Rebel™ EMP 215ic

Dual-voltage machine for MIG, TIG, Stick welding

GMAW GTAW SMAW 1 PHASE 3 YR WARRANTY 100% Satisfaction Guarantee

Rebel EMP 215ic

The Rebel™ EMP 215ic offers 120/230 V flexibility and some of the most innovative welding technology available. A breakthrough design inspired by professional welders, the Rebel EMP 215ic is a complete MIG/TIG/Stick package ready to weld anything – mild steel, aluminum, stainless steel – and go anywhere.

- True multi-process performance for best-in-class MIG, Flux-Cored, Stick, including 6010 Stick electrodes, and Lift TIG welding with Rebel EMP 215ic
- 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
- Innovative display has larger display screen and higher pixel density to provide a more clear view of the TFT screen than other light industrial welders; loaded with exclusive features: on-demand availability of the user's manual, listing of spare parts – all in multiple languages
- Unique, five-handle roll cage industrial design and unibody steel construction in a lightweight, highly portable unit; 3-year handle-to-handle warranty
- Rebel Series models come ready to weld out of the box with Professional Grade TWECO accessories and Victor gas regulator. Shielding gas not included.

Visit **esab.com** for more information.

Industry

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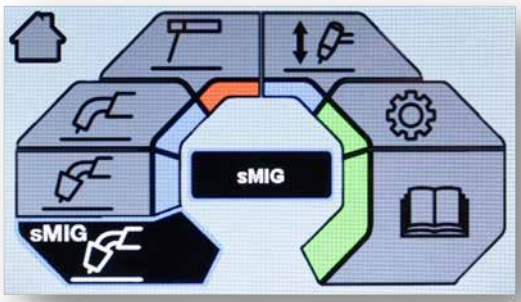

EMP 215ic display shown

Rebel EMP 215ic complete package.

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

Rebel™ EMP 215ic

Specifications	
Primary Voltage	120VAC, 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
Rated kVA @ Maximum	4.5 kVA (120 V), 7 kVA (230 V)
Lead Cord Length	6.5 ft. (2 m)
Maximum Output	240 A
MIG (GMAW) Welding Output	130 A/20.5 V (120 V) @ 20% Duty Cycle 205 A/24.3 V (230 V) @ 25% Duty Cycle
STICK (SMAW) Welding Output	90 A/23.6 V (120 V) @ 40% Duty Cycle 180 A/27.2 V (230 V) @ 25% Duty Cycle
TIG (GTAW) Welding Output	130 A/15.2 V (120 V) @ 40% Duty Cycle 180 A/17.2 V (230 V) @ 30% Duty Cycle
Current Range	5 – 150 A (120 V), 5 – 240 A (230 V)
MIG Welding Voltage Range	10 – 26 V
Wire Feed Speed Range	59 – 476 ipm (1.5 – 12.1 m/min)
Open Circuit Voltage	68 V
Maximum Plate Thickness	3/8 in. (9.5 mm)
Wire Diameter Range: Mild Steel Stainless Steel Aluminum Flux Cored	 .023 – .035 in. (0.6 – 0.9 mm) .030 – .035 in. (0.8 – 0.9 mm) .030 – .045 in. (0.8 – 1.2 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
Protection Class	IP23S
Power Source Dimensions, L x W x H	23 x 9 x 16 in. (584 x 229 x 406 mm)
Power Source Weight	40 lbs. (18.2 kg)

Ordering Information	
Description	**Part Number**
Rebel EMP 215ic Multi-Process MIG/TIG/Stick Package	0558102240

All packages include power supply, Tweco Fusion 180A MIG gun, Victor argon flowgauge regulator and 12.5 ft. (3.8 m) hose, Tweco earth clamp with leads, drive rolls and contact tips, sample .030 in. (0.8 mm) wire, Tweco electrode holder and sample electrodes, 17V Style TIG torch, power adapter and operator's manual.

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Options & Accessories	
Description	**Part Number**
TIG Torch 26 V and Accessories (required for TIG welding)	W4014603
TIG Torch 17 V and Accessories, 13 ft. (4 m) 25/50 mm Dinse	W4013802
Tweco Spool Gun 160 A, 12 ft. (3.6 m) (required for Al MIG welding)	1027-1397
Electrode Holder 200A and Lead Assembly, 4 m (13 ft.), 50 mm	WS200E13 (was 1201-9577)
Ground Clamp 200 A and Lead Assembly, 3 m (10 ft.), 50 mm	WS200G10 (was 1201-9585)
Victor Argon Flow Gauge Regulator GF-250-50-580	0781-9411
Gas Hose, 3.8 m (12.5 ft.), Male 5/8-18UNF	W4013900
Foot Control, 15 ft. (4.6 m) cable and 8-pin Male Plug	W4014450
Power Adapter, 230 V to 120 V, 15 A	W4014000
Rebel Utility Cart, max 177.8 mm (7 in.) diameter cylinder	0558102325
Single Cylinder Cart, max 9 in. (228.6 mm)	W4015001

Wear & Spare Parts	
Description	**Part Number**
Velocity Nozzle 0.5 in. (12.7 mm) Bore-Flush	1220-1200
Velocity Nozzle 0.5 in. Bore-Recess	1220-1201
Tweco 42-23-15 Conduit Liner (180-250A, 023, 15FT) Steel Wound, For Steel Wire	1420-1103
Conduit Liner 0.8-0.9 mm / .030-.035 in. (installed)	1420-1113
Velocity Contact Tip, .023 in. (0.6 mm)	1110-1308
Velocity Contact Tip, .030 in. (0.8 mm)	1110-1309
Velocity Contact Tip, .035 in. (0.9 mm)	1110-1310
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, Knurled V-Groove, .030/.035 in. (0.8/0.9 mm) (FCAW)	7977732

Rebel™ EMP 215ic

Process
MIG/Flux-Cored
Stick
TIG
Material
Mild Steel
Stainless Steel
Aluminum - Spool Gun Ready
Package Features
sMIG .023-.035 in. (0.6-0.9 mm)
sMIG Extended Range .023-.045 in. (0.6-1.2 mm)
4.3 in. Color LCD/TFT Display
90–270 V Dual Voltage (extended range)
Ready-to-Weld (all accessories included – including sample filler metals)
Auto-Detect Spool Gun Capable
4 in. (100 mm) Spool Capable
8 in. (200 mm) Spool Capable
12 in. (300 mm) Spool Capable
Four Memory Settings (per process)
Multi-lingual Display
Built-In Instruction Manual and Spare Parts List
Built-In Weld Parameters
Inductance Control (MIG mode only)
Trigger Lock (2T, 4T)
Voltage Trim Adjustment (MIG mode only)
SCT (Short Circuit Termination)
Burn-Back Adjustment
Pre-flow/Post-flow Adjustment
Spot Timer Capable
Automatic Hot Start
Arc Force Adjustment
Lift Arc

When choosing a top-performing welding machine you need top-performing ESAB Filler Metals.
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XA00181621/NA/EN/14-04-21/ Note: Specifications subject to change without notice. Products may vary from those pictured.