



PROCESSES



Flux Cored (FCAW) Welding



MIG (GMAW) Welding
(with optional MIG Kit)



Handler 125

5/3/1 INDUSTRIAL WARRANTY

MADE IN **USA**

The Handler 125 is a rugged constant-voltage DC welder with built-in wire feeder, that operates off 115-volt household current. It comes ready to weld, without shielding gas, using .030-.035 in. (0.8-0.9 mm) self-shielding flux cored wire. This is a great unit for outdoor applications when shielding gas could be blown away. Welds up to 3/16 in. steel with flux-cored wire.

For greater versatility, install an optional MIG Conversion Kit. Unit with kit installed can weld with .023-.030 in. (0.6-0.8 mm) solid wire and gas

shielding. Use C-25 gas (75% Argon/25% CO₂) on 22 gauge - 1/8 in. steel for a cleaner weld with less spatter. Use Tri-Mix gas and stainless wire for welding on 16-12 ga. stainless steel.

Comes Complete With:

- Comfortable H-9B gun, 8 ft. (2.4 m) with liner for .023-.035 in. (0.6-0.9 mm) diameter wire
- .030 in. (0.8 mm) contact tips
- Work clamp and cable
- Sample spool of .030 in. (0.8 mm) self-shielding flux cored wire
- Spool shaft to accommodate 4 in. spools. (Optional hub kit available for 8 in. spools.)
- Power cord with plug
- Weld set-up chart
- Owner's manual with parts lists, installation, operation, maintenance and wire welding guidelines

Applications

- Farm/Home
- Light Maintenance and Repair
- Light Fabrication

FEATURES

BENEFITS

| | |
|--|---|
| Broad output range of 30 - 125 A | Allows you to weld up to 3/16 in. steel with flux cored wire. |
| Four output voltage settings with wire feed speed tracking | Provides a broader operating window for each wire, with quick and easy adjustment for different thicknesses and joints. |
| Built-in contactor | Eases use and excellent safety feature which makes wire electrically "cold" until trigger is pulled. |
| Durable feed head with quick-release drive roll tension lever | Positive feed with adjustable tension plus easy accessibility to thread new wire. |
| Dual-groove quick-change drive roll | Makes it easy to change from one wire size to another. One knurled groove for .030-.035 in. (0.8-0.9 mm) wire, and one smooth groove for .023/.025 in. (0.6 mm) wire. |
| Short circuit protection | Protects unit against current overload. |
| Self-resetting thermal overload | Protects power transformer to ensure reliability. |
| Self-resetting motor protection | Protects wire feed system from overload, no fuses to change or circuit breaker buttons to reset. |
| Upgradeable for welding with gas | Easy-to-install MIG Conversion Kit available. |
| Hobart's 5/3/1 Industrial Warranty | Five-year warranty on transformers, three years on electronics (drive motors, rectifiers) and one year on guns. |

SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

DC **CV** **1**
Phase

| Rated Output | Current Range | Max. Open-Circuit Voltage | Wire Feed Speed Range | Amps Input at Rated Output, 60 Hz, 1-Phase | | | Dimensions | Net Weight |
|---------------------------------|---------------|---------------------------|--|--|------|-------|---|--------------------|
| | | | | 115 V | KVA | KW | | |
| 90 A, 19 VDC, at 20% Duty Cycle | 30 - 125 A | 29 V | 0-415 IPM (0-11 MPM) 0-500 IPM (0-13 MPM) at no load | 20 | 2.9 | 2.5 | H: 16-7/8 in. (429 mm) W: 9-7/8 in. (251 mm) D: 12-1/8 in. (308 mm) | 50 lb (22.7 kg) |
| 63 A, 21 VDC at 20% Duty Cycle* | | | | 15* | 2.2* | 1.77* | | |

*CSA rating.

Certified to both the Canadian and U.S. Standards for welding equipment.



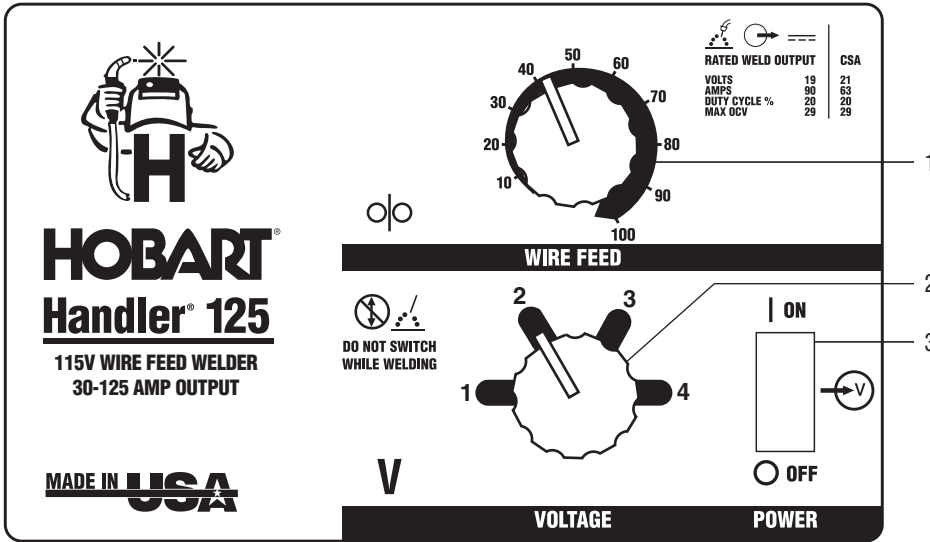
Hobart Welders An Illinois Tool Works Company

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International Sales Phone 920-735-4509 FAX 920-735-4125

Web Site HobartWelders.com



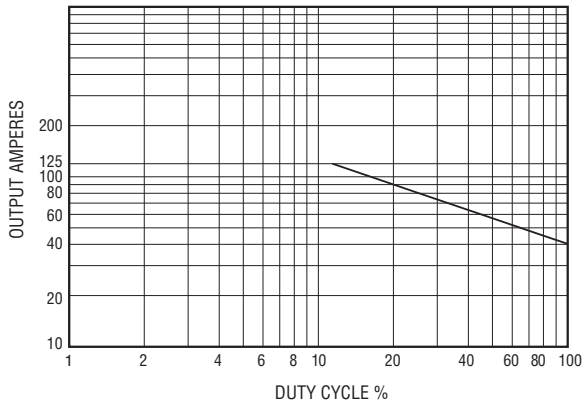
CONTROL PANEL



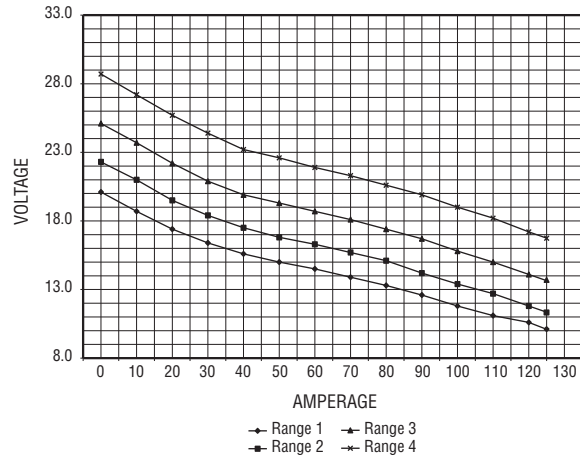
1. Wire Speed Control
2. Voltage Control Switch
3. Power Switch

PERFORMANCE DATA

DUTY CYCLE CURVE



VOLT/AMP CURVE



ACCESSORIES



MIG Conversion Kit #195158

Includes regulator, 5 ft. (1.5 m) gas hose, solenoid valve and connecting leads, hose adapter, three .023/.025 in. contact tips, one spool of .024 in. (0.6 mm) ER70S-6 solid wire, and installation instructions.

Hub Kit #195216

For using 8 in. (51 mm) spools.

Replacement Drive Roll

Hobart #212379R

Miller #212 379

Dual-groove, one smooth groove for .023/.025 in. (0.6 mm) wire and one knurled groove for .030-.035 in. (0.8-0.9 mm) wire.



Small Running Gear/Cylinder Rack #194776

Durable construction. For gas cylinders no larger than 7 in. (178 mm) diameter, maximum weight 75 lb. (34 kg).



Protective Cover #195186

Weather-resistant nylon resists stains and mildew, and protects the finish of your welder.

H-9B Replacement MIG Gun

Hobart #195157R

Miller #225 397

Comes in 8 ft. (2.4 m) length with liner, for .023-.035 in. (0.6-0.9 mm) diameter wire.



Contact Tips
(See chart below)



MIG Nozzle
(See chart below)
Protects tip adapter and focuses gas coverage.



Gasless Flux Cored Nozzle
(See chart below)

For use with self-shielding flux cored wires. Improves visibility, eases access in tight corners, protects tip adapter/gas diffuser from spatter and from shorting to the work piece. Usable with H9, H10, M10, and M15 torches.



Tip Adapter
(See chart below)



Replacement Liner
(See chart below)

CONSUMABLES

| Item | Hobart Package Part #* | Miller Package Part #** |
|----------------------------------|-------------------------|---------------------------|
| Contact Tips | | |
| .023/.025 in. (0.6 mm) | #770174 (5 per package) | #087 299 (10 per package) |
| .030 in. (0.8 mm) | #770177 (5 per package) | #000 067 (10 per package) |
| .035 in. (0.9 mm) | #770180 (5 per package) | #000 068 (10 per package) |
| Replacement Drive Roll | #212379R | #212 379 |
| MIG Nozzle | #770404 | #169 715 |
| Gasless Flux Cored Nozzle | #770487 | #226 190 |
| Tip Adapter | #770402 | #169 716 |
| Liner | #210970R | #210 970 |

*Available at farm and tool supply retailers.

**Available at Hobart/Miller welding distributors.

ORDERING INFORMATION AND SYSTEM CHECKLIST

| Power Source | Stock No. | Description | Qty. | Price |
|---|------------------------------------|--|----------------------------|-------|
| Handler 125 | #500487 | 115 VAC flux cored wire welding package | | |
| UPC: #715959298711; Shipping Weight: 55 lb. (25 kg); Carton Dimensions: 23-3/4 x 11-1/4 x 18-1/2 in. (603 x 286 x 470 mm); Pallet Qty: 12; Pallet Dimensions: 35 x 48 x 39 in. (889 x 1219 x 991 mm) | | | | |
| Accessories | | | | |
| MIG Conversion Kit | #195158 | Includes regulator, 5 ft. (1.5 m) gas hose, solenoid valve and connecting leads, hose adapter, 3 contact tips (.023/.025 in.), spool of ER70S-6 solid wire, and install instructions | | |
| Hub Kit | #195216 | For 8 in. spools | | |
| Small Running Gear/Cylinder Rack | #194776 | For cylinders no larger than 7 in. (178 mm), maximum weight 75 lb. (34 kg) | | |
| Protective Cover | #195186 | | | |
| Replacement Gun | #195157R #225 397 | Hobart Miller H-9B Gun, 8 ft. (2.4 m) with liner for .030–.035 in. (0.8–0.9 mm) diameter wire | | |
| Contact Tips | | See chart on pg 3 | | |
| Nozzles | | See chart on pg 3 | | |
| Tip Adapter | | See chart on pg 3 | | |
| Replacement Liner | | See chart on pg 3 | | |
| Tools and Safety Items | | | | |
| Date: | | | Total Quoted Price: | |

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