

Thunderbolt® XL AC

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**Stick Welding
Power Source** 

Quick Specs

Light Industrial Applications
Home and Farm Use
Garage/Job Shops
Plant Fabrication/Maintenance
Vocational Training

Processes
Stick (SMAW)

Input Power 1-Phase Power
Amperage Range
225: HIGH 40–235 A (AC), LOW 30–150 A (AC)
Max. Open-Circuit Voltage 80
Weight 225 AC: 85 lb (39 kg)

The Power of Blue.®

Infinite current control allows the operator to adjust output by as little as 1-amp increments. Users can always get the exact heat they need, unlike the step control design on competitive products.

The exclusive **patented Accu-Set™ amperage indicator** provides precise heat control with infinite amperage control.

High 100% duty cycle rating
For the 225 amp model: 100 amps AC



Comes Complete With:
Power source with 15 ft (4.5 m) electrode cable, electrode holder, 10 ft (3 m) work cable with clamp, and power cord with plug.
Note: Does not include wall receptacle.

Output selector switch allows you to quickly select low or high range without adjusting the output leads.

Fully varnished magnetic coils: varnish protects and lengthens the life of the coils inside.

Forced-draft cooling fan runs continuously and helps to extend the life of the power source.

Specifications (Subject to change without notice.)



Input Power	Rated Output at 20% Duty Cycle	Welding Amperage Range		Max. Open-Circuit Voltage	Amps Input at Rated Output, 50 or 60 Hz, 1-Phase 230 V	Dimensions	Weight
		High	Low				
225 VAC	225 A at 25 VAC, 60 Hz (15% Duty Cycle at 50 Hz)	40–235 A	30–150 A	80	47.5 2.3*	H: 18-3/4 in (476 mm) W: 12-3/4 in (323 mm) D: 17-1/2 in (445 mm)	85 lb (39 kg)

* While idling



Power source is warranted for 3 years, parts and labor.
Original main power rectifiers are warranted for 5 years.

MADE IN USA



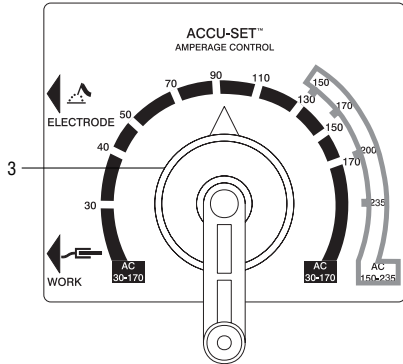
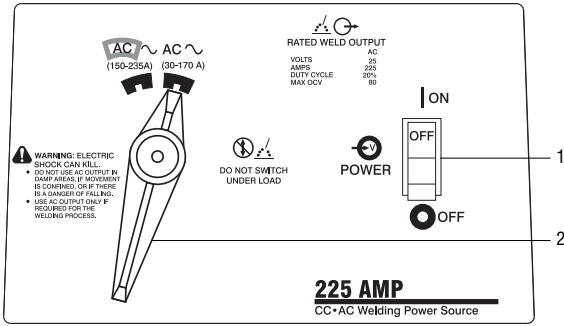
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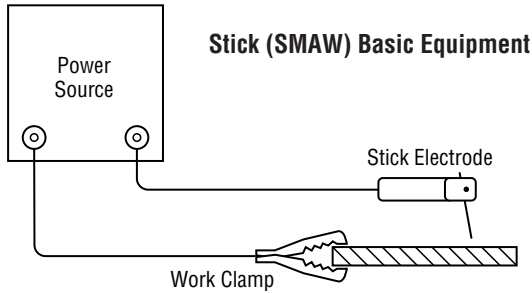


Control Panel



1. Power Switch
2. Selector Switch
3. Amperage Adjustment Control

Typical Installation



Electrode Charts

ELECTRODE POLARITY CHART

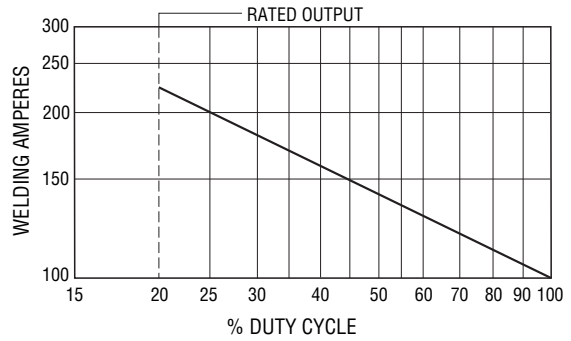
ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP. ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	GENERAL
6013	EP, EN	✓	ALL	LOW	GENERAL
7014	EP, EN	✓	ALL	MED.	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	SMOOTH, EASY, FASTER
Ni-CI	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

ELECTRODE/AMPERAGE CHART

ELECTRODE	DIAMETER		AMPERAGE RANGE				
	IN	MM	MIN.	50A	100A	150A	200A MAX.
6010 & 6011	3/32	2.4					
	1/8	3.2					
	5/32	4.0					
6013	3/16	4.8					
	1/16	1.6					
	5/64	2.0					
	3/32	2.4					
	1/8	3.2					
7014	5/32	4.0					
	3/16	4.8					
	3/32	2.4					
7018	1/8	3.2					
	5/32	4.0					
	3/32	2.4					
7024	1/8	3.2					
	5/32	4.0					
	3/32	2.4					
Ni-CI	1/8	3.2					
	5/32	4.0					
	3/16	4.8					
308L	3/32	2.4					
	1/8	3.2					

Performance Data

THUNDERBOLT XL 225 DUTY CYCLE CHART



Ordering Information

Power Source	Stock No.	Description	Qty.	Price
Thunderbolt® XL 225 AC	#903 641*	230 V, 50/60 Hz. Includes 5 ft (1.5 m) power cord w/230 V plug		
Running Gear	#043 927	Mounts easily to unit and provides convenient portability. Includes two wheels, two feet and handle.		
Miscellaneous				
Stick Electrodes		See charts above		
Helmet/Gloves/Scratch Brush				
Chipping Slag Hammer				
Wall Receptacle				

Date: Total Quoted Price:

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



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