specifications (Subject to change without notice.)



Model	Input Power	Welding Amp Range	Rated Output	Max. Mild Steel Thickness	Amps Input at Rated Output	Max. Open-Circuit Voltage	Dimensions	Net Weight
Stickmate 160i	120 V	20–80 A	65 A at 20% duty cycle	1/8 in. (3.2 mm)	20.7	91 V	H: 10.5 in. (267 mm) W: 7.125 in. (181 mm) D: 13.375 in. (340 mm)	15 lb. (6.8 kg)
	240 V	20–160 A	160 A at 30% duty cycle	3/8 in. (9.5 mm)	27.8			
Stickmate 210i	240 V	25–210 A	210 A at 20% duty cycle	1/2 in. (12.7 mm)	43.4	85 V		15.5 lb. (7.0 kg)

Conforms to ANSI/IEC Std. 60974-1.  
Conforms to CSA Std. E60974-1.  
Intertek



#### Hobart Welding Products

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

#### HobartWelders.com



## Electrode Charts

### Electrode Polarity Chart

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	
6013	EP, EN	✓	ALL	LOW	GENERAL
7014	EP, EN	✓	ALL	MED.	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	SMOOTH, EASY, FASTER
Ni-CI	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

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

### Electrode/Amperage Chart

ELECTRODE	DIAMETER		AMPERAGE RANGE			
	IN	MM	MIN. 50A	100A	150A	200A MAX.
6010 & 6011	3/32	2.4				
	1/8	3.2				
	5/32	4.0				
6013	3/16	4.8				
	1/16	1.6				
	3/32	2.4				
7014	1/8	3.2				
	5/32	4.0				
	3/16	4.8				
7018 & 7018 AC*	1/16	1.6				
	3/32	2.4				
	1/8	3.2				
7024	5/32	4.0				
	3/16	4.8				
	3/32	2.4				
Ni-CI	1/8	3.2				
	5/32	4.0				
	3/16	4.8				
308L	3/32	2.4				
	1/8	3.2				
	5/32	4.0				
	3/16	4.8				

\*7018 AC recommended for use with AC welders.

**Ideal performance for most 6010, 6011, 6013 and 7018 rods.**

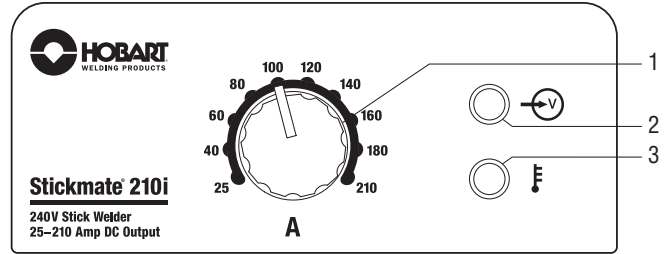
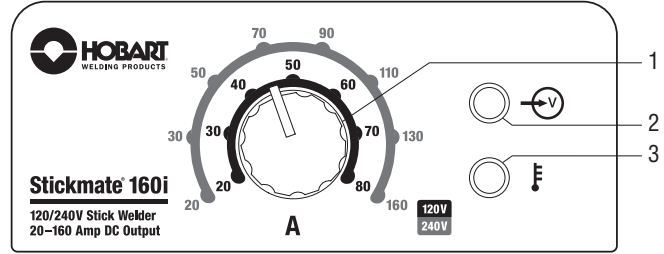
*Note: 6010 not recommended for open root welding.*

**Stickmate 160i**  
**120 V:** 1/16–1/8 in.  
*(some limitations with 3/32-inch rods and very limited with 1/8-inch rods based on rod/amperage)*

**240 V:** 1/16–5/32 in.  
*(some limitations with 5/32-inch rods based on amperage)*

**Stickmate 210i**  
**120 V:** 1/16–3/16 in.  
*(some limitations with 3/16-inch rods based on amperage)*

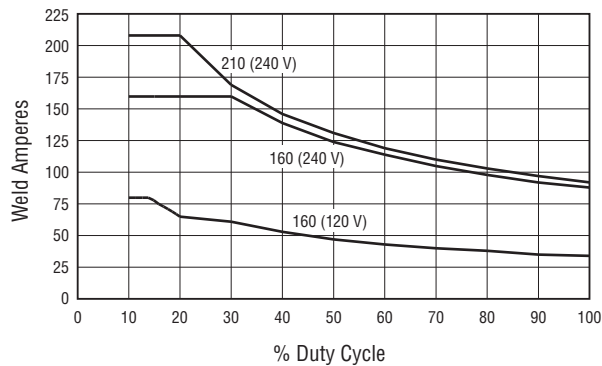
## Control Panels



1. Amperage Adjustment Control
2. Power Indicator Light
3. Overtemperature Light

## Performance Data

### Duty Cycle Chart



## Basic Equipment Setup (DCEP)

