

# Rebel™ EMP 285ic

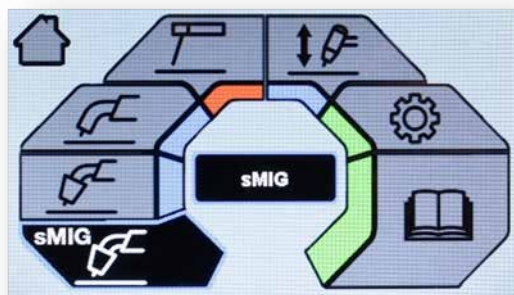
## Industrial, multi-process packages



Rebel EMP 285ic with cart and accessories.

### Industry

- Industrial General Fabrication
- Maintenance & Repair
- Industrial Production & Manufacturing
- Civil Construction
- Mechanical Contractors
- Agricultural Equipment
- Training Schools



Large 4.3 LCD - TFT Multilingual Display

Introducing Rebel™ EMP 285ic 1ph and 3ph systems, the most powerful, industrial Rebel yet for excellent performance on MIG, Flux-Cored, TIG and Stick applications. Capable of welding up to 350A, this TRUE multi-process, multi-voltage industrial welding machine runs the full range of .035 in. (0.9 mm) and .045 in. (1.2 mm) wires. It's the most portable, mobile welder in its class and has the power and performance to crush even the most demanding industrial jobs.

### Two models to choose from:

- Rebel EMP 285ic 120V-230V 1ph
- Rebel EMP 285ic 460V-575V 3ph
- Power to Perform – with 285A @ 40% (1ph model) and 285A @ 50% (3ph model) you'll have the confidence to run the full range of .045 in. (1.2 mm) wire, short arc and spray transfer, with increased deposition rates and higher productivity on smaller diameter wires such as .030 in. (0.8 mm) and .035 in. (0.9 mm).
- sMIG Technology – innovative “smart-MIG” feature that dynamically monitors the arc characteristics ultimately adapting to your technique resulting in a smooth, stable arc. Set wire diameter and plate thickness and you are ready to weld.
- With ESAB's new 4 Roll Drive System, weld up to .052 in. (1.4 mm) solid wire and up to 1/16 in. (1.6 mm) cored wire. Plus, electrodes up to 5/32 in. (4.0 mm) and TIG rods up to 3/16 in. (5.0 mm).
- Unmatched Portability/Mobility – weighing in at 70 lbs. (32 kg) with multi-voltage, multi-phase capability and 4 handle roll cage. Detach the Rebel EMP 285ic from its cart and tackle any job around the shop or out at the job site.
- TFT Multilingual Display – packed full of features, Rebel EMP 285ic 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.

# Rebel™ EMP 285ic

Specifications	
Primary Voltage	120-240 VAC 1 ph, 50/60 Hz, 460-575 VAC 3 ph, 50/60 Hz
Supply Voltage Range	90 –270 VAC
Maximum Output	300 A / 34 V (1 ph), 350 A / 34 V (3 ph)
MIG (GMAW/FCAW) Welding Output @ 104°F (40°C)	285 A / 28 V @ 40% Duty Cycle (1 ph) 220 A / 25 V @ 60% Duty Cycle (1 ph) 160 A / 22 V @ 100% Duty Cycle (1 ph) 285 A / 28 V @ 50% Duty Cycle (3 ph) 265 A / 27 V @ 60% Duty Cycle (3 ph) 200 A / 24 V @ 100% Duty Cycle (3 ph)
STICK (SMAW) Welding Output @ 104°F (40°C)	260 A / 30 V @ 40% Duty Cycle (1 ph) 210 A / 28 V @ 60% Duty Cycle (1 ph) 135 A / 25 V @ 100% Duty Cycle (1 ph) 285 A / 31 V @ 50% Duty Cycle (3 ph) 255 A / 30 V @ 60% Duty Cycle (3 ph) 180 A / 27 V @ 100% Duty Cycle (3 ph)
TIG (GTAW) Welding Output @ 104°F (40°C)	285 A / 21 V @ 40% Duty Cycle (1 ph) 240 A / 19 V @ 60% Duty Cycle (1 ph) 185 A / 17 V @ 100% Duty Cycle (1 ph) 285 A / 21 V @ 50% Duty Cycle (3 ph) 265 A / 21 V @ 60% Duty Cycle (3 ph) 220 A / 19 V @ 100% Duty Cycle (3 ph)
Current Range	5 – 300 A (1 ph), 5 – 350 A (3 ph)
MIG Welding Voltage Range	12 – 34 V
Wire Feed Speed Range	60 – 800 ipm (1.5 – 20.3 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 Flux-Cored	.023 – .052 in. (0.6 – 1.3 mm) .030 – .052 in. (0.8 – 1.3 mm) .030 – 1/16 in. (0.8 - 1.6 mm) .030 – 1/16 in. (0.8 - 1.6 mm)
Wire Spool Size	4 in. (100 mm), 8 in. (200 mm), 12 in. (300 mm)
Supply Plug	NEMA 6-50P (230 V), no plug for 3 ph unit
Lead Cord Length	10 ft. (3 m)
Approvals	CSA E60974-1-00 / UL60974-1 / IEC60974-1
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	70 lbs. (32 kg)

Ordering Information	
Description	Part Number
Rebel EMP 285ic 120V-230V 1 ph System	0558102554
Rebel EMP 285ic 120V-230V 1 ph System with Cart	0558102555
Rebel EMP 285ic 460V –575V 3 ph System	0558102556
Rebel EMP 285ic 460V –575V 3 ph System with Cart	0558102557

All packages include power supply, Tweco® Spray Master® Velocity™ MIG gun, electrode holder, Atom Arc® 7018 electrodes. 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 and operator's manual.

Cart packages also include single cylinder cart.

# Rebel™ EMP 285ic

## Options & Accessories

Description	Part Number
ESAB TXH 201 5/8 npt 12.5 ft. (3.8 m) TIG Torch Outfit	0558102493
Spray Master Velocity 250V MIG Gun, 15 ft. (4.5 m)	1023-1277
Spray Master Velocity 350V MIG Gun, 15 ft. (4.5 m)	1036-1756
Tweco 200A Spool Gun, 12 ft. (3.6 m)	1027-1398
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
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
Drive Roll V-groove for steel and stainless wires, .023/.030 in. (0.6/0.8 mm)	21155
Drive Roll V-groove for steel and stainless wires, .035/.045 in. (0.9/1.2 mm)	21156
Drive Roll V-groove for steel and stainless wires, .052 in. (1.4 mm)	21157
Drive Roll V-knurled groove for flux cored wires .030/.035 in. (0.8/0.9 mm)	21160
Drive Roll V knurled groove for flux cored wires .045-1/16 in. (1.2/1.6 mm)	21161
Drive Roll U groove for Aluminum wires 3/64-1/16in. (1.2-1.6mm)	21159
Center Guide	0558102581
Inlet guide	0558001758
Outlet Guide Tube (Solid, Flux Cored) .024 in. (0.6 mm)	0558102585
Outlet Guide Tube (Solid, Flux Cored) .030/.035 in. (0.8/0.9 mm)	0558102584
Outlet Guide Tube (Solid, Flux Cored) .045 in.(1.2 mm)	0558102582
Outlet Guide Tube (Solid, Flux Cored) .052 in. (1.4mm)	0558102583
Outlet Guide Tube (Aluminum) .030/.035 in. (0.8/0.9 mm)	0558102586
Outlet Guide Tube (Aluminum) .047 in. (1.2 mm)	0558102587
Outlet Guide Tube (Aluminum) 1/16 in. (1.6 mm)	0558102588

For Velocity Consumables see TwecoCatalogor Velocity Fact Sheet.



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XA00194221/NA/EN/11-15-17 Note: Specifications subject to change without notice. Products may vary from those pictured.