

# HOBART®

HOBART BROTHERS CO.  
TROY, OHIO USA

**5/3/1**  
**INDUSTRIAL**  
**WARRANTY**

# Handler® 140

## 115V Wire Feed Welder



217919  
Jan. 2013



#500559

### Includes:

- Comfortable 10-ft. (3 m) H100S2-10 gun
- 10-ft. (3 m) work cable with clamp
- Built-in gas solenoid valve and dual-gauge regulator with gas hose
- Spool hub assembly accommodates 4 or 8 in. spools
- Sample spool of .030 in. (0.8 mm) self-shielding flux-cored wire
- .030 in. (0.8 mm) contact tips
- Power cord with plug
- Weld set-up chart
- Owner's manual with installation, operation and maintenance guidelines

**B**uilt with Hobart quality and durability, the Handler 140 is a wire welding package with industrial performance capable of operating on standard 115/120 volt, 20 amp home circuits. The broad output range of 25–140 amps allows you to weld 24 gauge up to 1/4 inch steel.

The Handler 140 is capable of running the following wires: .023–.035 in. (0.6–0.9 mm) mild steel or stainless steel, .030–.035 in. (0.8–0.9 mm) flux-cored, and .030 in. (0.8 mm) aluminum. Five output voltage settings with wire feed tracking make the unit easy to set and adjust for different materials and thicknesses.

### Applications:

Home, farm and ranch and light fabrication projects.

- Mower Decks/Brackets
- Fences/Gates
- Kennels
- Signs
- Window Security Guards
- Grills/Smokers
- Firewood Racks
- Metal Furniture
- Machinery and Auto Repair, etc.

### Features

### Benefits

**Excellent arc performance**

Smooth, stable arc on all thicknesses.

**Industrial cast aluminum wire drive system**

Professional and durable wire feed performance.

**Five-position voltage control**

Five voltage ranges allow you to fine-tune the arc.

**Dual-groove quick-change drive roll**

Makes it easy to change from one wire size or type to another.

**Weighs only 57 pounds**

Easier to transport: increased ability to weld where you need to weld.

**Convenient polarity changeover**

Access makes it quick and easy to change polarity between solid or tubular wire.

**Sloped control panel**

Increased visibility to the user interface makes adjustments easier.

**Self-resetting thermal overload protection**

Protects power transformer from thermal overload to ensure reliability.

**Hobart's 5/3/1 Industrial Warranty**

Better protection for your investment; up to five years on critical components.

**Designed, assembled, serviced and supported in Troy, Ohio USA**

Industrial-quality products with time-tested reliability since 1917.

# Specifications (SUBJECT TO CHANGE WITHOUT NOTICE.)



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, 18.5 VDC, at 20% Duty Cycle	25–140 A	28 V	40–700 IPM 50–740 IPM at no load	20	2.9	2.5	H: 12-3/8 in. (315 mm) W: 10-5/8 in. (270 mm) D: 19-1/2 in. (495 mm)	57 lb. (26 kg)

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

## Handler 140 Welding Guide

Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting/Number on right of slash is Wire Feed Setting.

Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas 20–30 CFH Flow Rate	Diameter of Wire Being Used	24 ga.	20 ga.	18 ga.	16 ga.	12 ga.	10 ga.	3/16 in.	1/4 in.	CHANGING POLARITY
				.024 in. (0.6 mm)	.036 in. (0.8 mm)	.048 in. (1.2 mm)	.060 in. (1.6 mm)	.105 in. (2.7 mm)	.135 in. (3.4 mm)	(4.8 mm)	(6.4 mm)	
Steel	Flux Core E71T-11 (DCEN)	No Shielding Gas Required Good for windy or outdoor applications.	.030" (0.8 mm)	—	—	1/30	2/30	3/40	3/45	4/50	5/50*	DCEN Electrode Negative for Flux-Cored Wire
			.035" (0.9 mm)	—	—	—	2/25	3/35	4/35	5/35	5/40*	
Steel	Solid Wire ER70S-6 (DCEP)	C <sub>25</sub> Gas Mixture 75% Argon/25% CO <sub>2</sub> Produces less spatter. Better appearance.	.024" (0.6 mm)	1/30	2/40	2/50	3/50	4/55	—	—	—	DCEP Electrode Positive for Solid Wire
			.030" (0.8 mm)	1/25	2/30	2/35	3/35	4/40	4/50	5/45	5/50*	
			.035" (0.9 mm)	—	—	2/30	3/30	4/35	4/40	5/40	5/45*	
Steel	Solid Wire ER70S-6 (DCEP)	100% CO <sub>2</sub>	.024" (0.6 mm)	1/25	2/35	3/30	3/40	4/50	5/50	—	—	DCEP Electrode Positive for Solid Wire
			.030" (0.8 mm)	—	2/30	3/30	3/35	4/30	4/35	5/35	5/40*	
			.035" (0.9 mm)	—	—	—	3/25	4/30	4/35	5/30	5/35*	
Stainless Steel	Stainless Steel (DCEP)	Tri-Mix 90% He/7.5% Ar/2.5% CO <sub>2</sub>	.024" (0.6 mm)	—	—	3/30	4/50	—	5/50	—	—	DCEP Electrode Positive for Solid Wire
		98% Ar/2% CO <sub>2</sub>	.030" (0.8 mm)	—	—	3/20	4/40	—	5/40	—	—	
			.024" (0.6 mm)	—	—	1/45	2/60	—	4/70	—	—	
Aluminum	Aluminum** 4043 AL (DCEP)	100% Argon**	.030" (0.8 mm)	—	—	—	3/90**	5/90**	—	—	—	DCEP Electrode Positive for Solid Wire
	Aluminum** 5356 AL (DCEP)		.030" (0.8 mm)	—	—	—	2/100**	4/100**	—	—	—	

Match feed roll groove to diameter of wire being used. Set tension knob setting to 3 at start. Adjust tension per instructions in the manual.

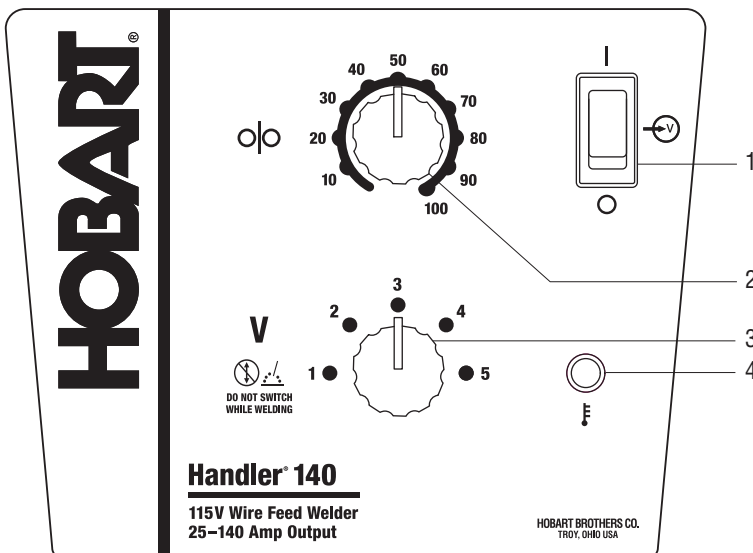
**CAUTION!** Do not change voltage switch position while welding. See owners manual for more information.

**Wire speed listed is a starting value only.** Wire speed setting can be fine-tuned while welding. Wire speed also depends on other variables such as stick out, travel speed, weld angle, cleanliness of metal, etc.

\*Multiple passes required.

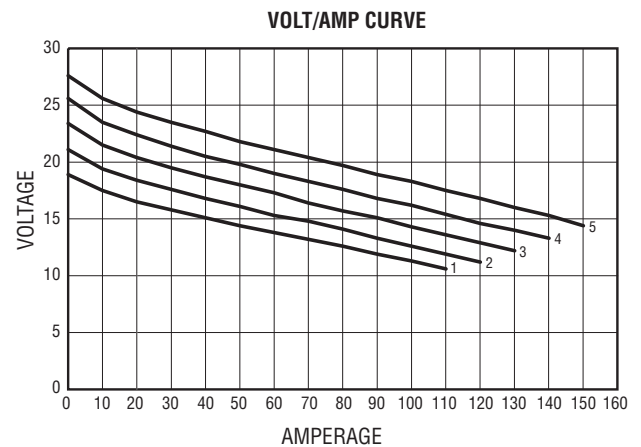
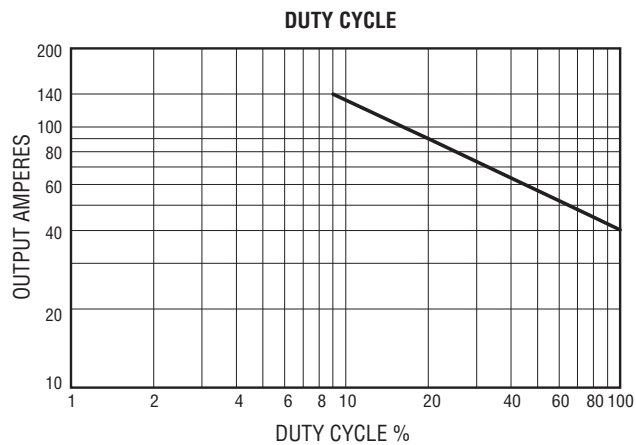
\*\*Aluminum wire is soft so feedability is not as good. Make sure that hub tension is not too tight and keep the torch as straight as possible. A "push angle" for the torch is recommended.

## Control Panel



1. Power Switch
2. Wire Speed Control
3. Voltage Control Switch
4. Over Temp Light

## Performance Data



## Accessories



### Spool Gun 3035-20 #300143

- 20-ft. (6.1 m) cable and gas hose
- Weld 14 gauge—1/8 in. (1.9–3.2 mm) aluminum with the Handler 140
- Threaded nozzle and contact tips
- Spool gun conversion kit consisting of control switch and gas diverter valve
- Enclosed wire spool compartment with internal spool hub tension adjustment for 4-in. (102 mm) rolls of wire
- For .030–.035 in. (0.8–0.9 mm) aluminum, steel and stainless steel
- Rated 150 amps, 60% duty cycle



### SGA 100 Spool Gun Control #043856

Required to connect spool gun to the Handler® 140. Includes 10-ft. (3 m) 115 VAC power cable and plug, 6-ft. (1.8 m) interconnecting cable, and 5-ft. (1.5 m) gas hose.

### H100S2-10 Replacement MIG Torch #245924

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



### Small Cart/Cylinder Rack #194776

Designed for portable MIG welders. Accommodates large and small gas cylinders.



### Running Gear/Cylinder Rack #770187

Heavy-duty construction. Accommodates large and small gas cylinders.



### Protective Cover #195186

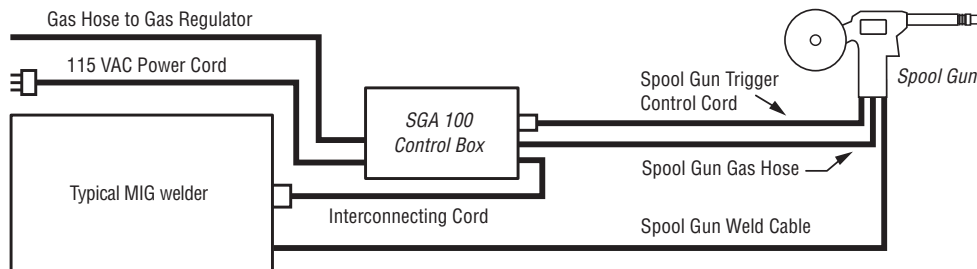
Weather-resistant nylon resists stains and mildew while protecting the finish of your welder.

## Consumables

Item	Hobart Package Part #	Miller Package Part #
<b>Contact Tips</b>		
.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)
<b>MIG Nozzle (Standard)</b>		
	#770404	#169 715
<b>Gasless Flux-cored Nozzle</b>		
	#770487	#226 190
<b>Tip Adapter</b>		
	#770402	#169 716
<b>Liners</b>		
.023/.025 in. (0.6 mm)	#196139	#194 010
.030/.035 in. (0.8/0.9 mm)	#196139	#194 011
.035/.045 in. (0.9/1.2 mm)	#196140	#194 012
<b>Power Source Drive Rolls</b>		
Dual-groove, V-smooth — For .023/.025 in. (0.6 mm) and .030–.035 in. (0.8–0.9 mm) wire	#237338	—
Dual-groove, V-knurled — For .030–.035 in. (0.8–0.9 mm) and .045 (1.2 mm) flux-cored wire	#202926	—
Dual-groove, V-knurled and V-smooth — For .030–.035 in. (0.8–0.9 mm) flux-cored and solid wire	#246565	—

## Typical Installation for Optional Spool Gun 3035-20 to Handler® 140

For Handler® 140, combine Spool Gun 3035-20 with SGA 100 to weld 14 gauge to 1/8 in. aluminum. To weld aluminum with comparable, competitive power sources, the spool gun may also be used with the SGA unit. *Note: Refer to SGA Owner's Manual for complete installation instructions.*



**Hobart Welders** An Illinois Tool Works Company

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