

Rebel™ EM 235ic

Dual-voltage machine for MIG Welding



Rebel EM 235ic

Industry

- Industrial and General Fabrication
- Repair and Maintenance
- Civil Construction
- Automotive
- Agricultural Equipment
- HVAC

Introducing Rebel EM 235ic - the next level Rebel welding machine for MIG welding performance in a portable package. When it comes to getting around and getting work done, Rebel EM 235ic is second to none. It is the most mobile welder in its class and has the power and performance to crush even the most demanding jobs.

- Excellent performance for best-in-class MIG and Flux-Cored welding
- Unmatched Portability – weighing in at 53 lbs. (24 kg) with dual voltage capability and 4 handle roll cage. Detach the Rebel EM 235ic from its cart and tackle any job around the shop or out at the job site.
- Power to Perform – have the confidence with Rebel EM 235ic to run the full range of .035 in. (0.9 mm) wire – short arc and spray transfer. Also up to .045 in. (1.2 mm) solid wire and up to .052 in. (1.4 mm) cored wire.
- 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.

Visit esab.com for more information.



Rebel EM 235ic complete package.

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

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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
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	.023 – .035 in. (0.6 – 0.9 mm)
Stainless Steel	.030 – .035 in. (0.8 – 0.9 mm)
Aluminum	.030 – .045 in. (0.8 – 1.2 mm)
Flux-Cored	.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 EM 235ic Multi-Process Package	0558012700
Rebel EM 235ic Multi-Process Package with cart	0558012701

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, power adapter, and operator's manual.

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

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Options & Accessories

Description	Part Number
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
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

Rebel™ EM 235ic

Process
MIG/Flux-Cored
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)
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

When choosing a top-performing welding machine you need top-performing ESAB Filler Metals.
Learn more at [esab.com/fillermetals](https://www.esab.com/fillermetals) today.



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