

Rebel™ Series Welding Machines

Dual-voltage machines for MIG, Stick, TIG welding



Rebel EMP 215ic

The Rebel™ Series Welding Machines offer 120/230V flexibility and some of the most innovative welding technology available. A breakthrough design inspired by professional welders, the Rebel is a complete package to weld anything – mild steel, aluminum, stainless steel – and go anywhere.

Three models to choose from*:

1. Rebel EMP 215ic for MIG/TIG/Stick
2. Rebel EMS 215ic for MIG/Stick
3. Rebel EM 215ic for MIG

**Each model is capable of only stated processes.*

- True multi-process performance for best-in-class MIG, Flux-Cored, Stick, including 6010 Stick electrodes, and Lift TIG welding with Rebel EMP 215ic
- Exclusive sMIG ("smart MIG") 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 larger display screen and higher pixel density to provide a more clear view of the TFT screen than other light industrial welders; loaded with exclusive 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 EMP 215ic comes ready-to-weld with professional-grade Tweco® Fusion™ MIG gun, electrode holder, earth clamp, TIG torch with accessories and Victor® gas regulator

Visit esab.com for more information.

Industry

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

Rebel™ Series Welding Machines

Specifications	
Primary Voltage	120VAC, 208/230 VAC
Supply Voltage Range	95 – 270 VAC
Number of Phases	1
Supply Frequency	50/60 Hz
Supply Plug	230 V, NEMA 6-50P
Rated kVA @ Maximum	4.5 kVA (120 V), 7 kVA (230 V)
Lead Cord Length	6.5 ft. (2 m)
Maximum Output	240 A
MIG (GMAW) Welding Output	130 A/20.5 V (120 V) @ 20% Duty Cycle 205 A/24.3 V (230 V) @ 25% Duty Cycle
STICK (SMAW) Welding Output	90 A/23.6 V (120 V) @ 40% Duty Cycle 180 A/27.2 V (230 V) @ 25% Duty Cycle
TIG (GTAW) Welding Output	130 A/15.2 V (120 V) @ 40% Duty Cycle 180 A/17.2 V (230 V) @ 30% Duty Cycle
Current Range	5 – 150 A (120 V), 5 – 240 A (230 V)
MIG Welding Voltage Range	10 – 26 V
Wire Feed Speed Range	59 – 476 ipm (1.5 – 12.1 m/min)
Nominal OCV Volt/DC	90 V
Maximum Plate Thickness	3/8 in. (9.5 mm)
Wire Diameter Range:	
Mild Steel	.023 – .035 in. (0.6 – 0.9 mm)
Stainless Steel	.030 – .035 in. (0.8 – 0.9 mm)
Aluminum	.030 – .045 in. (0.8 – 1.2 mm)
Flux Cored	.030 – .045 in. (0.8 – 1.2 mm)
Wire Spool Size	4 in. (100 mm), 8 in. (200 mm)
Approvals	CSA E60974-1-00, IEC 60974-1
Protection Class	IP23S
Power Source Dimensions, L x W x H	23 x 9 x 16 in. (584 x 229 x 406 mm)
Power Source Weight	40 lbs. (18.2 kg)

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Ordering Information	
Description	Part Number
Rebel EMP 215ic Multi-Process MIG/TIG/Stick Package	0558102240
Rebel EMS 215ic MIG/Stick Package	0558102239
Rebel EM 215ic MIG Package	0558102436

All packages include power supply, Tweco Fusion 180A MIG gun, Victor argon flowgauge regulator and 12.5 ft. (3.8 m) hose, Tweco earth clamp with leads, drive rolls and contact tips, sample .030 in. (0.8 mm) wire, power adapter and operator's manual.

Rebel EMS 215ic MIG/STICK Package (0558102239) also includes Tweco electrode holder and sample electrodes.

Rebel EMP 215ic Multi-Process Package (0558102240) also includes Tweco electrode holder and sample electrodes and 17V Style TIG torch.

Options & Accessories	
Description	Part Number
TIG Torch 26 V and Accessories (required for TIG welding)	W4014603
TIG Torch 17 V and Accessories, 13 ft. (4 m) 25/50 mm Dinse	W4013802
Tweco Spool Gun 160 A, 12 ft. (3.6 m) (required for Al MIG welding)	1027-1397
Electrode Holder 200A and Lead Assembly, 4 m (13 ft.), 50 mm	WS200E13 (was 1201-9577)
Ground Clamp 200 A and Lead Assembly, 3 m (10 ft.), 50 mm	WS200G10 (was 1201-9585)
Victor Argon Flow Gauge Regulator GF-250-50-580	0781-9411
Gas Hose, 3.8 m (12.5 ft.), Male 5/8-18UNF	W4013900
Foot Control, 15 ft. (4.6 m) cable and 8-pin Male Plug	W4014450
Power Adapter, 230 V to 120 V, 15 A	W4014000
Rebel Utility Cart, max 177.8 mm (7 in.) diameter cylinder	0558102325
Single Cylinder Cart, max 9 in. (228.6 mm)	W4015001

Wear & Spare Parts	
Description	Part Number
Tweco Fusion 180 (180 Amps, MIG Gun, 10 Foot)	1017-1338
Velocity Nozzle 0.5 in. (12.7 mm) Bore-Flush	1220-1200
Velocity Nozzle 0.5 in. Bore-Recess	1220-1201
Tweco 42-23-15 Conduit Liner (180-250A, 023, 15FT) Steel Wound, For Steel Wire	1420-1103
Conduit Liner 0.8-0.9 mm / .030-.035 in. (installed)	1420-1113
Velocity Contact Tip, .023 in. (0.6 mm)	1110-1308
Velocity Contact Tip, .030 in. (0.8 mm)	1110-1309
Velocity Contact Tip, .035 in. (0.9 mm)	1110-1310
Drive Roll, V-Groove, .023/.035 in. (0.6/0.9 mm)	W4014800
Drive Roll, V-Groove, .023/.030 in. (0.6/0.8 mm) (installed)	7977036
Drive Roll, Knurled V-Groove, .030/.035 in. (0.8/0.9 mm) (FCAW)	7977732

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Rebel EMP 215ic Complete Package



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