



### PROCESSES



Stick (SMAW) Welding

## 5/3/1 INDUSTRIAL WARRANTY



The STICKMATE<sup>®</sup> LX 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.

The Accu-Set™ (patented) 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

### Comes Complete with:

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

### FEATURES

### BENEFITS

<b>Accu-Set™ amperage indicator</b>	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.
<b>Infinite current control</b>	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.
<b>Output selector switch</b>	Allows you to quickly select low or high range without adjusting the output leads.
<b>High 100% duty cycle rating</b>	100 amps AC
<b>Two AC output ranges</b>	With two AC ranges to select from, you have greater control of weld performance.
<b>Fully varnished magnetic coils</b>	Varnish protects and lengthens the life of the coils inside for increased reliability.
<b>Forced-draft cooling fan</b>	The cooling fan runs continuously and helps to extend the life of the power source.
<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.)

LIGHT INDUSTRIAL



Rated Welding Output	Welding Amperage Range		Max. Open-Circuit Voltage	Amps Input at Rated Output 230 V, 50 or 60 Hz	Dimensions	Net Weight
	High	Low				
225 amps at 25 VAC, 20% duty cycle, 60 Hz 15% duty cycle, 50 Hz	40-235	30-150	80	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 to both the Canadian and U.S. Standards for welding equipment.



**Hobart Welders** An Illinois Tool Works Company

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Web Site [HobartWelders.com](http://HobartWelders.com)



## ELECTRODE CHARTS

### ELECTRODE POLARITY CHART

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	✓	ALL	DEEP	MIN. PREP, ROUGH,
6011	EP	✓	ALL	DEEP	HIGH SPATTER
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						
	5/64	2.0						
7014	3/32	2.4						
	1/8	3.2						
	5/32	4.0						
7018	3/16	4.8						
	3/32	2.4						
	1/8	3.2						
7024	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
Ni-CI	5/32	4.0						
	3/32	2.4						
	1/8	3.2						
308L	5/32	4.0						
	3/32	2.4						
	1/8	3.2						

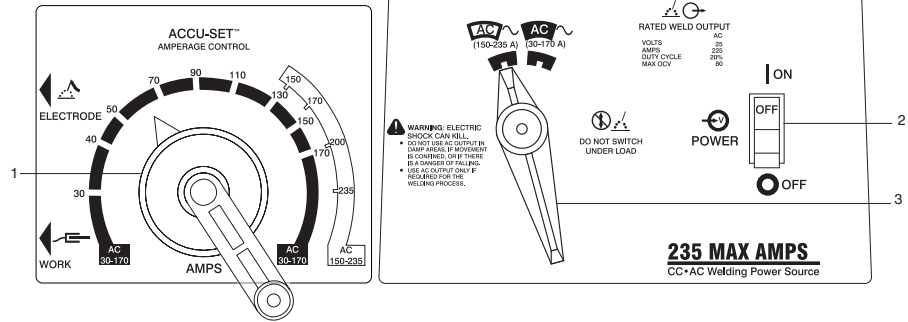
## ACCESSORIES



### Running Gear #043 927

Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and a handle.

## CONTROL PANEL



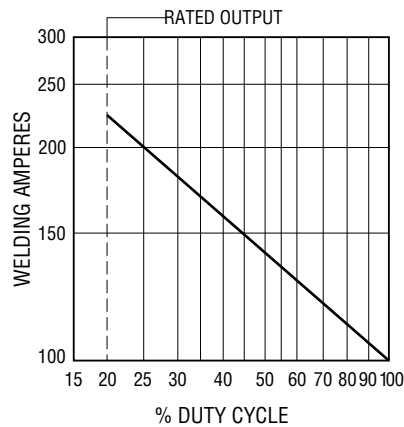
1. Amperage Adjustment Control

2. Power Switch

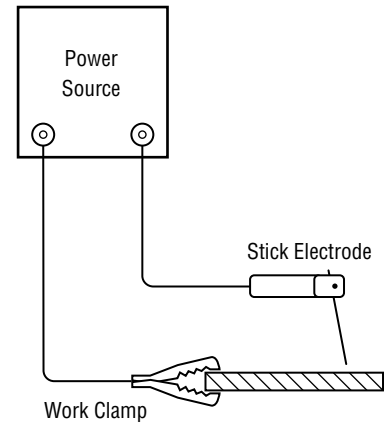
3. Selector Switch

## PERFORMANCE DATA

### DUTY CYCLE CHART



## STICK (SMAW) BASIC EQUIPMENT SETUP



## ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source and Options	Stock No.	Description	Qty.	Price
<b>STICKMATE LX 235 AC</b>	<b>#500 420</b>	230 V, 50/60 Hz, without running gear		
UPC: #715959232876; Shipping Weight: 89 lb (40 kg); Carton Dimensions: 22 x 13-1/4 x 27-1/4 in; Pallet Qty: 12; Pallet Dimensions: 41-1/2 x 44-1/2 x 43 in				
<b>Miscellaneous</b>				
Running Gear	<b>#043 927</b>	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and a handle.		
Stick Electrodes		See charts above		
Helmet				
Gloves				
Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				

Date:

Total Quoted Price:

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

## DISTRIBUTED BY:

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