

# IronMan™ 240

## Complete Single-Phase MIG Welding Package



287788  
Dec. 2020

208 V  
240 V

Spool Gun Ready



**NEW!**  
500574

### Quick Specs

DC CV 1 Phase

#### Welding Amp Range

30–280 A

#### Rated Output

200 A at 24 VDC, 60% duty cycle

#### Mild Steel Thickness Range

24 ga.–1/2 in.

**5/3/1**  
INDUSTRIAL WARRANTY

### Outperforms the competition on arc quality, voltage control and value.

Whether you're a professional or just want to weld like one, the IronMan 240 is unmatched in its class. It delivers 30 to 280 amps of pure power with an arc optimized to deliver a flawless weld, making spatter and post-weld cleanup almost nonexistent. Weld as thin as 24 gauge up to 1/2 inch (13 mm) mild steel.

The dual-gear wire drive system with aluminum housing delivers 50 to 700 ipm wire feed speed.

Reversible drive roll (two grooves for two wire sizes on one drive roll) decreases spare parts and changeover time.

Easy to set and adjust for different materials and thicknesses — features infinite voltage and wire feed for finer control, less spatter and cleaner welds.

#### Applications

- Maintenance/repair
- Auto body
- Manufacturing
- Construction
- Farm/ranch
- Metal art

#### Includes

- 15 ft. (4.6 m) MIG gun
- 10 ft. (3 m) work cable with clamp
- Power cord with plug
- Regulator/flow gauge with 5 ft. (1.5 m) gas hose
- .030 and .035 in. contact tips
- Dual-groove .030/.035 in. drive roll
- Built-in running gear/cylinder rack

Features	Benefits
<b>Infinite voltage and wire feed</b>	Offers easier fine control of the output parameters for improved arc performance with less spatter for a better bead appearance and less clean up.
<b>Spool gun ready</b>	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™ 200 spool gun.
<b>Run-in technology</b>	Experience smooth, spatter-free starts — the run-in feature automatically slows the wire feed speed to a pre-set speed prior to arc initiation, improving arc starts.
<b>Reversible drive roll (two grooves for two wire sizes on one drive roll)</b>	50 percent less stocking of drive rolls. Standard one-piece drive roll decreases spare parts and changeover time, reducing overall costs.
<b>Spool hub assembly accommodates 2-, 10-, 33- and 45-pound spools</b>	Changing wire spools is a snap with the toolless brake tension knob.
<b>Hinged door panel</b>	Provides easy access for spool and drive roll changes, increasing productivity and operator appeal.
<b>Fan-On-Demand™</b>	Cooling system operates only when needed reducing power consumption and contaminants drawn into the machine.
<b>Hobart 5/3/1 industrial warranty</b>	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.)

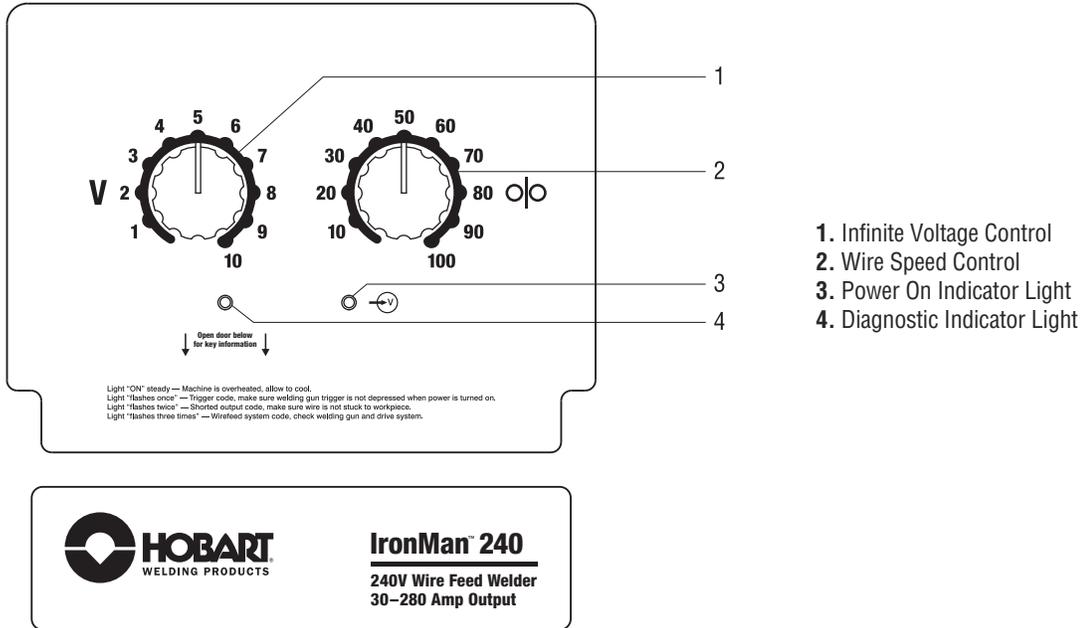


Welding Amp Range	Rated Output	Amperes Input at Rated Load				Open Circuit Voltage	Wire Feed Speed Range	Dimensions	Net Weight
		208 V	240 V	KVA	KW				
30–280 A	200 A at 24 VDC, 60% duty cycle	57.0	50.8	11.4	7.1	40 VDC	50–700 ipm (1.3–17.8 m/min.)	H: 30 in. (762 mm) W: 19 in. (483 mm) D: 40 in. (1,016 mm)	186 lb. (84 kg)

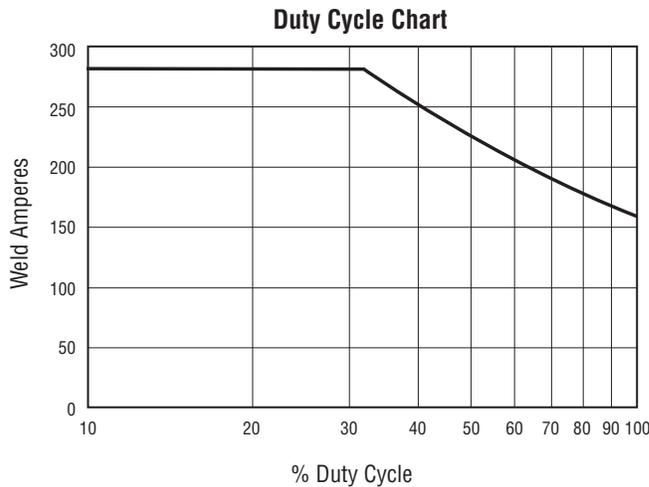
Note: Running off of generator power is not recommended for the IronMan 240. Operating temperature range: -4° to +104°F (-20° to +40°C)

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

## Control Panel



## Performance Data



## Accessories



### Protective Cover 770973

Form-fitted, vinyl-laminated, polyester fabric resists stains and mildew and protects the finish of your welder.



### Reversible V-Groove Drive Rolls for Mild Steel Wire

**235286** .030/.035 in. (0.8/0.9 mm)

**235287** .023 and .045 in. (0.6–1.1 mm)

### Reversible V-Knurled Drive Rolls for Flux-cored Wire

**132958** .035 in. (0.9 mm)

**132957** .045 in. (1.2 mm)

## MIG Gun and Accessories

### HR-200 Replacement MIG Gun 284973

Comes in 15 ft. (4.6 m) length with liner for .023–.045 in (0.6–1.1 mm) wire. Gun rated at 200 amps at 60 percent duty cycle using CO<sub>2</sub> gas or mixed gas.

**Contact Tips** (See chart on below)

**Nozzles** (See chart below)

**Adapter** (See chart below)



**Replacement Liners** (See chart below)

## Spool Gun and Accessories



### SpoolRunner™ 200 Spool Gun 770967

Spool gun with 4-inch spool and 20-foot cable assembly. Rated at 200 amps at 60 percent duty cycle. When combined with IronMan 240, this spool gun welds with .030–.035 inch wire on 16-gauge to 1/2-inch thick aluminum.



### Contact Tips (5 per package)

**199387** For .030 in. (0.8 mm) wire.

**199388** For .035 in. (0.9 mm) wire.

**199389** For .047 in. (1.2 mm) wire.



**Nozzle 050622**

### Standard Replacement Drive Roll

**243452** .030/.035 in. (0.8/0.9 mm)

### Optional VK Drive Roll

**136135** .030–.047 in. (0.8–1.2 mm)

Recommended for running .047 in. (1.2 mm) wire on SpoolRunner 200.

## MIG Gun Consumables

Item	Hobart Package Part #
<b>Contact Tips</b>	
.023/.025 in. (0.6 mm)	<b>770174 (5 per package)</b>
.030 in. (0.8 mm)	<b>770177 (5 per package)</b>
.035 in. (0.9 mm)	<b>770180 (5 per package)</b>
.045 in. (1.2 mm)	<b>770183 (5 per package)</b>
<b>Flush Nozzle</b>	
1/2 in. (12.7 mm) orifice flush	<b>770544</b>
5/8 in. (16 mm) orifice flush	<b>770405</b>
<b>Tip Adapter</b>	
	<b>770403</b>
<b>Replacement Liners</b>	
.023/.025 in. (0.6 mm)	<b>196139</b>
.030/.035 in. (0.8/0.9 mm)	<b>196139</b>
.035/.045 in. (0.9/1.2 mm)	<b>196140</b>

## Typical Installation for Optional SpoolRunner™ 200 Spool Gun to IronMan™ 240

It's quick and easy to install the SpoolRunner 200 spool gun on the IronMan 240. Just plug the power pin of the spool gun into the feedhead, and attach the trigger lead. Install the correct wire and gas for the job and it's ready to go.

