



PROCESSES



Stick (SMAW) Welding

5/3/1 WARRANTY



Hobart's STICKMATE LX 235 AC/160 DC power source lets 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.

The Accu-Set™ (patent pending) design, provides accurate heat control with infinite amperage control. Additionally, 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

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.
Replaceable weld cables	Removable cables let you lengthen or replace cables easily in future.
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 (MIG and plasma torches).

SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

LIGHT INDUSTRIAL



Mode	Rated Welding Output	Welding Amperage Range High Low	Max. Open-Circuit Voltage	Amps Input at Rated Output, 50 or 60 Hz, 230 V	Dimensions	Net Weight
AC	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)	104 lb (47 kg)
DC	150 amps at 25 VDC, 20% duty cycle @ 60 Hz; 15% duty cycle @ 50 Hz	30-160	80			

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



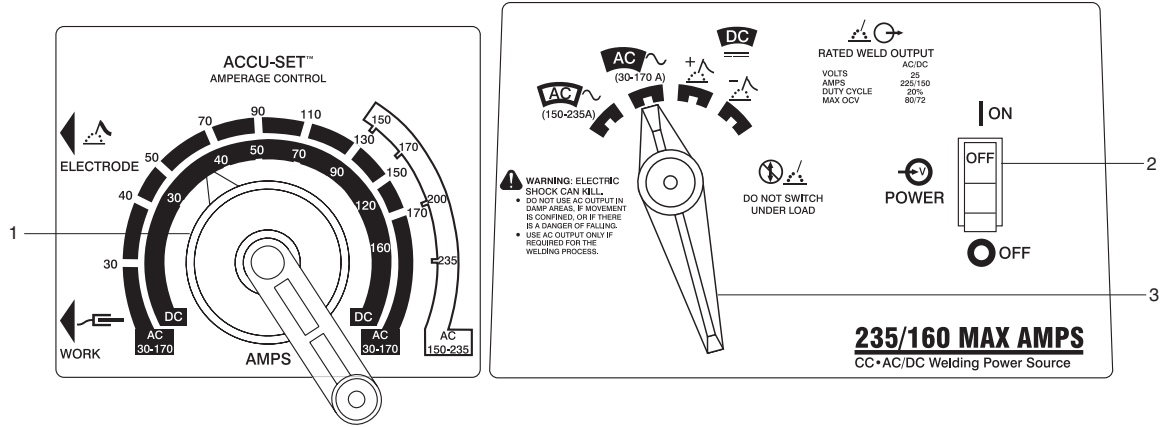
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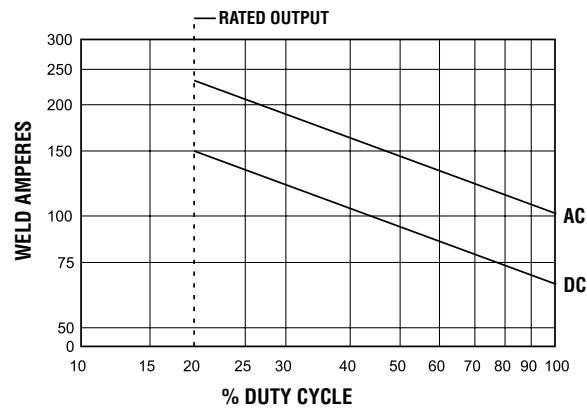
CONTROL PANEL



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

PERFORMANCE DATA

DUTY CYCLE



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	50	60	70	80	90	100
	1/8	3.2	60	70	80	90	100	110
	5/32	4.0	70	80	90	100	110	120
	3/16	4.8	80	90	100	110	120	130
6013	1/16	1.6	50	60	70	80	90	100
	5/64	2.0	60	70	80	90	100	110
	3/32	2.4	70	80	90	100	110	120
	1/8	3.2	80	90	100	110	120	130
	5/32	4.0	90	100	110	120	130	140
	3/16	4.8	100	110	120	130	140	150
7014	3/32	2.4	60	70	80	90	100	110
	1/8	3.2	70	80	90	100	110	120
	5/32	4.0	80	90	100	110	120	130
7018	3/32	2.4	60	70	80	90	100	110
	1/8	3.2	70	80	90	100	110	120
	5/32	4.0	80	90	100	110	120	130
7024	3/32	2.4	60	70	80	90	100	110
	1/8	3.2	70	80	90	100	110	120
	5/32	4.0	80	90	100	110	120	130
Ni-CI	3/32	2.4	60	70	80	90	100	110
	1/8	3.2	70	80	90	100	110	120
	5/32	4.0	80	90	100	110	120	130
	3/16	4.8	90	100	110	120	130	140
308L	3/32	2.4	60	70	80	90	100	110
	1/8	3.2	70	80	90	100	110	120
	5/32	4.0	80	90	100	110	120	130

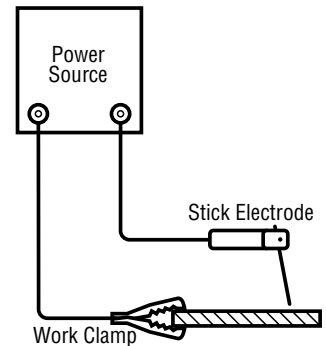
Accessories



Running Gear #043 927

Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and a handle. (Running gear are standard with #500 419 — see Ordering Information on back page.)

Stick (SMAW) Basic Equipment SETUP



ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source and Options	Stock No.	Description	Qty.	Price
STICKMATE LX 235 AC/160 DC	#500 419	230 V, 50/60 Hz, with running gear		
	#500 421	230 V, 50/60 Hz, without running gear		
Miscellaneous				
Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and a handle. (Standard with #500 419)		
Stick Electrodes		See charts on page 3		
Helmet				
Gloves				
Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				
Date:			Total Quoted Price:	


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HOBART

W E L D E R S

Litho in USA

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