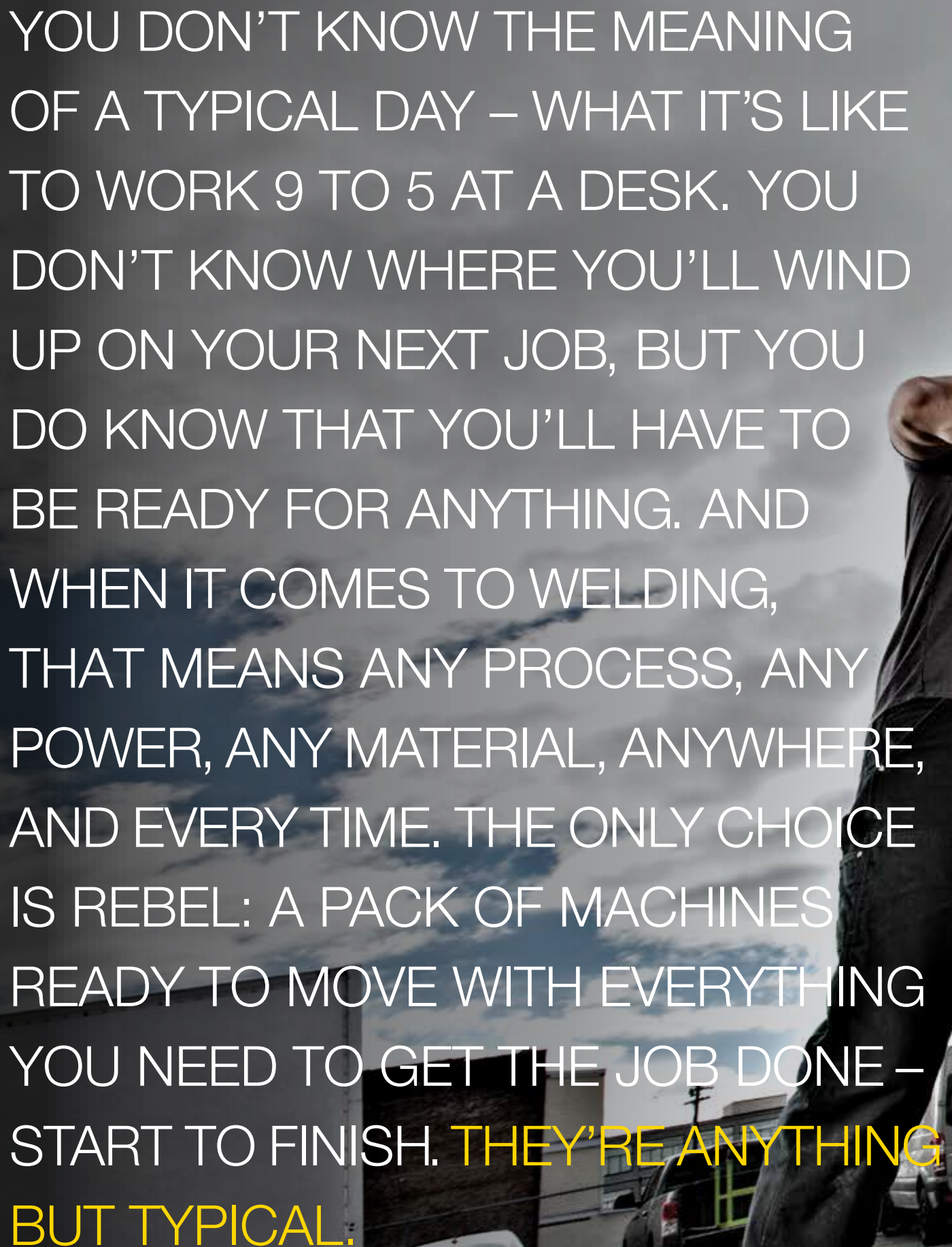




**REBEL** EMP 235ic  
**THE REBELLION IS GROWING.**

Ver. 2.0





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.**





# WHAT MAKES A REBEL?

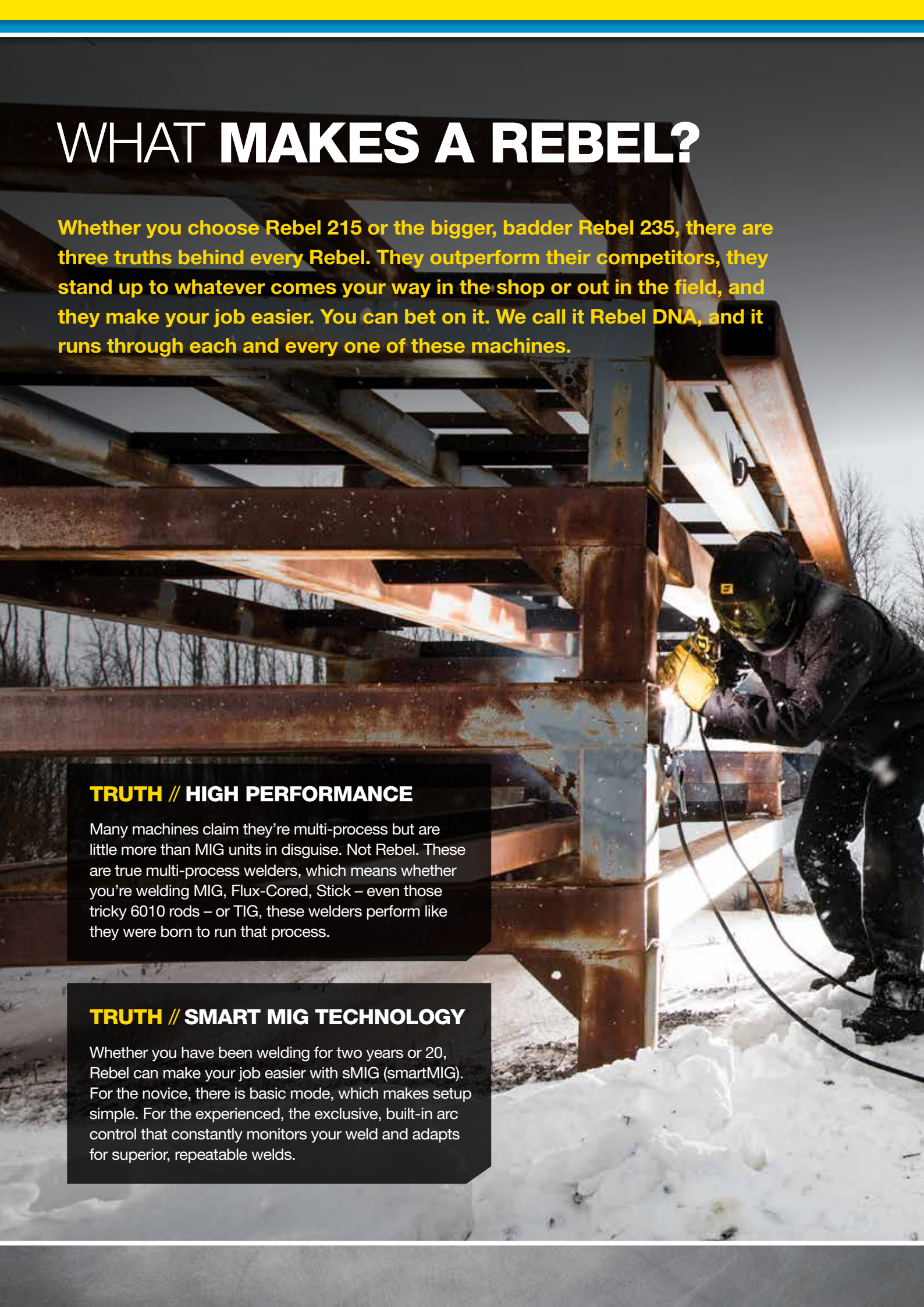
Whether you choose Rebel 215 or the bigger, badder Rebel 235, there are three truths behind every Rebel. They outperform their competitors, they stand up to whatever comes your way in the shop or out in the field, and they make your job easier. You can bet on it. We call it Rebel DNA, and it runs through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

Whether you have been welding for two years or 20, Rebel can make your job easier with sMIG (smartMIG). For the novice, there is basic mode, which makes setup simple. For the experienced, the exclusive, built-in arc control that constantly monitors your weld and adapts for superior, repeatable welds.







### **TRUTH // VERSATILITY**

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.

### **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 // THE TOTAL PACKAGE**

It takes more than a machine to get up and welding. So when you buy a Rebel, you can expect all the equipment you need to get going – right out of the box.



# THE MOST INCREDIBLE MACHINE ON-SITE.

## TRUE MULTI-PROCESS.

- Professional-grade MIG performance, including flux-cored
- Excellent MMA performance, including stainless steel, 6010 and 6011 cellulosic and 308L electrodes
- Exceptional lift TIG performance down to 5A
- Compatible with the Tweco SGT 250 spool gun for precision aluminium welding



## DUAL VOLTAGE.

- 120V–230V single-phase input power
- Top-level performance across all processes – even on 120V power
- Auto-detect knows what type of input power the machine's connected to
- Runs off a 4kW (120V) or 8kW (230V) generator



## LARGE, 4.3-IN. (86MM) COLOUR SCREEN.

- Intuitive LCD/TFT display
- Well protected by front handles and a hefty composite bezel
- Easily switch from one process to the next
- Built-in on-screen manual, spare parts listing, trouble shooting and welding parameters guide
- Multi-lingual capabilities

## RUGGED CASE DESIGN.

- Four perfectly placed handles that act as a roll cage while enabling versatile handling for easy transportation. Just detach the power source from its cart and you're able to tackle any job, anywhere.
- Steel unibody housing for increased protection and superior durability.
- Recessed body panels for increased strength
- IP23S rating for Indoor and Outdoor use



## sMIG TECHNOLOGY.

This technology we call sMIG (smartMIG) is an exclusive, built-in dynamic arc control that constantly monitors your weld and complex arc characteristics to produce less spatter and minimise weld defects while adapting to your technique to provide a smooth, stable arc and repeatable welds.

sMIG will modify your operating voltage during welding, taking in to consideration plate heat, operator position and stick out to ensure you maintain the optimum duty cycle ratio.

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.

Basic mode reduces the MIG learning curve – set wire diameter and material thickness and you are ready to weld

Advanced mode gives full control to adjust the arc characteristics to your liking

### READY-TO-WELD.

- TWECO Fusion 250 MIG Torch, 3m
- Electrode Holder Kit, 3m
- Work Lead, 3m
- Gas Hose including quick connector, 4.5m
- 200mm Spool OK AristoRod 12.50, 0.9mm wire
- Feed Rolls and Contact tips to suit



### SELECT WIRE DIAMETER



### SET MATERIAL TYPE AND THICKNESS



### START WELDING AND sMIG DOES THE REST





# THE DRIVE TO DO IT ALL.



## **SOLID CAST ALUMINIUM 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 optimised alignment and long-life drive stand components that ensure accurate, smooth wire feeding.

## **THE POWER TO PERFORM.**

When it comes to portable welders, the Rebel EMP 235ic is packed with the power to weld up to a half inch on mild steel, measuring in at 235A at 20%

You have the ability to weld a wide range of metal thicknesses and applications, including the full range of 0.9 in both short arc and spray arc transfer, up to 1.0 solid wires, and up to 1.2 cored wires. Plus, Rebel EMP 235ic can also weld Stick rods up to 4mm and TIG rods up to 4.8mm

## **MULTI-MATERIAL.**

Weld steel, stainless, and even aluminium.

## **WELD PARAMETER STORAGE.**

Save up to 20 memory locations - four welding parameters per process; ideal for switching between jobs..

## **TRIGGER HOLD FUNCTION 2T/4T.**

Reduces operator fatigue when MIG or TIG welding.

## **INFINITE VOLTAGE CONTROL.**

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

## **ADJUSTABLE INDUCTANCE.**

Perfect for fine-tuning arc stability and controlling spatter.

## **ADJUSTABLE BURN-BACK CONTROL.**

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

## **ADJUSTABLE ARC FORCE CONTROL.**

Optimises 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.





## ADJUSTABLE HOT START CONTROL.

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

## LIFT TIG 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 aluminium.

## IP23S.

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

## VRD.

Standards compliant Voltage Reduction Device  
Virtually eliminates electric shocks when not welding (Stick Mode).

## WARRANTY.



Rebel comes backed with a rock-solid, three-year, handle-to-handle warranty.

## DUAL SOLENOID VALVE.

There are two gas solenoid valves - one for MIG and spool gun, and the other for TIG.

When it comes to TIG applications, you have total gas control with this additional solenoid valve, allowing for automatic on/off at ignition and the ability to set pre- and post-gas flow for proper shielding while also cutting down on gas consumption.





# GET TO KNOW YOUR REBEL EMP 235ic.

## PROCESS

MIG/MAG and Flux-Cored  
MMA  
Lift TIG

## REBEL FEATURES

sMIG (Intelligent Arc Feedback and Arc Control)  
230V/120V Dual Voltage Input  
Automatic Hot Start (MMA mode only)  
Automatic Arc Force (MMA mode only)  
Lift Arc (TIG mode only)  
Voltage Trim Adjustment (MIG mode only)  
Inductance Adjustment (MIG mode only)  
Burn Back Adjustment (MIG mode only)  
Pre-Flow/Post-Flow Adjustment (MIG mode only)  
Spot Weld  
Up Slope / Down Slope  
Trigger Lock (2T, 4T)  
Over Temp Cut Out  
Anti-Stick  
SCT (Short Circuit Termination)  
PFC (Power Factor 0.98)  
VRD <35DC (Voltage Reduction Device)  
2 Separate Gas Lines (TIG & MIG)  
Euro Torch Connection  
Spool Gun Ready (Compatible with Tweco SGT250 Spool Gun)  
Suitable for 100-300mm Spools  
Robust casing with 4 Handle Roll Cage  
IP23S (Indoor and Outdoor use)  
4.3-in. (86 mm) Colour LCD/TFT Display  
On-Screen Setup Diagrams  
On-Screen Manual & Spare Parts  
On-Screen Weld Chart Parameters  
On-Screen Trouble Shooting Guide  
Weld Parameter Storage  
Multi-Lingual  
Basic and Advanced Options  
Ready-to-Weld (accessories included – including sample filler metals)

## MATERIAL

Mild Steel  
Stainless Steel  
Aluminium

## ORDERING INFORMATION

Tweco Fusion 250 MIG Torch (Euro), 3m	W4013701
Stick electrode holder with 3m lead	0700006900
Work Lead, 3m	0700006901
Nozzle 13mm	OTW22/50
Nozzle 16mm	OTW22/62
Contact Tip 0.6mm	OTW14/23
Contact Tip 0.8mm	OTW14/30
Contact Tip 0.9mm	OTW14/35
Contact Tip 1.0mm	OTW14/40
Contact Tip 1.2mm	OTW14/45
Insulator	OTW32
Gas Diffuser	OTW52
Liner 0.8-0.9mm Hard Wire	OTW42/3035
Liner 1.0-1.2mm Hard Wire	OTW42/4045
Liner 0.9-1.2mm Soft Wire	OTW42N/3545
Wire Outlet Guide - Steel Fe/SS/Flux Cored: 1.0-1.2mm	0464635880
Wire Outlet Guide - Steel Fe/SS/Flux Cored: 0.6-0.8mm	0464634880
Wire Outlet Guide - Teflon Aluminium: 1.0-1.2mm	0464598880
Wire Inlet Guide Fe/SS/Flux Cored: 0.6/0.8/0.9/1.2mm	0558102328
Feed Roll 'V' Groove Fe/SS: 0.6/0.8mm	7977036
Feed Roll 'V' Groove Fe/SS: 0.9/1.2mm	7977660
Feed Roll 'V' Knurled Flux Cored: 0.8/0.9mm	7977732
Feed Roll 'V' Knurled Flux Cored: 1.0/1.6mm	704277
Feed Roll 'U' Groove Aluminium: 0.8/0.9mm	7977731
Feed Roll 'U' Groove Aluminium: 1.0/1.2mm	7977264

## TECHNICAL DATA

Current Range	5-150A (120V), 5-240A (230V)
Supply Lead	15A (230V)
Effective Input Current (I <sub>1eff</sub> )	14.7A (230V)
Maximum Input Current (I <sub>1Max</sub> )	32.1A (230V)
MIG Welding Output, 40°C, 10min (230V)	235A @ 20%, 25.8V 130A @ 100%, 20.5V
Stick Welding Output, 40°C, 10min (230V)	210A @ 20%, 28.4V 110A @ 100%, 24.4V
TIG Welding Output, 40°C, 10 min (230V)	235A @ 35%, 19.4V 160A @ 100%, 16.4V

## TECHNICAL DATA

Max Plate Thickness	12mm
Max Wirefeed Speed	17.8mpm
Wire Sizes	M/S 0.6-1.0mm, S/S 0.8-1.0mm, AL/FC 0.8-1.2mm
Protection Class	IP23S
Approvals	IEC/EN 60974-1, 5, 7, 10, 12, 13. RoHS
Rec. Generator Size	8kW (230V); 4kW (120V)
Weight	30kg Power Source / 48kg Plant
Dimensions	(H 495mm x W 292mm x D 686mm)
Warranty	3 Years – handle to handle



**DARE // MAKE THE MOVE TO ESAB. PICK UP THE MOST INCREDIBLE GO-ANYWHERE, WELD-ANYTHING MACHINE. FIND OUT MORE AT [ESAB.COM/REBEL](http://ESAB.COM/REBEL).**

<b>ESAB REBEL EMP 235ic PACKAGE INCLUDES:</b>	<b>0700303880</b>
REBEL EMP 235ic Power Source	
Tweco Fusion 250 MIG Torch (Euro), 3m	
CIGWELD COMET Professional Argon Regulator/Flowmeter	
Gas hose includes quick connector, 4.5m	
Stick electrode holder with 3m lead	
Work Lead, 3m	
OK AristoRod 12.50, 200mm Spool, 0.9mm wire, 5kg (1A5009460H)	
Contact Tips for 0.8 / 0.9 / 1.0mm	
Drive Rolls: 0.9/1.2mm V Groove (fitted), 0.8-1.0mm V Groove, 0.8/0.9mm V Knurled	
Guide tube 1.0-1.2mm (fitted), 0.6-0.8mm (spare), Aluminium Guide Kit	
Brake Assembly Spacer for 100mm spools	
Material Thickness Guide	
USB with Instructional Manual	



## OPTIONAL ACCESSORIES.

**TIG Torch TXH 202, 4m with 8-Pin Plug**  
(0700300857)



**Foot Control** for TIG applications,  
4.5m cable (W4014450)



**Tweco SGT250 Spool Gun**  
(W4011250)



**Rebel Single Cylinder Trolley**  
(0558102491)



**Sentinel A-50 Welding Helmet**  
(0700000800)



**Tweco Organiser Box**, consumables  
for Fusion 150/250 MIG Torches and  
SGT250 Spool Gun (W4012300)



**Sentinel A-50 Air with Aristo Ait PAPR**  
(0700000826)



### A Complete Line of Filler Metals Including:

- **Solid Wire**  
OK Aristorod 12.50
- **Stainless Steel**  
OK Autrod 309LSi  
OK Autrod 316LSi
- **Cored Wire**  
Coreshield 15  
OK Tubrod 15.15
- **MMA Electrodes**  
OK 46.00  
OK 63.30  
OK 53.16







# UNRIVALED SERVICE AND SUPPORT.

Rebel, like every ESAB machine, is backed by our commitment to superior customer service and support. Our skilled customer service department is prepared to quickly answer any questions, address problems, and help with maintenance and upgrading of your machines.

With ESAB, you can be sure that you purchased a machine that will meet your needs today and in the future. Product and process training is also available. Ask your ESAB sales representative or distributor for a complete ESAB solution.

**For more information, visit [esab.com/dare](http://esab.com/dare).**

## 3-YEAR WARRANTY.

ESAB's industry-leading service and support means that if you do need help, you will be protected by the most comprehensive warranty in the business.



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