

HOBART®

MADE IN THE USA

5/3/1
INDUSTRIAL WARRANTY

STICKMATE® LX 235 AC/160 DC



AC/DC Stick (SMAW) Arc Welding Power Source

211809
Nov. 2010



#500421

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/160 DC power sources let you choose between AC or DC weld output to expand your welding options to either AC or DC Stick electrodes. DC output means fewer arc outages, less sticking, less spatter, better control on thin work, and easier out-of-position welding. AC output produces less arc blow and easier starts.

Accu-Set™ design provides accurate heat control with infinite amperage control. Additionally, the STICKMATE LX allows a higher duty cycle when amperage decreases, unlike some competitive products in the market.

Applications:

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

Features	Benefits
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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 235 AC/160 DC 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 AC, DCEP or DCEN without adjusting the output leads.
High 100% duty cycle rating	100 amps AC/65 amps DC.
High DC weld output	Up to 150 amps available at 20% duty cycle. The STICKMATE LX 235 AC/160 DC model has 20% more DC output than competitive products.
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.)					
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Mode	Rated Welding Output	Welding Amperage Range High Low	Max. Open-Circuit Voltage	Amps Input at Rated Output, 230 V, 50/60 Hz	Dimensions	Net Weight
AC	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)	104 lb. (47 kg)
DC	150 A at 25 VDC, 20% Duty Cycle at 60 Hz 15% Duty Cycle at 50 Hz	30–160 A				

Electrode Charts

ELECTRODE POLARITY CHART

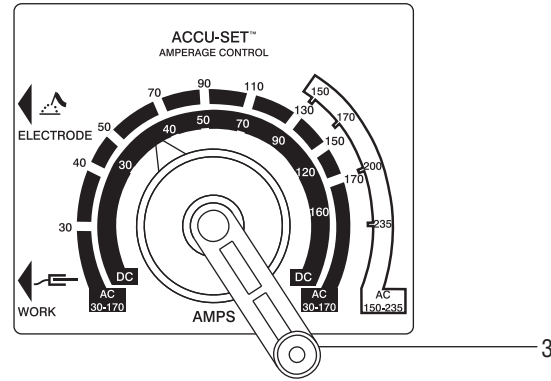
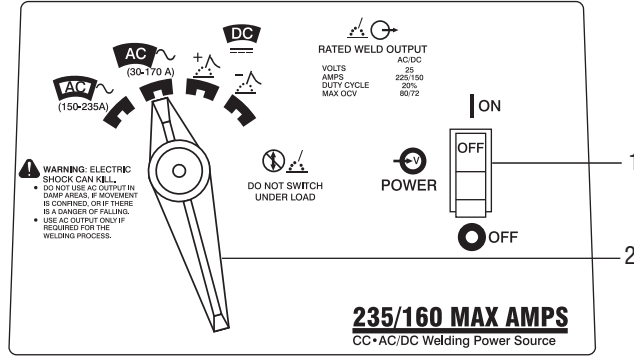
ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP, ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	GENERAL
6013	EP, EN	✓	ALL	LOW	SMOOTH, EASY, FAST
7014	EP, EN	✓	ALL	MED.	LOW HYDROGEN, STRONG
7018	EP	✓	ALL	LOW	SMOOTH, EASY, FASTER
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	CAST IRON
Ni-CI	EP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

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

ELECTRODE/AMPERAGE CHART

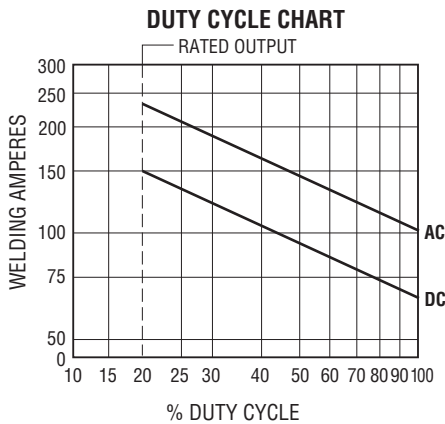
ELECTRODE	DIAMETER		AMPERAGE RANGE					
	IN	MM	MIN.	50A	100A	150A	200A	MAX.
6010 & 6011	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
	3/16	4.8						
6013	1/16	1.6						
	5/64	2.0						
	3/32	2.4						
	1/8	3.2						
7014	5/32	4.0						
	3/16	4.8						
	3/32	2.4						
7018	1/8	3.2						
	5/32	4.0						
	3/32	2.4						
7024	1/8	3.2						
	5/32	4.0						
	3/32	2.4						
Ni-CI	1/8	3.2						
	5/32	4.0						
	3/16	4.8						
	3/32	2.4						
308L	1/8	3.2						
	5/32	4.0						
	3/32	2.4						

Control Panel



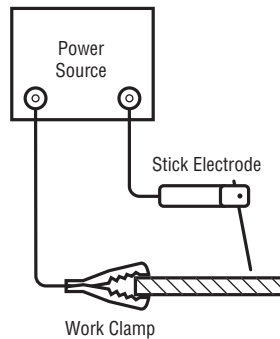
1. Power Switch
2. Selector Switch
3. Amperage Adjustment Control

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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Litho in USA

hobartwelders.com

