

Rebel™ EMP 215ic

Dual input voltage machine for MIG/MAG, LIFT TIG, Stick



Rebel EMP 215ic and accessories

Industry

- Light Fabrication
- Repair and Maintenance
- Automotive Bodies
- Mechanical Contractors
- Civil Construction
- Agricultural Equipment
- HVAC
- Training Schools

The Rebel™ EMP 215ic offers 120/230 VAC flexibility and some of the most innovative welding technology available. A breakthrough design inspired by professional welders, the Rebel EMP 215ic is a complete MIG/MAG/DC TIG/Stick package ready to weld anything – mild steel, aluminum, stainless steel – and go anywhere.

- True multi-process performance for best-in-class MIG/MAG, Flux-Cored, Stick, (including cellulosic electrodes), DC LIFT TIG, and DC Pulse LIFT TIG welding with Rebel EMP 215ic.
- Exclusive sMIG ("smart MIG") a short arc process feature, continuously learns and adapts to the operator's welding technique to provide a stable arc and superior, repeatable welds; increases productivity for the experienced welder, and reduces training time for novice welders.
- Innovative display has large display screen and high pixel density to provide a clear view of the TFT screen; loaded with features: on-demand availability of the user's manual, listing of spare parts – all in multiple languages.
- Unique, five-handle roll cage industrial design and unibody steel construction in a lightweight, highly portable unit; 3-year handle-to-handle warranty.
- Rebel Series models come ready to weld out of the box with Professional Grade Tweco accessories, ESAB consumables, and Victor gas regulator. Shielding gas not included.

Visit **esab.com** for more information.



Rebel™ EMP 215ic

Specifications	
Primary Voltage	120/230 VAC 1 ph +/- 10%, 50/60 Hz
Primary Current I _{max}	28.6 A (120 V) 30 A (230 V)
Primary Current I _{eff}	18 A (120 V) 14 A (230 V)
Energy Save Mode	21 W
Mains Cable	2 m (6.5 ft)
Supply Plug	230 V, NEMA 6-50P
Rated kVA/kW	4.5 kVA / 4.4 kW (120 V) 7 kVA / 6.8 kW (230 V)
Recommended Generator	8.2 kVA / 8.0 kW
MIG/MAG Welding Output 20% Duty Cycle 15% Duty Cycle	130 A/20.5 V (120 V) 235 A/26.0 V (230 V)
SMAW/Stick Welding Output 20% Duty Cycle 25% Duty Cycle	130 A/25.2 V (120 V) 180 A/27.2 V (230 V)
TIG Welding Output 40% Duty Cycle 20% Duty Cycle	130 A/15.2 V (120 V) 200 A/18.0 V (230 V)
Open Circuit Voltage	52 V
Open Circuit Voltage VRD	<35 V
Power Factor at Max Current	0.99 (120 V) 0.98 (230 V)
Efficiency at Max Current	83.6%
Setting Range (MIG/MAG)	15 A / 14.75 V – 130 A / 20.5 V (120 V) 15 A / 14.75 V – 235 A / 26.0 V (230 V)
Setting Range (MMA/SMAW/Stick)	6 A / 20.6 V – 130 A / 25.2 V (120 V) 16 A / 20.6 V – 180 A / 27.2 V (230 V)
Setting Range (DC TIG)	5 A / 10.2 V – 130 A / 15.2 V (120 V) 5 A / 10.2 V – 200 A / 18 V (230 V)
Wire Feed Speed	2.0 – 12.1 m/min (80 – 475 ipm)
Maximum Plate Thickness	9.5 mm (3/8 in.)
Wire Diameter Range: Mild Steel Stainless Steel Aluminum Flux Cored	0.6 – 1.0 mm (0.023 – 0.035 in.) 0.8 – 1.0 mm (0.030 – 0.035 in.) 0.8 – 1.2 mm (0.030 – 0.045 in.) 0.8 – 1.2 mm (0.030 – 0.045 in.)
Wire Spool Size	100 mm (4 in.), 200 mm (8 in.)
Approvals	CSA: E60974-1-00
Protection Class	IP23S
Dimensions, L x W x H	584 x 229 x 406 mm (23 x 9 x 16 in.)
Weight	20.6 kg (45.3 lbs)

Rebel™ EMP 215ic

Ordering Information

Description	Part Number
Rebel EMP 215ic – MIG/MAG/Stick/Lift TIG Welding System	0558102240

Delivery includes: Power source, Tweco Fusion 180 MIG/MAG Gun 3 m (10 ft), Victor Gas Regulator/Flow gauge, Gas Hose 3 m (10 ft), Tweco return cable kit 16 mm² 3 m (10 ft) OKC 50, Tweco electrode holder 16 mm² 3 m (10 ft) OKC 50, 17V Style TIG torch with consumables, ESAB OK AristoRod 12.50 0.8 mm (0.030 in.) 1 kg (2.2 lbs), Feed rolls 0.6/0.8 mm (0.023/0.030 in.) V fitted, 0.8/0.9 mm (0.030/0.035 in.) V and 0.8/0.9 mm (0.030/0.035 in.) VK, Velocity Contact Tips 0.6, 0.8, 0.9 mm (0.023, 0.030, 0.035 in.), Power cable adapter, 230V/120V NEMA 6-50R to NEMA 5-15P, Instruction manuals.

Accessories

Description	Part Number
Tweco Fusion 180A MIG Gun, 3m (10 ft)	1017-1338
Return cable kit, 16 mm ² , OKC 50, 3 m (10 ft)	WS200G10
Electrode Holder 200A and Lead Assembly, 4 m (13 ft), OKC 50	WS200E13
Victor GF-250-50-580, Flow Gauge Regulator, for Ar/CO ₂	0781-9411
Victor GRF400-320 Flow Gauge Regulator, for CO ₂	0781-2703
Gas hose with 5/8 in.-18 RH fittings, 3m (10 ft)	W4013900
Tweco Spool Gun 160A 3.5 m (12 ft)	1027-1397
TIG Torch 17 V and Accessories, 4 m (13 ft) 25/50 mm OKC	W4013802
ESAB Heliarc SR-9V gas cooled, 3.8 m (12.5 ft), 5/8 in. gas, OKC 50	0700026600
ESAB Heliarc SR-9V gas cooled, 7.6 m (25 ft), 5/8 in. gas, OKC 50	0700026601
ESAB Heliarc SR-17V gas cooled, 3.8 m (12.5 ft), 5/8 in. gas, OKC 50	0700026614
ESAB Heliarc SR-17V gas cooled, 7.6 m (25 ft), 5/8 in. gas, OKC 50	0700026615
ESAB Heliarc SR-26V gas cooled, 3.8 m (12.5 ft), 5/8 in. gas, OKC 50	0700026624
ESAB Heliarc SR-26V gas cooled, 7.6 m (25 ft), 5/8 in. gas, OKC 50	0700026625
TIG Foot Control 5 m (15 ft) cable and 8-pin connector	W4014450
MMA 4 Hand Remote Current Control, 10 m (33 ft) cable, 8-pin	0700500084
Power Adapter, 230 V to 120 V, 15 A NEMA 6-50R to NEMA 5-15P	W4014000
TIG Accessory Kit 1 mm (.040 in.) & 1.6 mm (1/16 in.) (20-115 A)	1442-0065
TIG Accessory Kit 2.4 mm (3/32 in.) & 3.2 mm (1/8 in.) (110-225 A)	1442-0066
Rebel Single Cylinder Cart	0558102491
Rebel Dual Cylinder Cart	0558102492
OKC 50, Cable Connector, Male (2 ea.)	9425-1431
OKC 50, Cable Connector, Female (2 ea.)	9425-1432

Bold = included in the package.

Rebel™ EMP 215ic

Wear Parts	
Description	Part Number
Feed Roll, 0.6/0.8 mm (0.023/0.030 in) V	7977036
Feed Roll, 0.8/0.9 mm (0.030/0.035 in) V	0558103014
Feed Roll, 0.9/1.2 mm (0.035/0.045 in) V	7977660
Feed Roll, 0.8/0.9 mm (0.030/0.035 in) VK	7977732
Feed Roll, 0.9/1.2 mm (0.035/0.045 in) VK	0349312497
Feed Roll, 0.8/0.9 mm (0.030/0.035 in) U	7977731
Feed Roll, 1.0/1.2 mm (0.040/0.045 in) U	7977264
Guide, Inlet, Wire, 0.8-1.2 mm (0.030-0.045 in)	0558102328
Guide, Outlet, Wire, 0.8-1.2 mm (0.030-0.045 in)	0558102326
Guide, Inlet, Wire, 0.6 mm (0.024 in)	0558102327
Key, Shaft, Motor, Drive	0558102334

Bold = included in the package.

Wear Parts – Tweco Fusion MIG Gun	
Description	Part Number
Velocity Contact Tip, 0.6 mm (0.023 in.) Tweco Fusion 180A	1110-1308
Velocity Contact Tip, 0.8 mm (0.030 in.) Tweco Fusion 180A	1110-1309
Velocity Contact Tip, 0.9 mm (0.035 in.) Tweco Fusion 180A	1110-1310
Velocity Contact Tip, 1.2 mm (0.045 in.) Tweco Fusion 180A	1110-1312
Velocity Nozzle, 3/8 in. ID, Tweco Fusion 180A	1220-1206
Velocity Nozzle, 1/2 in. ID, Tweco Fusion 180A	1220-1201
Velocity Nozzle, 5/8 in. ID, Tweco Fusion 180A	1220-1203
Velocity FCAW Tip Holder	1220-1207
Velocity FCAW Tip Holder Insulator	1220-1208
Conduit / Liner, Fusion 180A, 0.8/0.9 mm (0.030/0.035 in.), Hard	1420-1140
Conduit / Liner, Fusion 180A, 1.0/1.2 mm (0.040/0.045 in.), Hard	1420-1123
Conduit / Liner, Fusion 180A, 0.8/1.2 mm (0.030/0.045 in.), Soft	1420-1003

Bold = included in the package.

Wear Parts – Tweco Spool Gun	
Description	Part Number
Standard Contact Tip, 0.6 mm (0.023 in.)	1110-1100
Standard Contact Tip, 0.8 mm (0.030 in.)	1110-1101
Standard Contact Tip, 0.9 mm (0.035 in.)	1110-1102
Standard Nozzle, 3/8 in. ID	1210-1100
Standard Nozzle, 1/2 in. ID	1210-1110
Standard Nozzle, 5/8 in. ID	1210-1120
Conduit / Liner, Tweco Spool Gun	2031-2107
Gas Diffuser, Tweco Spool Gun	1510-1101



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