



REBEL EMP 215ic

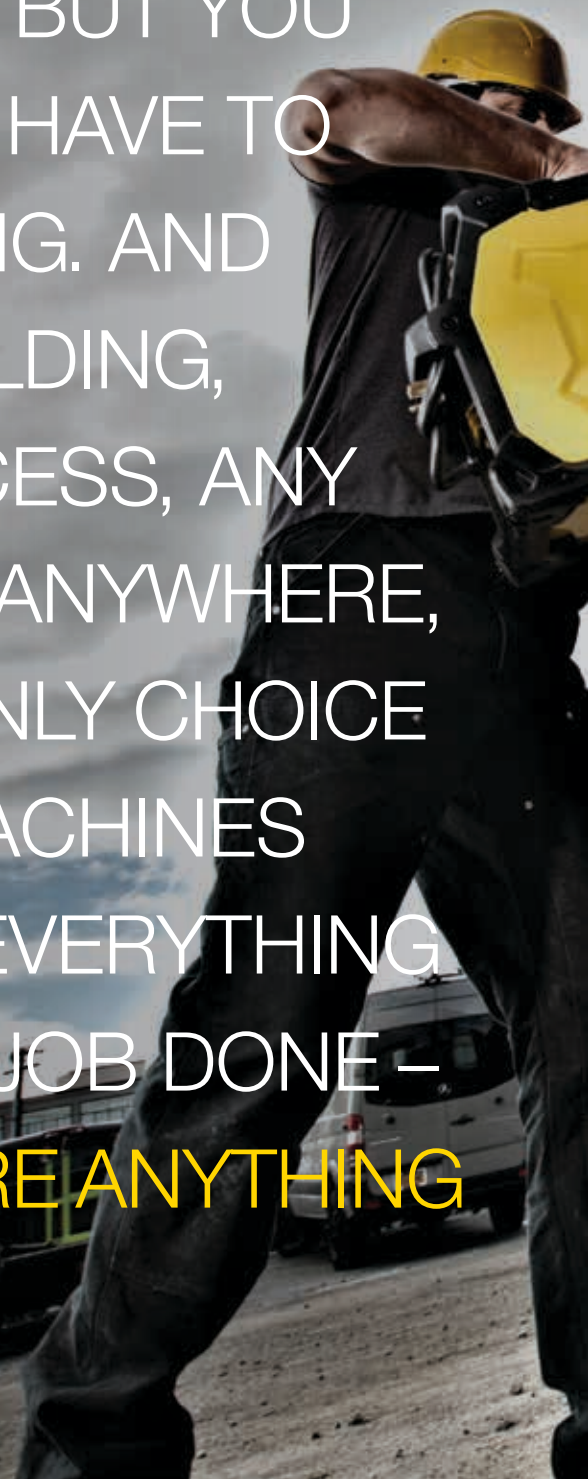
The go-anywhere, weld-anything machine

REBEL EMP 235ic

The true multi-process industrial machine

THE REBELLION IS GROWING.

YOU DON'T KNOW THE MEANING OF A TYPICAL DAY – WHAT IT'S LIKE TO WORK 9 TO 5 AT A DESK. YOU DON'T KNOW WHERE YOU'LL WIND UP ON YOUR NEXT JOB, BUT YOU DO KNOW THAT YOU'LL HAVE TO BE READY FOR ANYTHING. AND WHEN IT COMES TO WELDING, THAT MEANS ANY PROCESS, ANY POWER, ANY MATERIAL, ANYWHERE, AND EVERY TIME. THE ONLY CHOICE IS REBEL: A PACK OF MACHINES READY TO MOVE WITH EVERYTHING YOU NEED TO GET THE JOB DONE – START TO FINISH. THEY'RE ANYTHING BUT TYPICAL.





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WHAT MAKES A REBEL?

Whether you choose Rebel 215 or the bigger, badder Rebel 235, there are three truths behind every Rebel. They outperform their competitors, they stand up to whatever comes your way in the shop or out in the field, and they make your job easier. You can bet on it. We call it Rebel DNA, and it runs through each and every one of these machines.

TRUTH // HIGH PERFORMANCE.

Many machines claim they're multi-process but are little more than MIG units in disguise. Not Rebel. These are true multi-process welders, which means whether you're welding MIG, Flux-Cored, Stick – even those tricky 6010 rods – or TIG, these welders perform like they were born to run that process.

TRUTH // UNMATCHED TOUGHNESS.

You're on-site, out in the field, and in the shop. You need a machine that can go where you go and withstand the harsh environments you face. Rebel can. With a sturdy multi-handle roll cage, steel unibody construction, and IP23S-level protection, Rebel's rugged exterior gives you the confidence to go where you need to go without fear.



TRUTH // NEXT-LEVEL TECHNOLOGY.

Whether you've been welding for two years or 20, Rebel's exclusive sMIG (smartMIG) technology is sure to impress. For rookies, there's basic mode, which makes setup a breeze. For veterans, the built-in dynamic arc control constantly monitors your weld and adapts to your technique, providing a smooth, stable arc and superior, repeatable welds.

REBEL EMP 215ic: THE GO-ANYWHERE, WELD-ANYTHING MACHINE.

It's the machine that started it all by redefining what it means to be multi-process and ready-to-weld – Rebel EMP 215ic. Choose this Rebel and you'll get every piece of equipment you need to get going, no matter the process, material, or location. In addition to the multi-process system, there's also Rebel EM 215ic (MIG only) and Rebel EMS 215ic (MIG/Stick).

TRUE MULTI-PROCESS.

Rebel EMP 215ic has perfected every process, no shortcuts, no compromises, and it will make you a multi-process believer. With the 4.3-inch multi-lingual display, you can easily switch from professional-grade MIG and Flux-Cored to LiftTIG and Stick, including 6010 and 6011 cellulosic and 308L electrodes. Plus, it's even compatible with a spool gun for welding aluminum.



ADAPTABLE DUAL VOLTAGE.

Because you never know where your next job may be, you need a machine that'll run – and run well – no matter your input power. Rebel EMP 215ic runs on 120 V and 230 V single-phase input power, and it will maintain performance down to 90 V without nuisance errors. Working in the field? No problem. It runs off a 3.7 kVA (120 V) or 7.5 kVA (230 V) generator.





CRAZY SMART TECHNOLOGY.

This technology we call sMIG (smartMIG) produces less spatter, minimizes weld defects, and adapts to your technique to provide a smooth, stable arc and repeatable welds. Simply set wire diameter and plate thickness and you're ready to weld. No matter your skill level, setup is quick and easy with basic mode for beginners and advanced mode for the pros.

SELECT WIRE DIAMETER



SET MATERIAL THICKNESS



START WELDING AND sMIG DOES THE REST



REBEL EMP 215ic TECHNICAL DATA

Current Range	5–150 A (120 V); 5–240 A (230 V)
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
Max Plate Thickness	3/8 in. (9.5 mm)
Protection Class	IP23S
Approvals	CSA E60974-1-00; IEC 60974-1
Generator Size Recommendation	3.7 kVA (110 V); 7.5 kVA (230 V)
Weight	40 lb. (18.2 kg)
Dimensions (H x W x D)	16 in. x 9 in. x 23 in. (406 mm x 229 mm x 584 mm)
Warranty	3 years – handle to handle; 1 year – torch; 100% satisfaction guarantee
Industries	Light Fabrication, Repair and Maintenance, Automotive and Restoration, Mechanical Contractors, Civil Construction, Agricultural Equipment, HVAC, Training Schools

REBEL EMP 235ic: THE TRUE MULTI-PROCESS INDUSTRIAL MACHINE YOU HAVE TO SEE TO BELIEVE.

When it comes to getting around and getting work done, Rebel EMP 235ic is second to none. It's the most mobile welder in its class and has the power and performance to crush even the most demanding jobs. In addition to the multi-process system, a single-process Rebel EM 235ic (MIG only) is also available.



UNPARALLELED PORTABILITY.

Weighing in at only 53 pounds, Rebel EMP 235ic is the lightest machine in its class, which means it can go wherever you go. And that's priceless in today's demanding industries. With four perfectly placed handles and the ability to detach the power source from its cart, you're able to tackle any job, anywhere, with dual voltage capability from 90 V to 270 V.



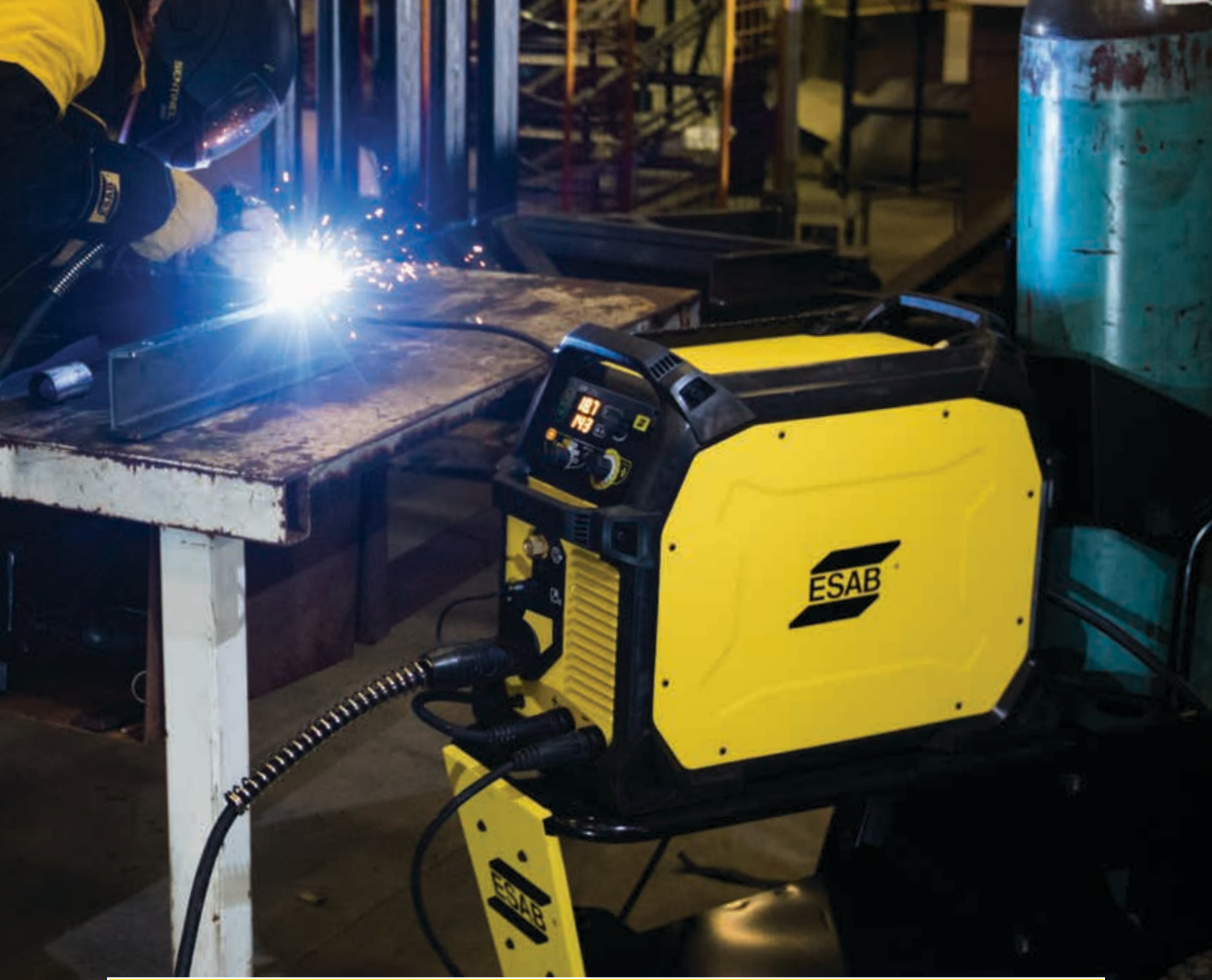
THE POWER TO PERFORM.

When it comes to portable welders, small means weak, right? Dead wrong. Rebel EMP 235ic is packed with the power to weld up to a half inch on mild steel, measuring in at 235 A at 40% duty cycle with a max output of 250 A/30 V.

VERSATILITY THAT CAN'T BE BEAT.

Rebel EMP 235ic is three machines in one – MIG, TIG, and Stick. And for welders, that means the days of having multiple machines are officially over. Your options are now open with the ability to weld a wide range of metal thicknesses and applications, including the full range of .035 in both short arc and spray arc transfer, up to .045 solid wires, and up to .052 cored wires. Plus, Rebel EMP 235ic can also weld Stick rods up to 5/32 in. and TIG rods up to 3/16 in.





REBEL EMP 235ic TECHNICAL DATA

Current Range	5–150 A (120 V); 5–250 A (230 V)
MIG (GMAW) Welding Output	120 A/19 V (120 V) @ 40% duty cycle 235 A/26 V (230 V) @ 40% duty cycle
Stick (SMAW) Welding Output	90 A/23.6 V (120 V) @ 40% duty cycle 210 A/28.4 V (230 V) @ 40% duty cycle
TIG (GTAW) Welding Output	130 A/15.2 V (120 V) @ 40% duty cycle 240 A/19.6 V (230 V) @ 40% duty cycle
Max Plate Thickness	1/2 in. (12.7 mm)
Protection Class	IP23S
Approvals	CSA E60974-1-00; UL60974-1; IEC 60974-1
Generator Size Recommendation	3.7 kVA (110 V); 7.5 kVA (230 V)
Weight	53 lb. (24 kg)
Dimensions (H x W x D)	26.5 in. x 11.5 in. x 19.5 in. (673 mm x 292 mm x 495 mm)
Warranty	3 years – handle to handle; 1 year – torch; 100% satisfaction guarantee
Industries	General Fabrication, Repair and Maintenance, Civil Construction, Mechanical Contractors, Automotive and Restoration, Farm and Ranch, HVAC, Training Schools

EVEN MORE INCREDIBLE STANDARD FEATURES.

SOLID CAST ALUMINUM FEEDER.

The design of this cast feeder mechanism increases durability, decreases wire shavings and bird nesting, provides for easy drive roll changes (no tools required), and delivers consistent feeding performance. All in all it has optimized alignment and long-life drive stand components that ensure accurate, smooth wire feeding.

LIGHTWEIGHT.

The 40-pound Rebel 215 and 53-pound Rebel 235 are easy to carry from jobsite to jobsite.



MULTI-MATERIAL.

Weld steel, stainless, and aluminum with the optional spool gun.



ADJUSTABLE INDUCTANCE.

Perfect for fine-tuning arc stability and controlling spatter.

WELD PARAMETER STORAGE.

Save up to four welding parameters per process; ideal for switching between jobs.

ADJUSTABLE BURN-BACK CONTROL.

Prevents wire from sticking in the weld pool or burning back, damaging the contact tip.

TRIGGER HOLD FUNCTION 2T/4T.

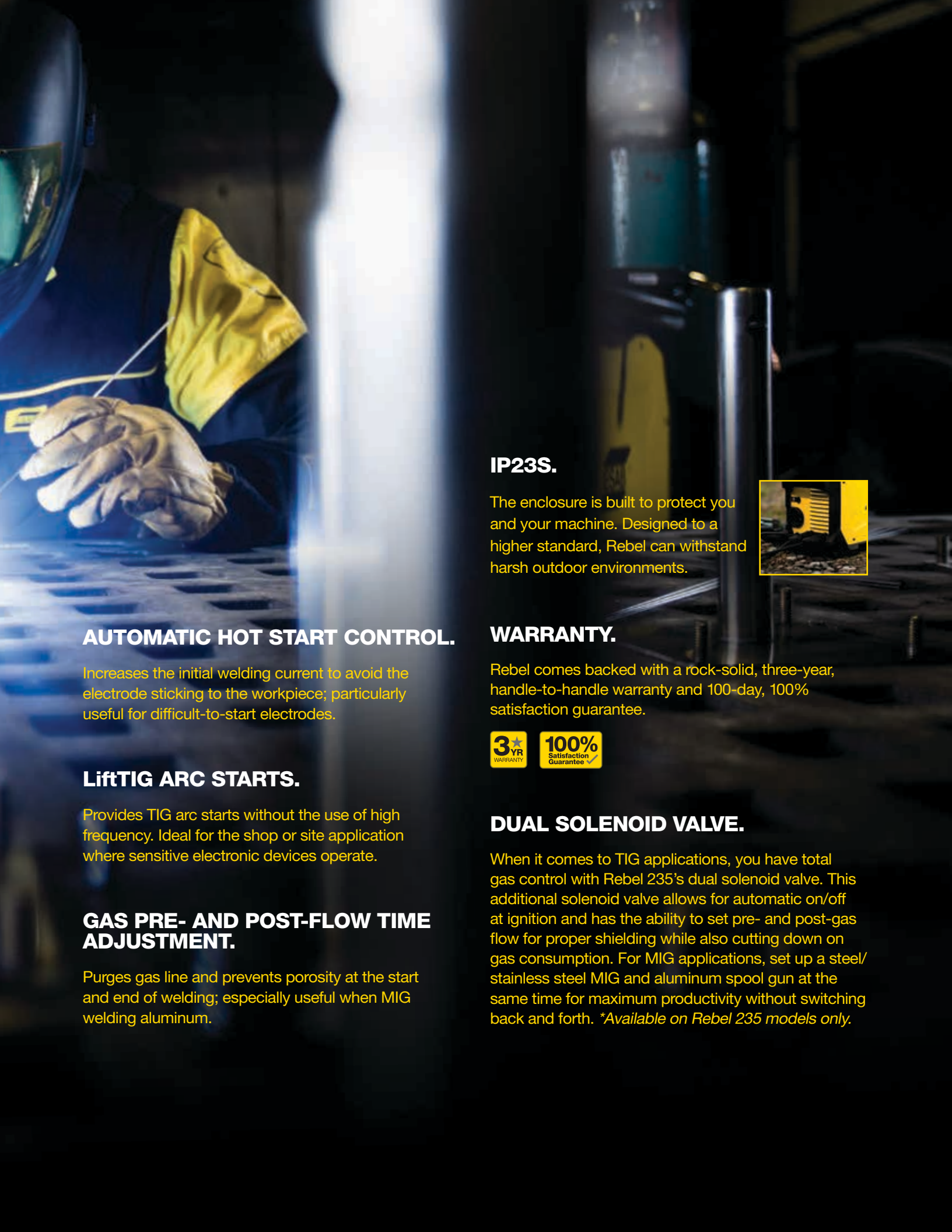
Reduces operator fatigue when MIG or TIG welding.

ADJUSTABLE ARC FORCE CONTROL.

Optimizes Stick electrode performance and allows the operator to increase the arc voltage for a short period of time to avoid arc outs and “sticking” when the arc is too short.

INFINITE VOLTAGE CONTROL.

Fine-tune the arc characteristic by adjusting the voltage setting.



AUTOMATIC HOT START CONTROL.

Increases the initial welding current to avoid the electrode sticking to the workpiece; particularly useful for difficult-to-start electrodes.

LiftTIG ARC STARTS.

Provides TIG arc starts without the use of high frequency. Ideal for the shop or site application where sensitive electronic devices operate.

GAS PRE- AND POST-FLOW TIME ADJUSTMENT.

Purges gas line and prevents porosity at the start and end of welding; especially useful when MIG welding aluminum.

IP23S.

The enclosure is built to protect you and your machine. Designed to a higher standard, Rebel can withstand harsh outdoor environments.



WARRANTY.

Rebel comes backed with a rock-solid, three-year, handle-to-handle warranty and 100-day, 100% satisfaction guarantee.



DUAL SOLENOID VALVE.

When it comes to TIG applications, you have total gas control with Rebel 235's dual solenoid valve. This additional solenoid valve allows for automatic on/off at ignition and has the ability to set pre- and post-gas flow for proper shielding while also cutting down on gas consumption. For MIG applications, set up a steel/stainless steel MIG and aluminum spool gun at the same time for maximum productivity without switching back and forth. **Available on Rebel 235 models only.*

WHAT'S INCLUDED WITH YOUR **REBEL 215.**

PACKAGE FEATURES	EM 215ic	EMS 215ic	EMP 215ic
Process			
MIG	X	X	X
Flux-Cored	X	X	X
Stick (DC)		X	X
TIG (DC)			X
Materials			
Steel	X	X	X
Stainless Steel	X	X	X
Aluminum	X	X	X
Exclusive Features			
sMIG (.023-.035)	X	X	X
sMIG Extended Range (.023-.045)			
4.3 in. Color LCD/TFT Display		X	X
90-270 V Dual Voltage (extended range)	X	X	X
Ready-to-Weld (all accessories included – including sample filler metals)	X	X	X
Auto-Detect Spool Gun Capable	X	X	X
4 in. Spool Capable	X	X	X
8 in. Spool Capable	X	X	X
12 in. Spool Capable			
Four Memory Settings (per process)		X	X
Multi-lingual Display		X	X
Built-In Instruction Manual and Spare Parts List		X	X
Built-In Weld Parameters		X	X
Inductance Control (MIG mode only)		X	X
Trigger Lock (2T, 4T)		X	X
Voltage Trim Adjustment (MIG mode only)		X	X
SCT™ (Short Circuit Termination)		X	X
Burn-Back Adjustment		X	X
Pre-flow/Post-flow Adjustment		X	X
Spot Timer Capable		X	X
Automatic Hot Start		X	X
Arc Force Adjustment		X	X
Lift Arc			X

BUNDLED ACCESSORIES	EM 215ic	EMS 215ic	EMP 215ic
Tweco Fusion 180 A MIG gun with 10 ft. (3 m) cable	X	X	X
Tweco 200 A electrode holder with 13 ft. (4 m) cable		X	X
Tweco 17 V TIG torch with 12.5 ft. (3.8 m) cable			X
Tweco 13 ft. (4 m) ground clamp with leads	X	X	X
Victor argon flowgauge regulator with 12.5 ft. (3.8 m) gas hose	X	X	X
110 V adapter plug	X	X	X
Four general purpose 6013 Stick electrodes		X	X
AristoRod 12.50 .030, 8 in., 5 lb. sample spool	X	X	X

OPTIONAL ACCESSORIES.

- Tweco Spool Gun** (Part No. 1027-1397)
 Spool Gun 160 A, 12 ft. (3.6 m) cable, suits 4 in. (100 mm) spools – required for welding aluminum



- Foot Control** (Part No. W4014450)
 Foot control contractor on/off and current control with 8-pin male plug and 15 ft. (4.6 m) cable



- Basic Utility Cart** (Part No. 0558102325)
 Utility cart accommodates maximum 7 in. (177.8 mm) diameter cylinder



- Single Cylinder Cart** (Part No. W4015001)
 Single cylinder cart accommodates up to 9 in. (228.6 mm) diameter cylinder with accessory drawer, plus one parts storage box



EVERYTHING THAT'S INCLUDED WITH YOUR **REBEL 235.**

PACKAGE FEATURES	EM 235ic	EMP 235ic
Process		
MIG	X	X
Flux-Cored	X	X
Stick (DC)		X
TIG (DC)		X
Materials		
Steel	X	X
Stainless Steel	X	X
Aluminum	X	X
Exclusive Features		
sMIG (.023--.035)	X	X
sMIG Extended Range (.023--.045)	X	X
4.3 in. Color LCD/TFT Display		X
90–270 V Dual Voltage (extended range)	X	X
Ready-to-Weld (all accessories included – including sample filler metals)	X	X
Auto-Detect Spool Gun Capable	X	X
4 in. Spool Capable	X	X
8 in. Spool Capable	X	X
12 in. Spool Capable	X	X
Four Memory Settings (per process)		X
Multi-lingual Display		X
Built-In Instruction Manual and Spare Parts List		X
Built-In Weld Parameters		X
Inductance Control (MIG mode only)		X
Trigger Lock (2T, 4T)		X
Voltage Trim Adjustment (MIG mode only)		X
SCT™ (Short Circuit Termination)		X
Burn-Back Adjustment		X
Pre-flow/Post-flow Adjustment		X
Spot Timer Capable		X
Automatic Hot Start		X
Arc Force Adjustment		X
Lift Arc		X

BUNDLED ACCESSORIES	EM 235ic	EMP 235ic
Tweco Spray Master 250 MIG gun with 15 ft. (4.6 m) cable	X	X
Tweco 200 A electrode holder with 13 ft. (4 m) cable		X
Tweco 13 ft. (4 m) ground clamp with leads	X	X
Victor argon flowgauge regulator with 12.5 ft. (3.8 m) gas hose	X	X
110 V adapter plug	X	X
Atom Arc Acclaim 7018 sample pack Stick electrodes		X
AristoRod 12.50 .035, 8 in., 11 lb. sample spool	X	X

OPTIONAL ACCESSORIES.

- **ESAB TXH 201 5/8 npt 12.5 ft. TIG Torch Outfit** (Part No. 0558102493)



- **Tweco 200 A 12 ft. Spool Gun** (Part No. 1027-1398)

- **Tweco 200 A 25 ft. Spool Gun** (Part No. 1027-1399)



- **Foot Control** (Part No. W4014450)
Foot control contractor on/off and current control with 8-pin male plug and 15 ft. (4.6 m) cable



- **Single Cylinder Cart** (Part No. 0558102491)

