

Rebel™ EMP 235ic

Specifications	
Primary Voltage	120 VAC, 208/230 VAC
Supply Voltage Range	90 – 270 VAC
Number of Phases	1
Supply Frequency	50/60 Hz
Supply Plug	230 V, NEMA 6-50P
Lead Cord Length	10 ft. (3 m)
Maximum Output	250 A/30 V
MIG (GMAW/FCAW) Welding Output @ 104°F (40°C)	120 A/19 V (120 V) @ 40% Duty Cycle 235 A/26 V (230 V) @ 40% Duty Cycle
STICK (SMAW) Welding Output @ 104°F (40°C)	90 A/23.6 V (120 V) @ 40% Duty Cycle 210 A/28.4 V (230 V) @ 25% Duty Cycle
TIG (GTAW) Welding Output @ 104°F (40°C)	130 A/15.2 V (120 V) @ 40% Duty Cycle 240 A/19.6 V (230 V) @ 40% Duty Cycle
Current Range	5 – 150 A (120 V), 5 – 250 A (230 V)
MIG Welding Voltage Range	10 – 30 V
Wire Feed Speed Range	60 – 700 ipm (1.5 – 18 m/min)
Nominal OCV Volt/DC	68 VDC
Maximum Plate Thickness	1/2 in. (12.7 mm)
Wire Diameter Range: Mild Steel Stainless Steel Aluminum	.023 – .035 in. (0.6 – 0.9 mm) .030 – .035 in. (0.8 – 0.9 mm) .030 – .045 in. (0.8 – 1.2 mm)
Wire Spool Size	4 in. (100 mm), 8 in. (200 mm), 12 in. (300 mm)
Approvals	CSA E60974-1-00, IEC 60974-1, UL60974-1
Protection Class	IP23S
Power Source Dimensions, L x W x H	26.5 x 11.5 x 19.5 in. (673 x 292 x 495 mm)
Power Source Weight	53 lbs. (24 kg)

Ordering Information	
Description	Part Number
Rebel EMP 235ic Multi-Process Package	0558012702
Rebel EMP 235ic Multi-Process Package with cart	0558012704

Includes power supply, Tweco SprayMaster 250 MIG gun, Victor argon flowmeter regulator, 12.5 ft. (3.8 m) hose, return clamp with leads, drive rolls and contact tips, .035 in. (0.9 mm) wire, electrode holder and ESAB Atom Arc 7018 electrodes, power adapter, and operator's manual.

Rebel EMP 235ic with Cart package also includes single cylinder cart.

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Options & Accessories

Description	Part Number
ESAB TXH 201 5/8 npt 12.5 ft. (3.8 m) TIG Torch Outfit	0558102493
Spray Master 250 MIG Gun, 15 ft. (4.5 m)	1023-1140
Tweco 200A Spool Gun, 12 ft. (3.6 m)	1027-1398
Tweco 200A Spool Gun, 25 ft. (7.6 m)	1027-1399
Foot Control, 15 ft. (4.6 m) cable and 8-pin Male Plug	W4014450
Rebel Single Cylinder Cart	0558102491

Wear & Spare Parts

Description	Part Number
Tweco HD 22 Series 3/8	1220-1305
Tweco HD 22 Series 1/2	1220-1306
Conduit Liner 0.8-0.9 mm / .030-.035 in. (installed)	1420-1113
Tweco 11-23 Contact Tip (023)	1110-1100
Tweco 11-30 Contact Tip (030)	1110-1101
Tweco 11-35 Contact Tip (035)	1110-1102
Tweco 11-45 Contact Tip (045)	1110-1104
TwecoTong T532MC Electrode Holder (200A, thru 5/32, 2/0 Max) Copper Alloy, Master Carton	9110-1122
Ground Clamp 200 A and Lead Assembly, 10 ft. (3 m), 50 mm	WS200G10
HRF 1425-580 Regulator/Flowmeter	0781-2743
Gas Hose, 3.8 m (12.5 ft.), Male 5/8-18UNF	W4013900
Power Adapter, 230 V to 120 V, 15 A	W4014000
Drive Roll, V-Groove, .023/.035 in. (0.6/0.9 mm)	W4014800
Drive Roll, V-Groove, .023/.030 in. (0.6/0.8 mm) (installed)	7977036
Drive Roll, V-Groove, .035/.045 in. (0.9/1.2 mm) for steel & stainless wires	7977660
Drive Roll, Knurled V-Groove, .030/.035 in. (0.8/0.9 mm) (FCAW)	7977732
Drive Roll, Knurled V-Groove, .035/.045 in. (0.9/1.2 mm) (FCAW)	0349312497
Drive Roll, U-Groove, .030/.035 in. (0.8/0.9 mm) for aluminum	7977731
Guide Tube, .023-.030 in. (0.6-0.8 mm)	0558102460
Guide Tube, .035-.052 in. (0.9-1.2 mm)	0558102461
Guide Tube, .030-.035 (0.8-0.9 mm) for aluminum	0558102455
Guide Tube, .040-.045 in. (1.0-1.2 mm) for aluminum	0558102456