

Rebel™ EMP 205ic AC/DC

Portable, true all-process welding system



Rebel EMP 205ic AC/DC and accessories.

We made the impossible possible with the first-ever portable, all-process machine, complete with MIG, Flux-Cored, Stick, DC TIG, and now AC TIG capabilities, which means – yes – it TIG welds aluminum. It's a TRUE all-in-one welding system that delivers best-in-class performance in each process in the most portable, durable, go anywhere, weld anything industrial package on the market today.

- True All-Process – excellent performance on MIG, Flux-Cored, STICK (including 6010 electrodes), DC TIG and AC TIG industrial applications
- Standard AC TIG features such as High Frequency starting, Balance Adjustment, Frequency Adjustment and Pulse
- sMIG Technology - exclusive sMIG (“smart MIG”) feature continuously learns and adapts to the operator’s welding technique to provide a stable arc and superior, repeatable welds; increases productivity for the experienced welder, and reduces training time for novice welders
- Unmatched Portability and Durability – weighing in at only 49 lbs. (22 kg), Rebel™ EMP 205ic AC/DC with 5 handle roll cage can tackle any job around the shop or out at the job site
- TFT Multilingual Display – packed full of features, Rebel EMP 205ic AC/DC has 4 programmable memory locations for each process, multi-language selection, trim adjustment, inductance control, pre/post flow control and spot weld setting - giving you the ability to fine tune your welds for the most optimal performance

Industry

- Light Fabrication
- Repair and Maintenance
- Automotive Bodies
- Food and Beverage
- Aluminum Trailers
- Boiler tubes
- Pipe Construction
- Mechanical Contractors
- Agricultural Equipment
- Training Schools



Large 4.3 LCD - TFT Multilingual Display

Visit esab.com for more information.

When choosing a top-performing welding machine you need top-performing ESAB Filler Metals. Learn more at esab.com/fillermetals today.

Rebel™ EMP 205ic AC/DC

Specifications	
Primary Voltage	120/230 VAC 1 ph +/- 10%, 50/60 Hz
Input Current Draw	30 A (27.6 A) @ 25% Duty Cycle
Maximum Output	235 A / 26.0 V (MIG) 180 A / 27.2 V (Stick) 205 A / 18.2 V (DC TIG)
MIG (GMAW/FCAW) Welding Output	205 A / 24.3 V @ 25% Duty Cycle 150 A / 21.5 V @ 40% Duty Cycle 125 A / 20.3 V @ 60% Duty Cycle 110 A / 19.5 V @ 100% Duty Cycle
STICK (SMAW) Welding Output	170 A / 27.2 V @ 25% Duty Cycle 125 A / 25.0 V @ 60% Duty Cycle 100 A / 24.0 V @ 100% Duty Cycle
TIG (GTAW) AC/DC Welding Output	205 A / 18.2 V @ 25% Duty Cycle 125 A / 15.0 V @ 60% Duty Cycle 110 A / 14.4 V @ 100% Duty Cycle
AC TIG Functionality Balance Range Frequency Range Pulsed TIG (DC only)	1 – 99% 25 – 400 Hz 1 – 500 p/s
Current Range	5 – 235 A
MIG Welding Voltage Range	12 – 26 V
Wire Feed Speed Range	80 – 475 ipm (2.0 – 12.0 m/min)
Open Circuit Voltage	68 V
Rated kVA	4.98 kVA (recommended > 7 kVA generator)
Power Factor at Max Current	0.98
Efficiency at Max Current	83%
Lead Cord Length	6 ft. (1.8 m)
Approvals	CSA
Protection Class	IP23
Dimensions, L x W x H	23 x 9 x 16 in. (584 x 229 x 406 mm)
Weight	49 lbs. (22 kg)

Ordering Information	
Description	Part Number
Rebel EMP 205ic AC/DC 10 ft. (3 m) System	0558102553

Package includes power supply, Tweco® Fusion® 180 Velocity™ MIG gun, electrode holder, Heliarc® HW-17 TIG Torch outfit with accessory kit, foot control, .035 in. (0.9 mm) wire, Atom Arc® 7018 electrodes. Victor® argon flowmeter regulator, 12.5 ft. (3.8 m) hose, return clamp with leads, drive rolls and contact tips, and operator's manual

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Options & Accessories

Description	Part Number
Tweco 160A Spool Gun, 12 ft. (3.6 m)	1027-1397
Tweco Fusion 180A MIG Gun, 10 ft. (3 m)	1017-1388
Electrode Holder 200A and Lead Assembly, 13 ft. (4 m), 50 mm	WS200E13
Tweco Ground Clamp w/Lead, 10 ft. (3 m), 50 mm Dinse	WS200G10
Victor HRF 1425-580 Regulator/Flowmeter	0781-2743
Power Adapter - 230V to 120V, 15A	W4014000
Rebel Utility Cart, max 7 in. (177.8 mm) diameter cylinder	0558102325
Rebel Single Cylinder Cart	0558102491
Rebel Dual Cylinder Cart	0558102492

For more information about Fusion Velocity Consumables, see Tweco Catalog or Velocity Fact Sheet.

Wear & Spare Parts

Description	Part Number
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)	7977036
Drive Roll Knurled V-groove, .030/.035 in. (0.8/0.9 mm) FCAW	7977732
Guide Tube, .023-.030 in. (0.6-0.8 mm)	0558102460
Guide Tube, .035-.045 in. (0.9 - 1.2 mm)	0558102461

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