

# HOBART®

MADE IN THE  
USA

**5/3/1**  
INDUSTRIAL  
WARRANTY

# STICKMATE® 205 AC

## AC Stick (SMAW) Arc Welding Power Source



216440  
Nov. 2010



#500502

**Includes:**

- 12-ft. (3.7 m) electrode cable with heavy-duty holder
- 10-ft. (3 m) work cable with clamp
- Power cord with plug

The STICKMATE® 205 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. Recommended for a variety of electrodes 1/16–5/32 in diameter.

Accu-Set™ design provides accurate heat control with infinite amperage control. Additionally, the STICKMATE 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
Accu-Set™ amperage indicator	Accu-Set is an exclusive design for accurately controlling amperage or heat output.
Infinite current control	The precise control of the STICKMATE allows the operator to adjust output by as little as 1-amp increments. Adjustments can be made while welding to achieve desired heat level, unlike the step control design on competitive products.
Increasing duty cycle	Duty cycle increases as amperage setting decreases. 100% duty cycle at 90 A, 25 V.
Max. 80 open-circuit voltage	Assists with arc starting and arc stability.
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.)



Rated Welding Output	Welding Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 230 V, 50/60 Hz	Dimensions	Net Weight
165 A at 25 VAC, 20% Duty Cycle, 50/60 Hz	30–205 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)	83 lb. (38 kg)

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

## Electrode Charts

### ELECTRODE SELECTION CHART

ELECTRODE	AC	DC*	POSITION	PENETRATION	USAGE
6010	NO	EP	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	YES	EP	ALL	DEEP	GENERAL, EASY
6013	YES	EP, EN	ALL	LOW	SMOOTH, EASY, FAST
7014	YES	EP, EN	ALL	MED	LOW HYDROGEN, STRONG
7018	YES	EP	ALL	LOW	SMOOTH, EASY, FASTER
7018AC	YES	EP	ALL	LOW	CAST IRON
7024	YES	EP, EN	FLAT HORIZ FILLET	LOW	STAINLESS
Ni-CI	YES	EP	ALL	LOW	
308L	YES	EP	ALL	LOW	

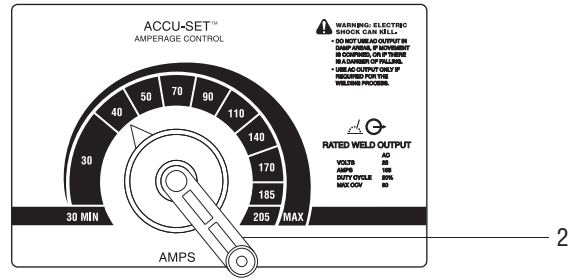
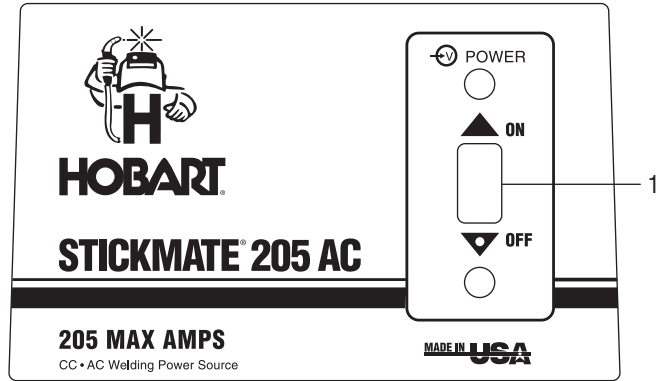
\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
\*EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

### WELDING RANGE CHART

ELECTRODE AWS CLASS	DIAMETERS			
	1/16	3/32	1/8	5/32
6010	X	40-85	75-125	110-165
6011	20-35	40-85	75-125	110-165
6013	20-45	40-90	80-130	105-180
7014	35-60	80-125	110-165	150-210
7018	30-50	65-100	110-165	150-220
7018 AC*	30-50	65-100	110-165	150-220
7024	X	100-145	140-190	180-250
Ni-CI	X	50-70	65-85	100-140
308L	X	40-80	75-115	105-160

\*7018 AC recommended for use with AC welders.

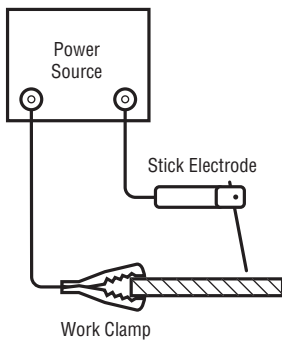
## Control Panel



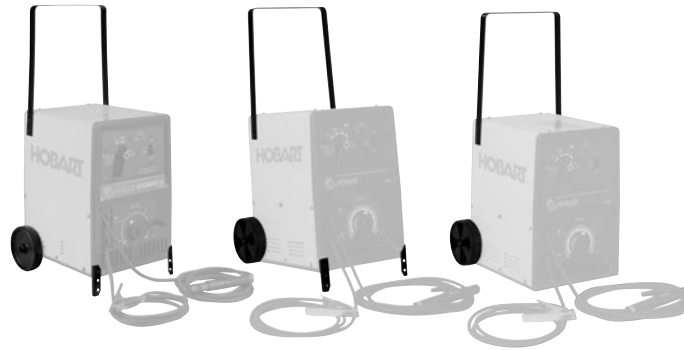
1. Power Switch
2. Amperage Adjustment Control

## 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

