

# HOBART®

HOBART BROTHERS CO.  
TROY, OHIO USA

**5/3/1**  
INDUSTRIAL  
WARRANTY

# Stickmate® LX 235 AC

## AC Stick (SMAW) Arc Welding Power Source



211753  
June 2012



#500420

**Includes:**

- 15-ft. (4.5 m) electrode cable with heavy-duty holder
- 10-ft. (3 m) work cable with clamp
- 5-ft. (1.5 m) power cord with plug

The Stickmate LX 235 AC Stick welding power sources have the control to get the exact heat you need — always. Also, these machines allow weld time to increase when amperage decreases.

They have the range and muscle to handle many Stick welding, hard surfacing, and cutting jobs. At the same time, they have the precision for low hydrogen and special alloy electrodes.

Accu-Set™ design provides accurate heat control with infinite amperage control. This Stick welder also allows a higher duty cycle when amperages decrease to give you more arc time when welding thinner materials.

**Applications:**

- Farms
- Ranches
- Ornamental Iron
- Garages
- Hobbyists
- Maintenance
- Individuals

Features	Benefits
Accu-Set™ amperage indicator	Accu-Set is an exclusive design for accurately controlling amperage or heat output. As you turn the Accu-Set™ control, the indicator more clearly shows the amperage setting.
Infinite current control	The precise control of the Stickmate LX allows the operator to adjust output by as little as 1-amp increments. Users can always get the exact heat they need, unlike the step control design on competitive products.
Output selector switch	Allows you to quickly select low or high range without adjusting the output leads.
High 100% duty cycle rating	100 amps AC.
Two AC output ranges	With two AC ranges to select from, you have greater control of weld performance.
Fully varnished magnetic coils	Varnish protects and lengthens the life of the coils inside for increased reliability.
Forced-draft cooling fan	The cooling fan runs continuously and helps to extend the life of the power source.
Hobart's 5/3/1 Warranty	Five-year warranty on transformers, stabilizers and generators; three years on electronics (drive motors, rectifiers); and one year on guns.

Specifications (SUBJECT TO CHANGE WITHOUT NOTICE.)					AC	CC	1 Phase
Rated Welding Output	Welding Amperage Range		Max. Open-Circuit Voltage	Amps Input at Rated Output, 230 V, 50/60 Hz	Dimensions		Net Weight
	High	Low					
225 A at 25 VAC, 20% Duty Cycle at 60 Hz 15% Duty Cycle at 50 Hz	40–235 A	30–150 A	80 V	47.5	H: 18-3/4 in. (476 mm) W: 12-3/4 in. (323 mm) D: 17-1/2 in. (445 mm)		85 lb. (39 kg)

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

## 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

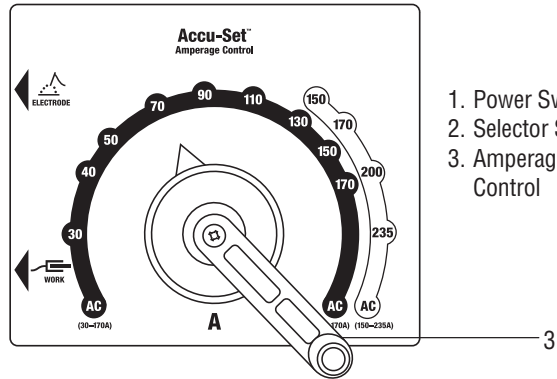
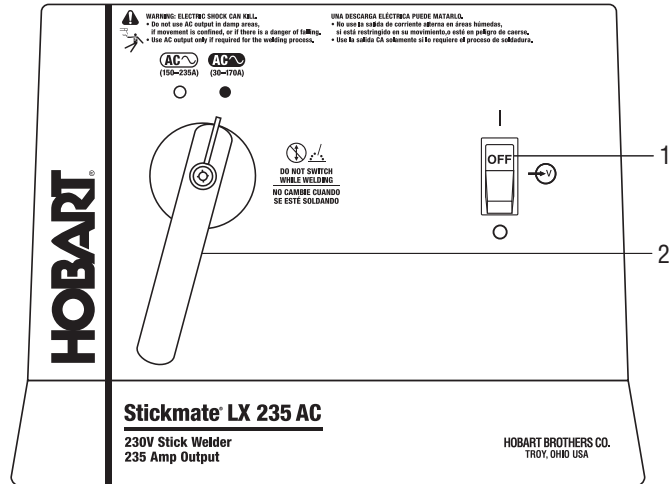
\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

### 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						

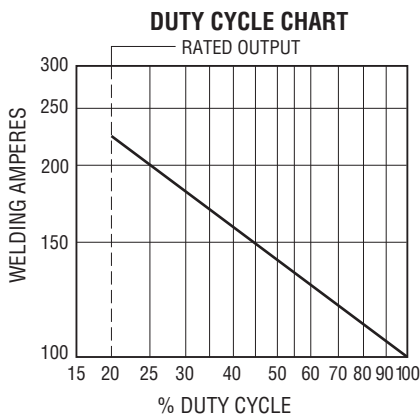
\*7018 AC recommended for use with AC welders.

## Control Panel



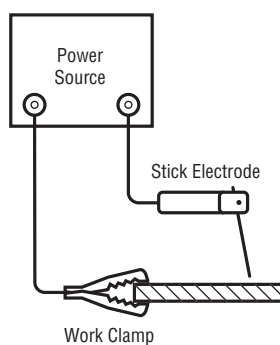
1. Power Switch
2. Selector Switch
3. Amperage Adjustment Control

## Performance Data



## Basic Equipment Setup

### Stick (SMAW)



## Accessories

### Running Gear #043927

Mounts easily to unit and provides convenient portability, with various mounting options to suit user preference. Includes two wheels, two feet and a handle.



**Hobart Welders** An Illinois Tool Works Company

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