

Handler® 210i

120/240-Volt Wire Feed Welder



403313
July 2026

120 V
240 V

Spool
Gun
Ready



500588

Includes

- 10 ft. (3 m) HR-100 MIG gun with ergonomic, rubber-padded handle
- 10 ft. (3 m) work cable with clamp
- Power cord with adapter for 120 V and 240 V
- Built-in gas solenoid valve and dual-gauge regulator with gas hose
- Extra .030 and .035 in. (0.8 and 0.9 mm) contact tips
- Quick Select™ drive roll for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire
- Material thickness gauge

Quick Specs

DC CV 1 Phase

Welding Amp Range

120 V: 30–140 A 240 V: 30–210 A

Rated Output

120 V, 15 A: 45 A at 16.3 VDC, 100% duty cycle
120 V, 20 A: 90 A at 18.5 VDC, 25% duty cycle
240 V: 210 A at 24.5 VDC, 25% duty cycle

Mild Steel Thickness Range 24 ga.–3/8 in.

5/3/1
INDUSTRIAL
WARRANTY

Dual power. Ease of Use. Superior arc at best value with 210 amps of weld output.

The Handler 210i is a powerful and versatile machine. Dual voltage input power gives you the flexibility to weld on either 120 or 240 volts. Connect to common 120-volt input power or 240-volt without the use of any tools. Simply choose the plug that fits the receptacle.

Weld as thin as 24 gauge up to 3/8 inch in a single pass with a broad output range of 30–210 amps. Easily run thicker materials with multiple passes. All while weighing only 26 pounds.

Quick and easy setup with Quick Select™ drive rolls which offer three grooves — two for different sizes of solid wire and a third for flux-cored wire.

Easy to set and adjust for different materials and thicknesses — features infinite wire and voltage control. Fine tune wire speed to each whole number and voltage to the 1/10th for maximum flexibility of operation.

Applications

- Maintenance/repair
- Boat/marine
- Metal art
- Construction
- Farm/ranch
- DIY
- Auto body

Features	Benefits
Easy-to-use interface with infinite wire speed and voltage control	Offers easier fine control of the output parameters for improved arc performance with less spatter, and better bead appearance with less clean up.
Spool gun ready	Spool guns enhance feedability and reduce “bird-nesting” associated with soft aluminum wires. No additional control box or adapter is required to connect the SpoolRunner™ 100 spool gun.
Dual-voltage	Allows connection to 120 or 240 V receptacles without tools.
Spool hub assembly accommodates 4- or 8-inch spools	Offers you flexibility to use small or large spools of wire to better suit your welding needs.
Quick Select drive roll	Makes setup quicker by offering three grooves — two for different size solid wire and a third for flux-cored wire.
Generator compatible	Will be able to operate and provide full output when powered by a generator with 9,500 watts (9.5 kW) continuous or higher output on 240 volts. Limited output will occur when used with smaller generators.
Hobart 5/3/1 industrial warranty	Five-year warranty on transformers, stabilizers and main rectifiers; three years on generators, PC boards and drive systems; and one year on guns (MIG, plasma and TIG torches).



Hobart Welding Products

An ITW Welding Company
Sales: 800-626-9420
Service: 800-332-3281

HobartWelders.com



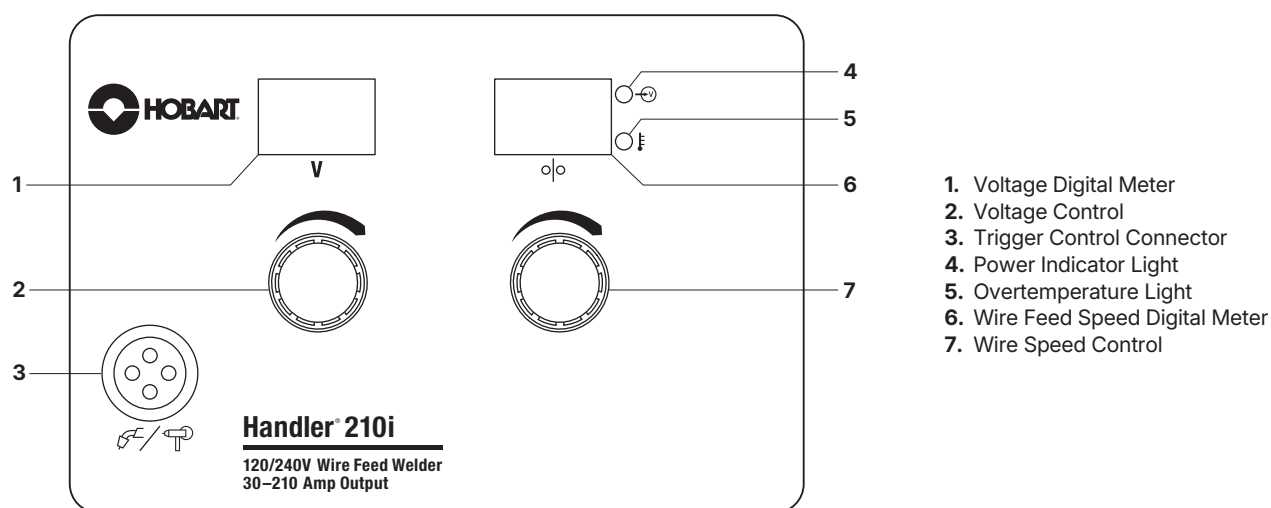
Specifications (Subject to change without notice.)



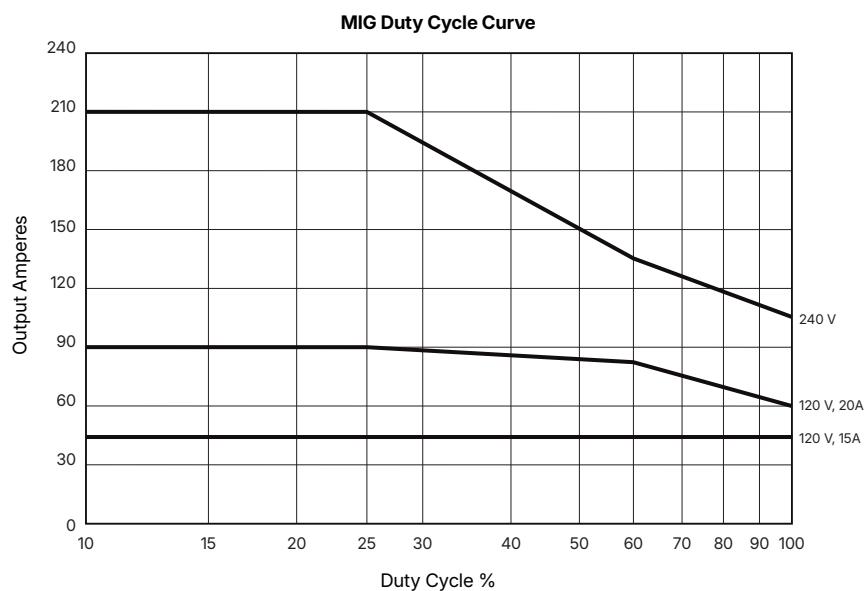
Input Power	Welding Amp Range	Rated Output	Amps Input at Rated Output, 60 Hz				Max. Open Circuit Voltage	Wire Feed Speed Range	Dimensions	Net Weight
120 V, 15 A, 50/60 Hz	30–140 A	45 A at 16.3 VDC, 100% duty cycle	13.8	—	1.66	0.91	53 VDC	60–650 ipm (1.5–16.5 m/min.)	H: 14.625 in. (371 mm) W: 9.75 in. (248 mm) D: 20 in. (508 mm)	26 lb. (11.8 kg)
120 V, 20 A, 50/60 Hz	30–140 A	90 A at 18.5 VDC, 25% duty cycle 60 A at 17.0 VDC, 100% duty cycle	27.6	—	3.31	2.03	53 VDC			
240 V, 50/60 Hz	30–210 A	210 A at 24.5 VDC, 25% duty cycle 105 A at 19.3 VDC, 100% duty cycle	—	44.3	10.63	6.15	72 VDC			

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Control Panel



Performance Data



Accessories



SpoolRunner™ 100 Spool Gun 300796

- 10 ft. (3 m) cable
- Weld 18 gauge—1/4 in. (1.2–6.3 mm) aluminum with the Handler® 210i
- Rated at 150 amps at 60 percent duty cycle
- For .023–.035 in. (0.6–0.9 mm) aluminum, steel and stainless steel wire on 4 in. (102 mm) diameter spools
- Includes rugged plastic carrying case
- Shipped with three .030 in. (0.8 mm) and three .035 in. (0.9 mm) contact tips



HR-100 Replacement MIG Gun 284546

Comes in 10 ft. (3 m) length with liner for .030–.035 in. (0.8–0.9 mm) diameter wire.

Consumables

Item	For HR-100 Gun/Power Source— Hobart Package Part #	For HR-100 Gun— Miller Package Part #	For SpoolRunner 100— Hobart Package Part #
Contact Tips			
.023/.025 in. (0.6 mm)	770174 (5 per package)	087299 (10 per package)	199730 (5 per package)
.030 in. (0.8 mm)	770177 (5 per package)	000067 (10 per package)	186419 (5 per package)
.035 in. (0.9 mm)	770180 (5 per package)	000068 (10 per package)	186406 (5 per package)
.045 in. (1.2 mm)	770183 (5 per package)	000069 (10 per package)	—
MIG Nozzle	770404	169715	186405
Gasless Flux-cored Nozzle	770487	226190	—
Tip Adapter	770402	169716	—
Liners			
.023/.025 in. (0.6 mm)	196139	194010	—
.030/.035 in. (0.8/0.9 mm)	196139	194011	—
.035/.045 in. (0.9/1.2 mm)	196140	194012	—
Power Source Drive Rolls			
Quick Select™ drive roll for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire	261157	261157	—
Dual-groove, V-knurled drive roll for .030–.035 in. (0.8–0.9 mm) and .045 (1.2 mm) flux-cored wire	202926	202926	—
SpoolRunner 100 Drive Roll			
For .023 in. (0.6 mm) wire	—	—	199731
For .030/.035 in. (0.8/0.9 mm) wire	—	—	186413
SpoolRunner 100 Push Roll			
For .023 in. (0.6 mm) wire	—	—	199732
For .030/.035 in. (0.8/0.9 mm) wire	—	—	186414

Handler® 210i Welding Guide (120/240 Volt)

The Handler 210i is capable of running the following wires: .023–.035 in. (0.6–0.9 mm) mild steel or stainless steel
.030–.045 in. (0.8–1.2 mm) flux-cored
.030–.035 in. (0.8–0.9 mm) aluminum

QR for Setup

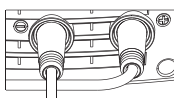
Scan this code or visit
HobartWelders.com/210isetup
to view video of
Handler® 210i setup.



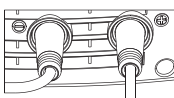
Call a Hobart
Service Technician at
1-800-332-3281

Changing Polarity

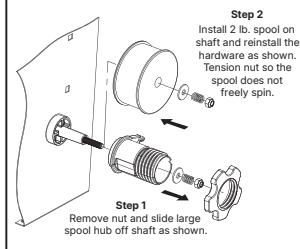
DCEP
Direct Current
Electrode Positive
for Solid Wire



DCEN
Direct Current
Electrode Negative
for Flux-Cored Wire



Installing 4 in. Wire Spool



Consumables

Contact Tips (5 per package)
770174 .023–.025 in.
770177 .030 in.
770180 .035 in.
Nozzles
770404 1/2 in. slip-type MIG
770487 Flux-cored
Insulated Liners (15 ft.)
196139 .023–.035 in. for MIG gun
196140 .035–.045 in. for MIG gun
Drive Rolls
261157 .024 in. V-groove /
.030–.035 in. V-groove /
.035 V-knurled
202926 .030–.035 in. / .045 V-knurled

Accessories

284546 HR100 MIG Gun
300796 Aluminum Spool Gun

Consumables and accessories are available
for purchase at authorized Hobart partners.

Steel Wire Welding (MIG/Flux-Cored) Parameters

Material		Polarity	Shielding Gas*	Flow Rate	Wire Size	120V										240V									
						24 ga. (V/IPM)	22 ga. (V/IPM)	20 ga. (V/IPM)	18 ga. (V/IPM)	16 ga. (V/IPM)	14 ga. (V/IPM)	1/8 in. (V/IPM)	3/16 in. (V/IPM)	24 ga. (V/IPM)	22 ga. (V/IPM)	20 ga. (V/IPM)	18 ga. (V/IPM)	16 ga. (V/IPM)	14 ga. (V/IPM)	1/8 in. (V/IPM)	3/16 in. (V/IPM)	1/4 in. (V/IPM)	5/16 in. (V/IPM)	3/8 in. (V/IPM)	
Steel	Solid Wire ER70S-6	DCEP	C25 75% Ar/ 25% CO2	25 - 45 CFH	.024"	16.2/122	16.4/137	17.3/165	17.9/228	18.8/334	19.2/437	20.0/610	20.0/650	16.2/122	16.4/137	17.3/165	17.9/228	18.8/334	19.2/437	20.0/610	20.0/650				
					.030"	15.2/66	15.6/82	16.2/102	16.7/118	17.4/169	17.6/248	18.9/295	19.0/303	15.2/66	15.6/82	16.2/102	16.7/118	17.4/169	17.6/248	18.9/295	19.0/303	21.2/421	22.2/512	22.4/551	
					.035"				15.8/78	16.0/94	16.1/118	17.0/157	17.9/185	18.1/200	15.2/60	15.3/63	15.8/78	16.0/94	16.1/118	17.0/157	18.3/220	18.5/228	20.8/303	22.8/417	23.1/437
			C100 100% CO2	15 - 30 CFH	.024"	15.8/122	15.9/161	15.9/189	19.5/299	20.6/394	21.0/520	21.0/575		15.8/122	15.9/161	15.9/189	19.5/299	20.6/394	21.0/520	21.0/575	21.0/634	22.7/401	22.8/464	23.0/488	
					.030"				17.3/90	17.8/126	18.7/165	19.4/224	19.5/252	19.6/273				17.3/90	17.8/126	18.7/165	19.4/224	19.8/287	20.0/307	22.7/401	22.8/464
					.035"				16.6/82	17.0/98	17.7/126	18.3/169	19.2/192	20.0/200	16.3/66	16.5/74	16.6/82	17.0/98	17.7/126	18.3/169	19.2/212	20.0/228	21.2/303	22.8/362	24.3/390
Stainless Steel	Stainless Steel 308L	DCEP	C2 98% Argon/ 2% CO2	25 - 45 CFH	.024"				16.8/244	18.0/378	19.0/468					16.8/244	18.0/378	19.0/468	21.3/650	20.5/600					
					.030"				16.2/141	17.2/228	17.8/311					16.2/141	17.2/228	17.8/311	19.8/421	20.1/453	21.1/614				
					.035"										15.1/110	16.6/173	17.0/204	18.0/267	18.1/279	20.0/267	20.1/405				
Steel	Flux-Cored E71T-11	DCEN	No Shielding Gas		.030"				15.0/78	16.5/185	18.0/260	20.3/311	20.7/358				15.0/78	16.5/185	18.0/260	20.7/407	21.2/423	23.5/606			
				.035"				15.0/63	16.3/94	16.3/149	18.8/200	20.1/203				15.0/63	16.3/94	16.3/149	18.5/216	20.1/252	22.0/338	23.3/464	23.5/500		
				.045"												16.5/78	18.5/110	20.0/122	21.5/173	22.0/189	23.0/228				

Aluminum Wire Welding Parameters (With Optional SpoolRunner)

Aluminum	ER4043	DCEP	100% Argon	35–45 CFH	.030"				13.8/267	14.1/295	14.7/346	18.5/417					13.8/267	14.1/295	14.7/346	18.5/417	20.8/425	21.8/539		
					.035"												13.2/189	13.6/220	14.0/287	18.4/350	21.0/363	22.2/437		
					.030"				12.7/240	13.3/295	14.9/417	19.8/575					12.7/240	13.3/295	14.9/417	19.8/575	21.5/622	22.0/650		
					.035"						15.0/346	18.8/429							15.0/346	19.0/470	19.3/473	21.4/606		

* Please see Owner's Manual for detailed information on welding gas selection and mixtures.

NOTE: Settings are approximate. Adjust as required.

Typical Installation for Optional SpoolRunner™ 100 Spool Gun to Handler® 210i

It's quick and easy to install the SpoolRunner 100 spool gun on the Handler 210i. Just plug the power pin of the spool gun into the feedhead and attach the trigger lead for spool gun operation. Install the correct wire and gas for the job and it's ready to go.

