



OM-225 333A

2006-06

Processes



Flux Cored (FCAW) Welding



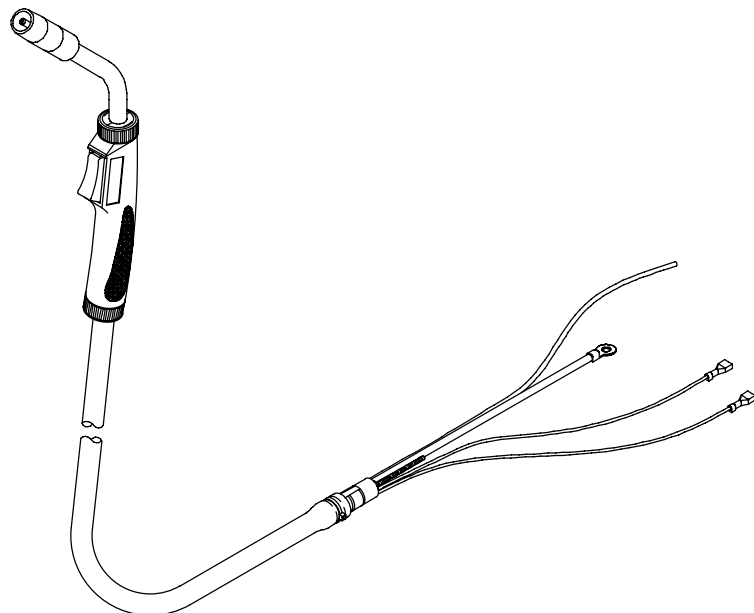
MIG (GMAW) Welding (Optional)

Description



Semi-Automatic, Air-Cooled
Flux Cored (FCAW) And MIG
(GMAW) Welding Gun

H-9B Gun



www.HobartWelders.com



OWNER'S MANUAL

File: Flux Cored (FCAW)



From Hobart to You

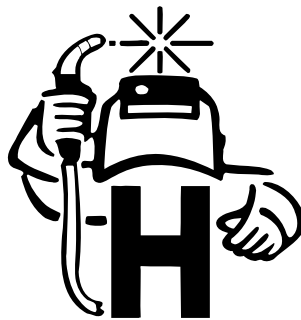
Thank you and congratulations on choosing Hobart. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

This Owner's Manual is designed to help you get the most out of your Hobart products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.



Hobart is registered to the ISO 9001:2000 Quality System Standard.

We've made installation and operation quick and easy. With Hobart you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Hobart Welders manufactures a full line of welders and welding related equipment. For information on other quality Hobart products, contact your local Hobart distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call 1-877-Hobart1 or visit our website at www.HobartWelders.com.**

For Technical Help call 1-800-332-3281.

5/3/1 WARRANTY

Working as hard as you do – every power source from Hobart is backed by the best warranty in the business.

Protect Your Investment!



Register your product at:
HobartWelders.com

TABLE OF CONTENTS

SECTION 1 –SAFETY PRECAUTIONS FOR FCAW AND GMAW WELDING GUNS – READ BEFORE USING	1
1-1. Symbol Usage	1
1-2. FCAW And GMAW Gun Hazards	1
EMF INFORMATION	2
SECTION 2 – SAFETY INFORMATION	3
SECTION 3 – INSTALLATION	3
3-1. Specifications	3
3-2. Duty Cycle And Overheating	3
3-3. Installing Gun Into Welding Power Source	4
3-4. Installing Contact Tip And Nozzle	5
3-5. Threading Welding Wire	6
SECTION 4 – OPERATION	7
4-1. Operating The Gun	7
SECTION 5 – MAINTENANCE & TROUBLESHOOTING	8
5-1. Replacing Gun Contact Tip	8
5-2. Cleaning Gun Liner	8
5-3. Replacing Gun Liner	9
5-4. Replacing Switch/Handle	11
5-5. Removing Gun From Welding Power Source	12
5-6. Routine Maintenance	13
5-7. Troubleshooting	13
SECTION 6 – PARTS LIST	14
WARRANTY	

SECTION 1 –SAFETY PRECAUTIONS FOR FCAW AND GMAW WELDING GUNS – READ BEFORE USING

SR7_8/03

1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.










▲ Marks a special safety message.

☞ Means NOTE; not safety related.



This group of symbols means Warning! Watch Out! Possible ELECTRIC SHOCK and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. FCAW And GMAW Gun Hazards

 WARNING		GMAW WELDING can be hazardous.	
PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS KEEP AWAY UNTIL CONSULTING YOUR DOCTOR. In welding, as in most jobs, exposure to certain hazards occurs. Welding is safe when precautions are taken. The safety information given below is only a summary of the more complete safety information found in the wire feeder and welding power source Owner's Manuals. Read and follow all safety precautions. HAVE ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK PERFORMED ONLY BY QUALIFIED PEOPLE.			
	ELECTRIC SHOCK can kill. <ol style="list-style-type: none">1. Always wear dry insulating gloves.2. Insulate yourself from work and ground.3. Do not touch live electrode or electrical parts.4. Repair or replace worn, damaged, or cracked gun or cable insulation.5. Turn off welding power source before changing contact tip or gun parts.6. Keep all covers and handle securely in place.		ARC RAYS can burn eyes and skin. <ol style="list-style-type: none">1. Wear welding helmet with correct shade of filter.2. Wear correct eye and body protection.3. Cover exposed skin with spatter-resistant clothing.
			HOT SURFACES can burn skin. <ol style="list-style-type: none">1. Allow gun to cool before touching.2. Do not touch hot metal.3. Protect hot metal from contact by others.
	FUMES AND GASES can be hazardous to your health. <ol style="list-style-type: none">1. Keep your head out of the fumes.2. Ventilate area, or use breathing device.3. Read Material Safety Data Sheets (MSDSs) and manufacturer's instructions for material used.		NOISE can damage hearing; SOME APPLICATIONS, SUCH AS PULSING, are noisy. <ol style="list-style-type: none">1. Check for noise level limits exceeding those specified by OSHA.2. Use approved ear plugs or ear muffs if noise level is high.3. Warn others nearby about noise hazard.
	WELDING can cause fire or explosion. <ol style="list-style-type: none">1. Do not weld near flammable material.2. Do not weld on closed containers.3. Watch for fire; keep extinguisher nearby.		WELDING WIRE can cause puncture wounds. <ol style="list-style-type: none">1. Keep hands and body away from gun tip when trigger is pressed.
	BUILD UP OF GAS can injure or kill <ol style="list-style-type: none">1. Shut off shielding gas supply when not in use.2. Always ventilate confined spaces or use approved air-supplied respirator.		

EMF INFORMATION

NOTE



Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, *Biological Effects of Power Frequency Electric & Magnetic Fields – Background Paper*, OTA-BP-E-53 (Washington, DC: U.S. Government Printing Office, May 1989): “. . . there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields can interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about questions of possible risk or to offer clear science-based advice on strategies to minimize or avoid potential risks.”

To reduce magnetic fields in the workplace, use the following procedures:

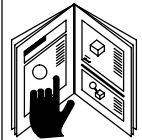
1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around the body.
4. Keep welding power source and cables as far away as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

About Pacemakers:

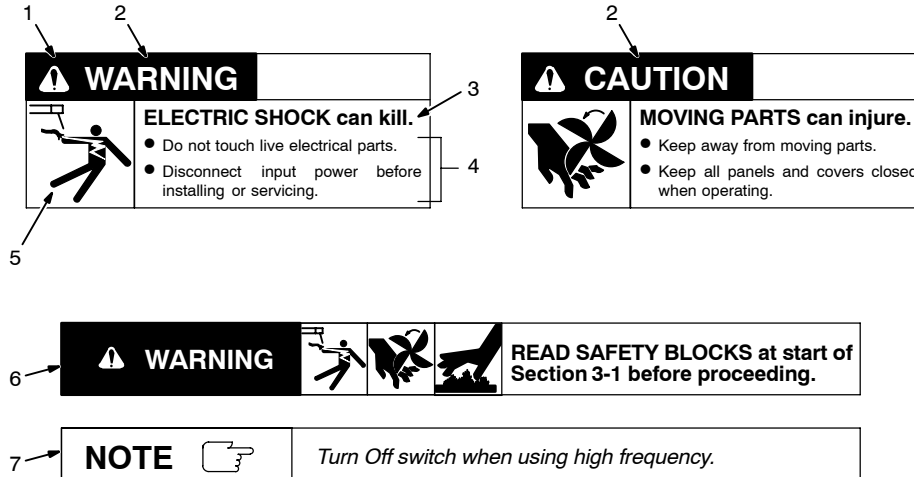
The above procedures are among those also normally recommended for pacemaker wearers. Consult your doctor for complete information.

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SECTION 2 – SAFETY INFORMATION



- Read all safety messages throughout this manual.
- Obey all safety messages to avoid injury.
- Learn the meaning of WARNING and CAUTION.



1 Safety Alert Symbol

2 Signal Word

WARNING means possible death or serious injury can happen.

CAUTION means possible minor injury or equipment damage can happen.

3 Statement Of Hazard And Result

4 Safety Instructions To Avoid Hazard

5 Hazard Symbol (If Available)

6 Safety Banner

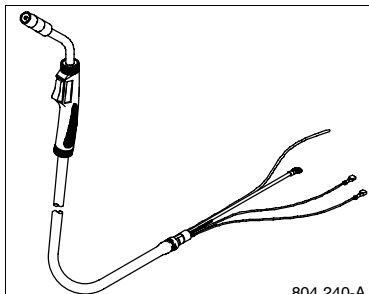
Read safety blocks for each symbol shown.

7 NOTE

Special instructions for best operation – not related to safety.

SECTION 3 – INSTALLATION

3-1. Specifications



804 240-A

Air-Cooled Welding Gun For FCAW And GMAW Welding

H-9B Feeds .030 – .035 in (0.8 – 0.9 mm) Flux Cored Wire Or .023 – .030 in (0.6 – 0.8 mm) Solid Wire
Duty Cycle Rating:

60%: 70 A With Flux Cored Wire

60%: 90 A With CO₂ Shielding Gas

60%: 70 A With Mixed Gases

Weight With 8 ft (2.4 m) Power Cable: 2.2 lb (1.0 kg)

3-2. Duty Cycle And Overheating



See Section 3-1. Specifications for amperage rating and duty cycle.

Duty Cycle is percentage of 10 minutes that unit can weld at rated load without overheating.

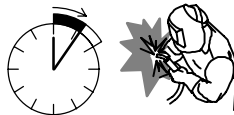
▲ Exceeding duty cycle can damage unit and void warranty.

100% duty cycle

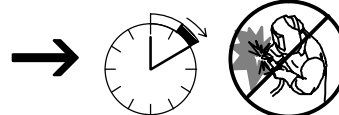


Continuous Welding

60% duty cycle

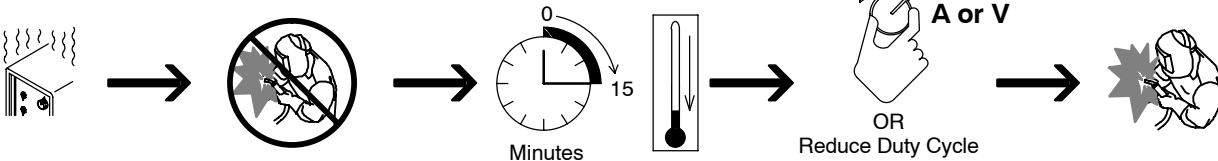


6 Minutes Welding



4 Minutes Resting

Overheating



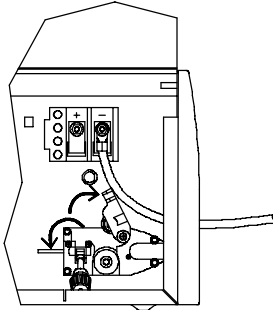
sduty1 5/95

3-3. Installing Gun Into Welding Power Source

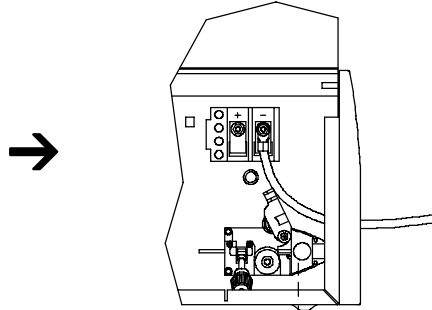


If existing gun requires removal, see Section 5-5.

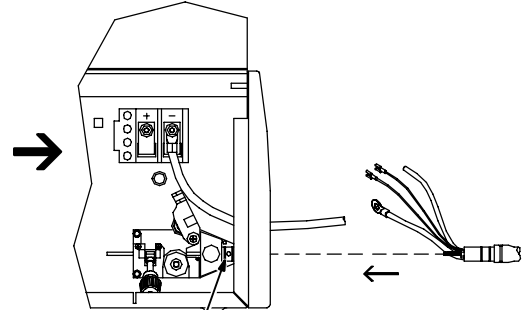
Turn off welding power source.



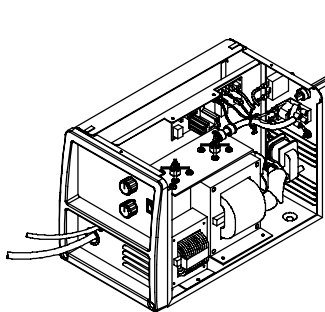
Open pressure assembly.



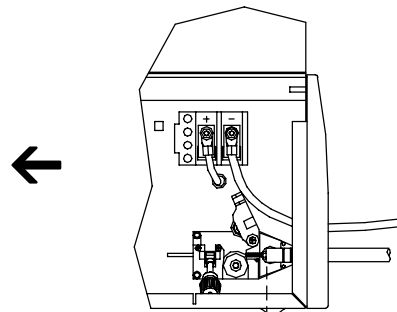
Remove screws (3) from cover, and remove cover from wire drive assembly.



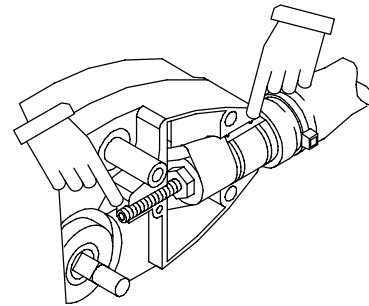
Insert gun cable through opening in front panel. Route weld cable, trigger leads, and gas hose through opening in drive housing.



Remove wrapper from unit.

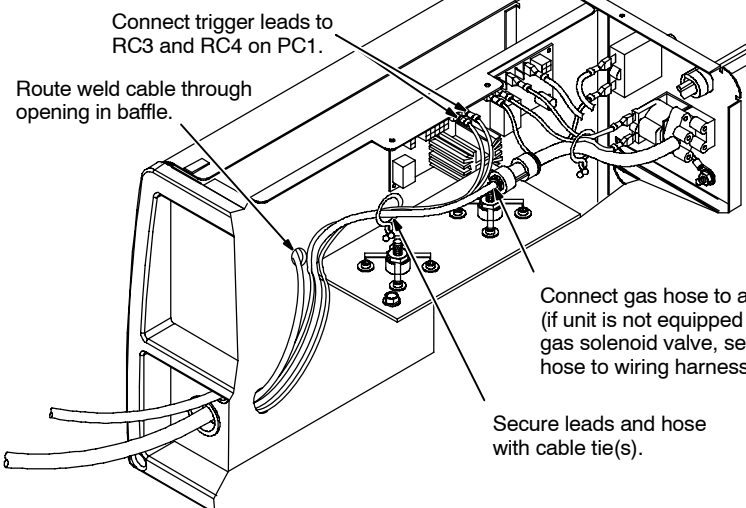


Reinstall cover and secure with screws (3).



Reinstall cable end into drive housing with retaining grooves inserted into the two retaining ribs. Be sure to position gas hose up and trigger leads down. Position liner in groove so that end is flush with back of groove.

Route wires, cable, and hose to avoid contact with sharp edges, hot surfaces, or moving parts.

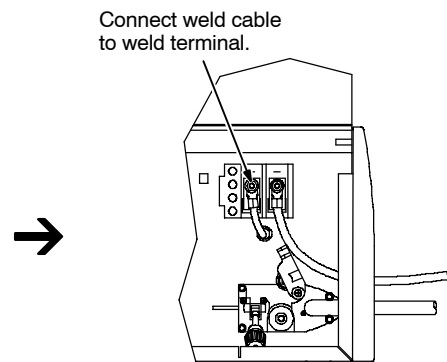


Connect trigger leads to RC3 and RC4 on PC1.

Route weld cable through opening in baffle.

Connect gas hose to adapter (if unit is not equipped with gas solenoid valve, secure hose to wiring harness).

Secure leads and hose with cable tie(s).

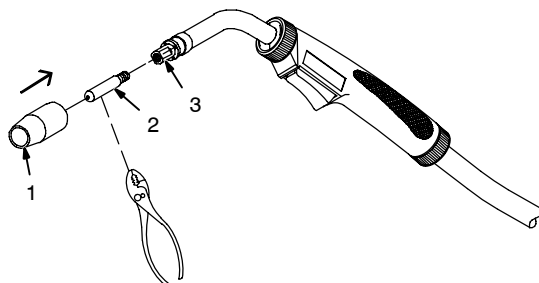


Reinstall wrapper onto unit.

Thread wire according to Section 3-5.

803 497-A / Ref. 803 378-A

3-4. Installing Contact Tip And Nozzle



▲ Turn off welding power source.

1 Nozzle

Remove nozzle.

2 Contact Tip

3 Tip Adapter

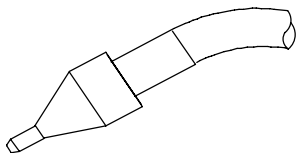
Thread welding wire through gun (see Section 3-5).

Slide contact tip over wire and tighten tip into tip adapter.

Install nozzle.

Flux Nozzle

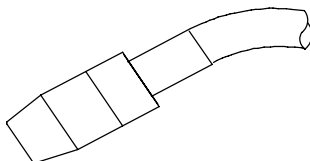
Use with flux cored wire only. Narrow design allows access in tight spaces and provides better visibility of puddle during welding.



Push nozzle over contact tip and adapter until it is seated onto adapter. Contact tip will be exposed approximately 7/16 in (11.3 mm) when installed properly.

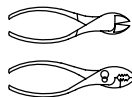
MIG Nozzle

Use with solid or flux cored wire.



Push nozzle over contact tip and adapter until it is seated onto adapter. End of contact tip will be flush with end of nozzle when installed properly.

Tools Needed:



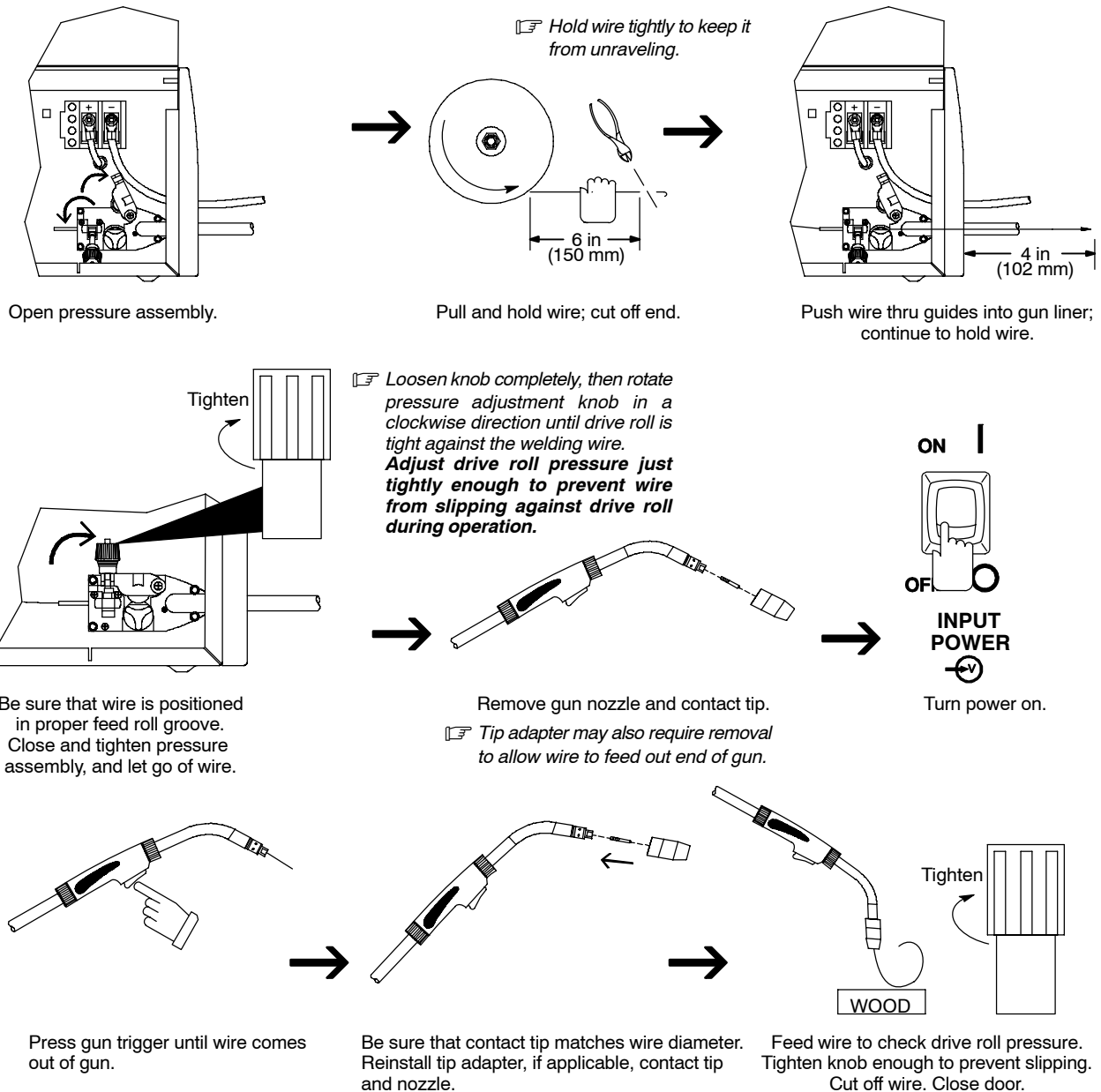
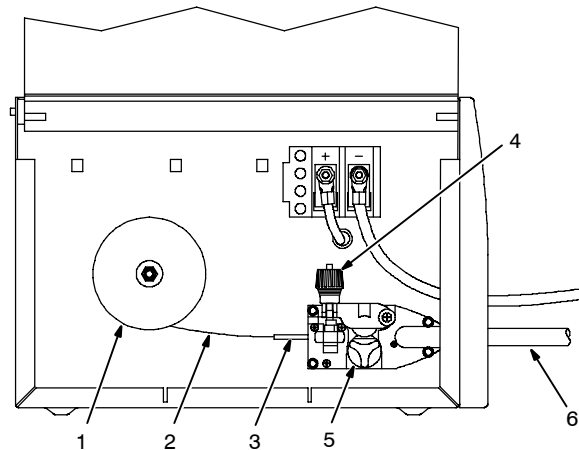
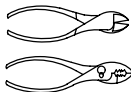
Ref. 804 241-A

3-5. Threading Welding Wire



- 1 Wire Spool
 - 2 Welding Wire
 - 3 Inlet Wire Guide
 - 4 Pressure Adjustment Knob
 - 5 Drive Roll
 - 6 Gun Cable
- Lay gun cable out straight.

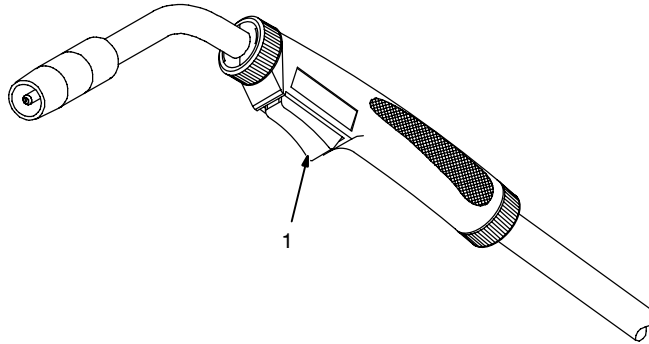
Tools Needed:



Ref. 803 444-A / Ref. 205 837

SECTION 4 – OPERATION

4-1. Operating The Gun



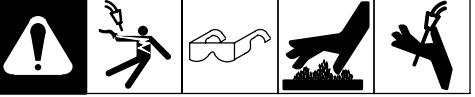
1 Trigger Switch

When pressed, energized wire feeds and shielding gas flows (if unit is equipped with optional gas solenoid).

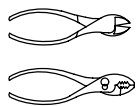
Ref. 804 240-A

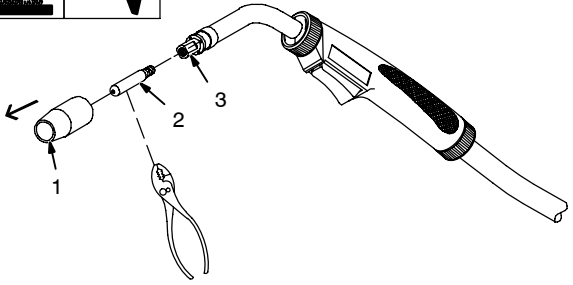
SECTION 5 – MAINTENANCE & TROUBLESHOOTING

5-1. Replacing Gun Contact Tip



Tools Needed:





▲ Turn off welding power source.

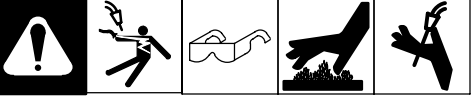
- 1 Nozzle
- 2 Contact Tip
- 3 Tip Adapter

Remove nozzle.

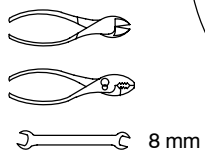
Cut off welding wire at contact tip. Remove contact tip from tip adapter, and install new contact tip. Reinstall nozzle.

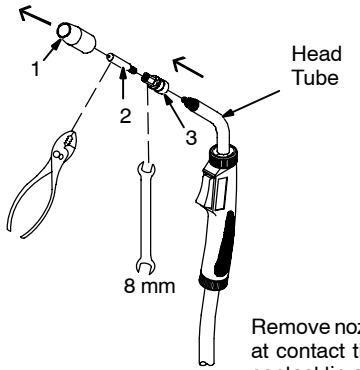
Ref. 804 241-A

5-2. Cleaning Gun Liner



Tools Needed:





Remove nozzle. Cut off wire at contact tip, and remove contact tip and tip adapter.

8 mm

Head Tube

Open pressure assembly. Retract wire from liner onto spool.

Hold wire tightly to keep it from unraveling. Secure end of wire at spool.

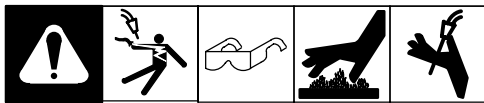
Remove screws (3) from cover, and remove cover from wire drive assembly.

Thread wire according to Section 3-5.

Lay gun cable out straight, and blow out liner.

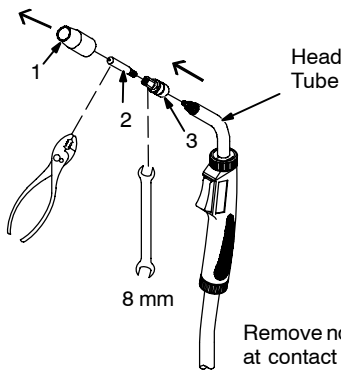
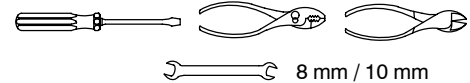
Reassemble drive cover and gun in reverse order from taking it apart.

5-3. Replacing Gun Liner

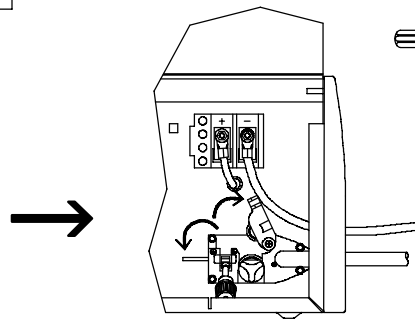


▲ Turn off welding power source.

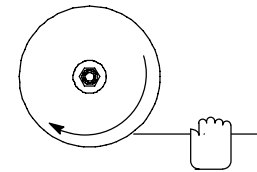
Tools Needed:



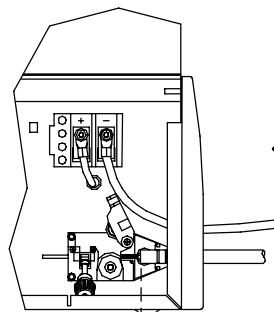
Remove nozzle. Cut off wire at contact tip, and remove contact tip and tip adapter.



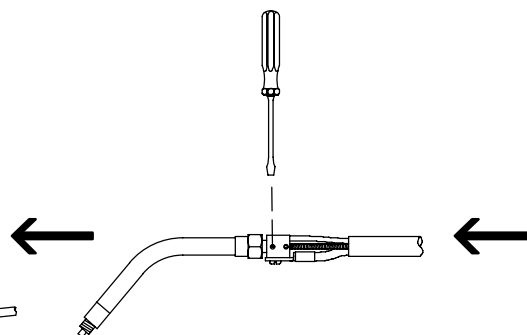
Open pressure assembly. Retract wire from liner onto spool.



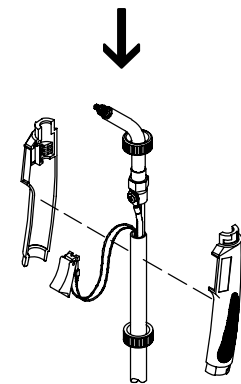
Hold wire tightly to keep it from unraveling. Secure end of wire at spool.



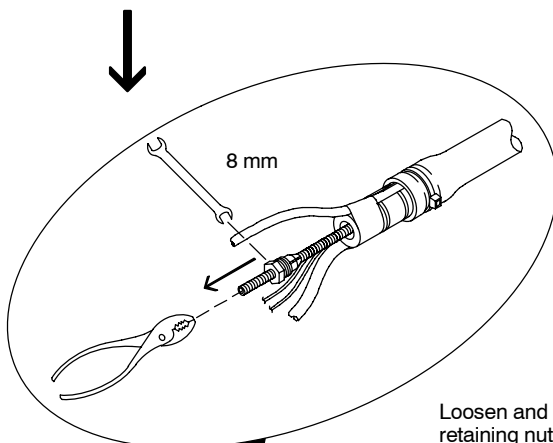
Remove screws (3) from cover, and remove cover from wire drive assembly.



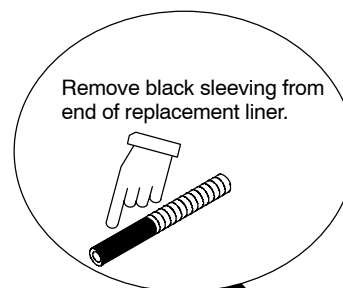
Loosen liner setscrew.



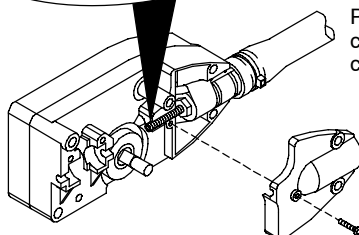
Twist top and bottom handle locking rings counterclockwise 1/4 turn. Slide bottom ring down cable and top ring forward over head tube. Separate gun handle halves.



Loosen and remove retaining nut from liner. Pull liner out of gun cable. If necessary, twist cable to ease removal.



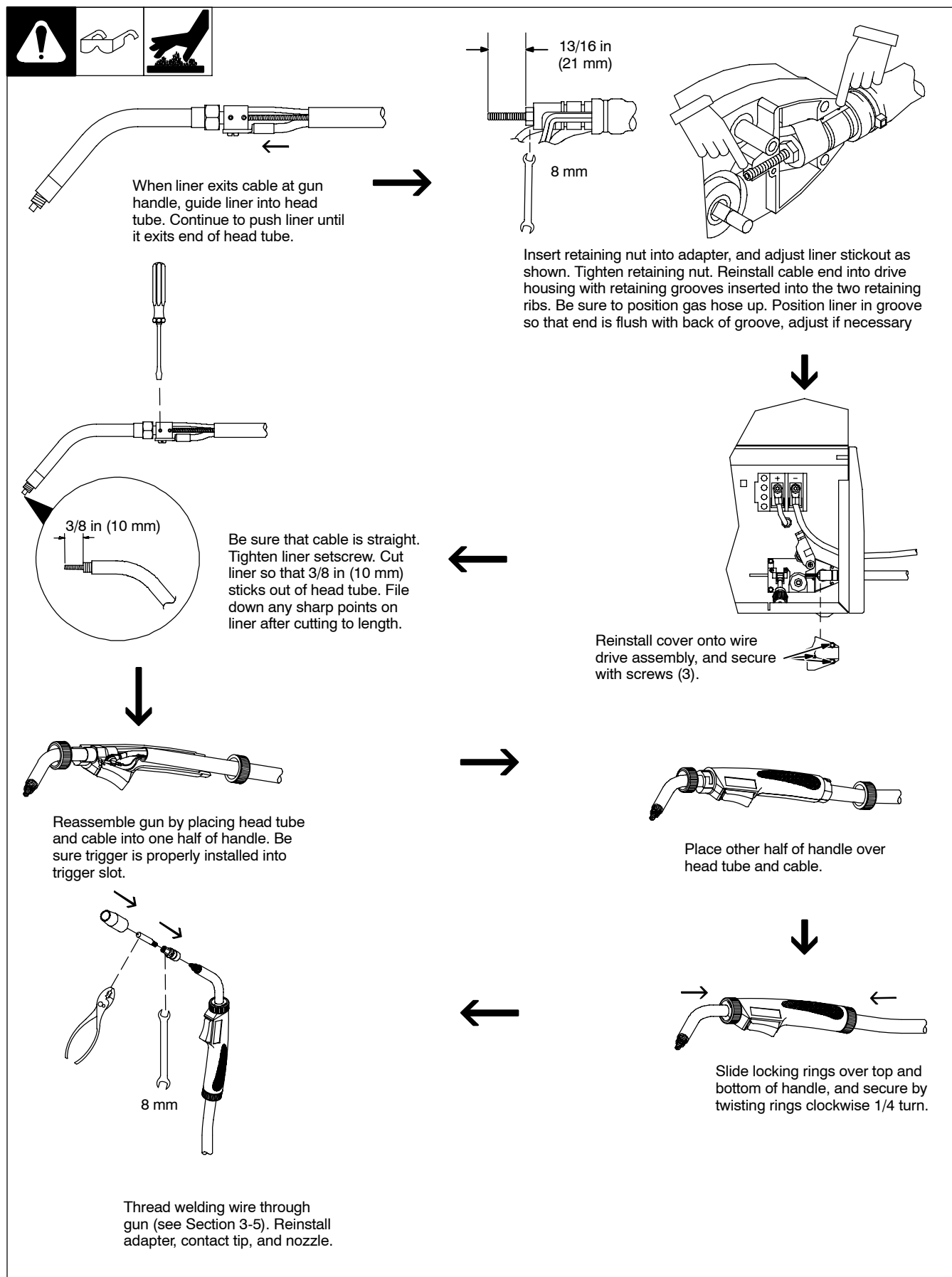
Remove black sleeving from end of replacement liner.



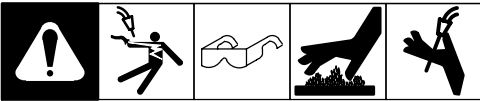
Install retaining nut on one end of liner. Lay gun cable straight on a flat surface. Insert bare end of liner (end without retaining nut) into wire drive end of cable. Push liner toward gun. If necessary, twist cable to ease installation.

Ref. 804 241-A / 803 497-A / 803 837-A / 803 899-A

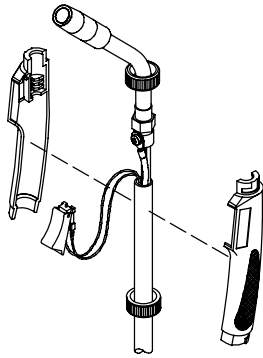
5-3. Replacing Gun Liner (Continued)



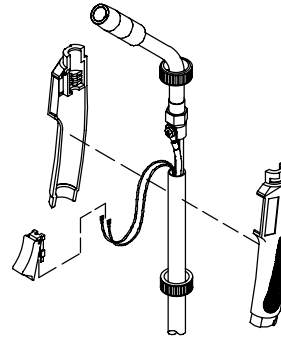
5-4. Replacing Switch/Handle



▲ Turn Off welding power source.



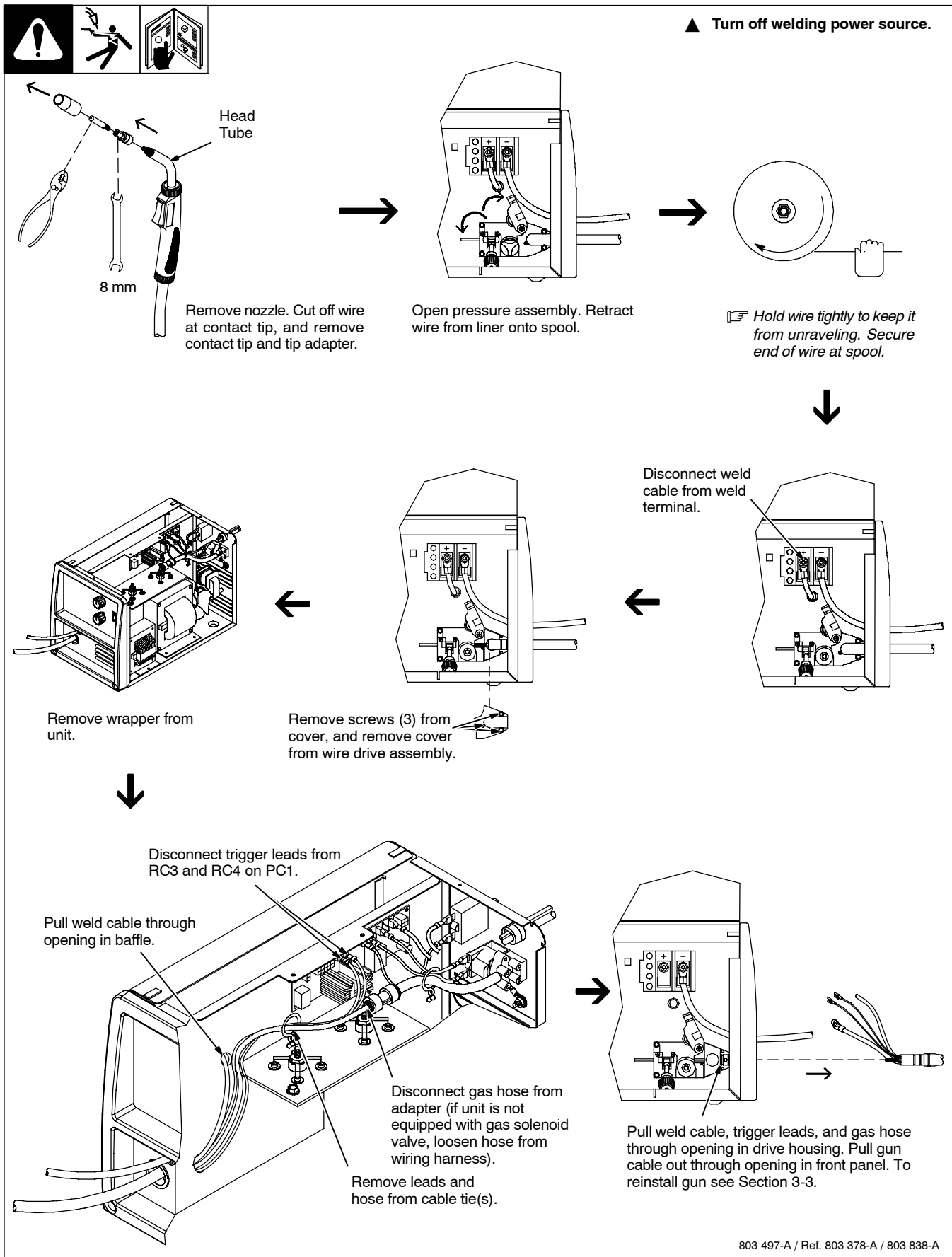
Twist top and bottom handle locking rings counterclockwise 1/4 turn. Slide bottom ring down cable and top ring forward over head tube. Separate gun handle halves.





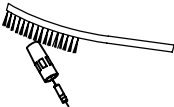

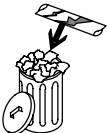
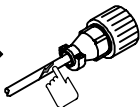


Disconnect switch leads and remove switch. Connect leads to new switch (polarity is not important). Be sure trigger is properly installed into trigger slot. Reassemble in reverse order.

Ref. 804 241-A / 804 242-A

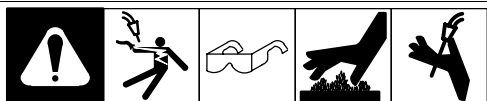
5-5. Removing Gun From Welding Power Source



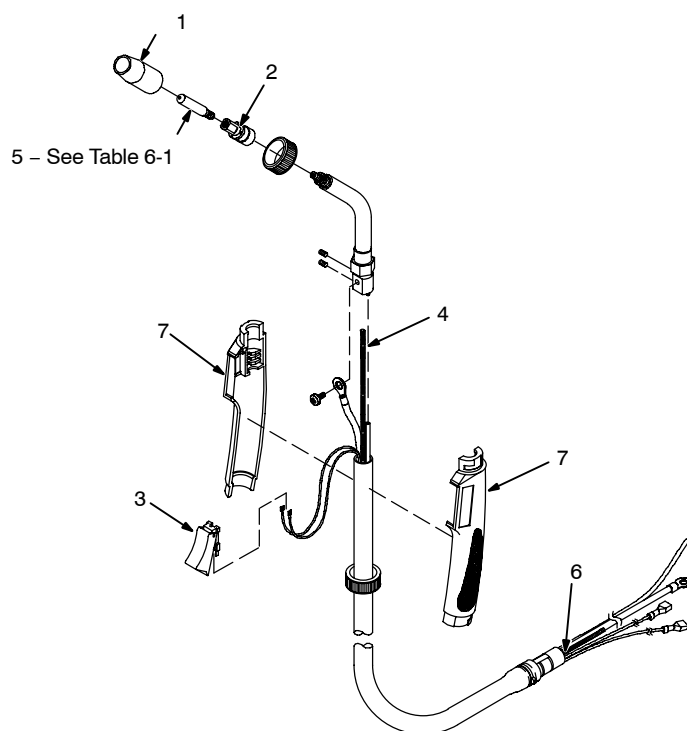
5-6. Routine Maintenance

				<p>▲ Turn Off welding power source before maintaining.</p>	
<p>Each Spool Of Wire</p>					
		<p>Blow Out Gun Casing</p>			
				<p>Clean Nozzle And Check Contact Tip</p>	
<p> 3 Months</p>					
		<p>Replace Cracked Parts</p>			
		<p>Control Cord</p>			
				<p>Gas Hose</p>	
					
				<p>Gun Cable</p>	

5-7. Troubleshooting

				
Trouble		Remedy		
Wire does not feed; wire is not energized; wire feeds unevenly.		Check contact tip. Check for kinks in gun cable.		
		Check contact tip. Check for kinks in gun cable. Blow out gun liner (see Section 5-2).		
		Check for secure gun trigger lead connections at PC1 (see Section 3-3).		
		Check, and if necessary, replace gun trigger switch (see Section 5-4).		
Weld porosity.		Remove weld spatter buildup in nozzle.		
		Make sure inner head tube is tight in cable connector.		
		Check shielding gas flow/supply.		
Wire feeding stops or does not feed properly during welding.		Straighten gun cable and/or replace damaged parts (see Section 5-2 or 5-3).		
		Adjust drive roll pressure (see Section 3-5).		
		Change to proper drive roll groove (see welding power source manual).		
		Readjust hub tension (see weld power source manual).		
		Clean or replace liner if dirty or plugged (see Section 5-2 or 5-3).		
		Replace drive roll or pressure bearing if worn or slipping (see welding power source manual).		

SECTION 6 – PARTS LIST



804 243-A

Figure 6-1. H-9B Gun

Item No.	Part No.	Description	Quantity
225 397 Figure 6-1. H-9B Gun			
... 1	169 715	NOZZLE, slip type .500 orf flush	1
... 1	♦226 190	NOZZLE, flux cored slip type	1
... 2	169 716	ADAPTER, contact tip	1
... 3	225 410	SWITCH, trigger	1
... 4	210 970	LINER, monocoil .023/.035 wire x 8ft	1
... 5	♦087 299	TIP, contact scr .023 wire x 1.125	1
... 5	000 067	TIP, contact scr .030 wire x 1.125	1
... 5	♦000 068	TIP, contact scr .035 wire x 1.125	1
... 6	226 010	NUT, liner retainer	1
... 7	226 080	HANDLE ASSY	1

♦OPTIONAL

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Table 6-1. Contact Tip Options

HOBART PART NO.	DESCRIPTION	REMARKS
196 134	Tip, contact scr .023 wire	Pkg of 5
196 131	Tip, contact scr .030 wire	Pkg of 5
196 132	Tip, contact scr .035 wire	Pkg of 5
196 137	Nozzle, slip type .500 orf flush	Qty 1
196 135	Adapter, contact tip	Qty 1

WELD-IT PART NO.	DESCRIPTION	REMARKS
770 174	Tip, contact scr .023 wire	Pkg of 5
770 177	Tip, contact scr .030 wire	Pkg of 5
770 180	Tip, contact scr .035 wire	Pkg of 5

HOBART 5/3/1 WARRANTY

Effective January 1, 2005

Warranty Questions?

Call

1-800-332-3281

7 AM – 6 PM EST

Service

You always get the fast, reliable response you need. Most replacement parts can be in your hands in 24 hours.

Support

Need fast answers to the tough welding questions? Contact your distributor or call 1-800-332-3281. The expertise of the distributor and Hobart is there to help you, every step of the way.

Assistance

Visit the Hobart website:
www.HobartWelders.com

5/3/1 WARRANTY applies to all Hobart welding equipment, plasma cutters and spot welders with a serial number preface LF or newer.

This limited warranty supersedes all previous Hobart warranties and is exclusive with no other guarantees or warranties expressed or implied.

Hobart products are serviced by Hobart or Miller Authorized Service Agencies.

LIMITED WARRANTY – Subject to the terms and conditions below, Hobart/Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Hobart equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Hobart. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Hobart/Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Hobart/Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Hobart/Miller will provide instructions on the warranty claim procedures to be followed.

Hobart/Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the date that the equipment was delivered to the original retail purchaser, or one year after the equipment is sent to a North American distributor or eighteen months after the equipment is sent to an International distributor.

1. 5 Years — Parts and Labor
 - * Original Main Power Rectifiers
 - * Transformers
 - * Stabilizers
 - * Reactors
2. 3 Years — Parts and Labor
 - * Drive Systems
 - * PC Boards
 - * Rotors, Stators and Brushes
 - * Idle Module
 - * Solenoid Valves
 - * Switches and Controls
 - * Spot Welder Transformer
3. 1 Year — Parts and Labor Unless Specified (90 days for industrial use)
 - * Motor-Driven Guns
 - * MIG Guns/TIG Torches
 - * Relays
 - * Contactors
 - * Regulators
 - * Water Coolant Systems
 - * Flowgauge and Flowmeter Regulators (No Labor)
 - * HF Units
 - * Running Gear/Trailers
 - * Plasma Cutting Torches
 - * Remote Controls
 - * Replacement Parts (No labor)
 - * Accessories
 - * Field Options

(NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
4. Engines, batteries and tires are warranted separately by the manufacturer.

Hobart's 5/3/1 Limited Warranty shall not apply to:

1. **Consumable components such as contact tips, cutting nozzles, slip rings, drive rolls, gas diffusers, plasma torch tips and electrodes, weld cables, and tongs and tips, or parts that fail due to normal wear.** (Exception: brushes, slip rings, and relays are covered on Hobart Engine-Driven models.)
2. Items furnished by Hobart/Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Hobart/Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

HOBART PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Hobart's/Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Hobart/Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Hobart/Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Hobart's/Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Hobart/Miller authorized service facility as determined by Hobart/Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL HOBART/MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY HOBART/MILLER IS EXCLUDED AND DISCLAIMED BY Hobart/Miller.

Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.





Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip

Protect Your Investment!



Register your product at:
HobartWelders.com



Resources Available

Always provide Model Name and Serial/Style Number.

To locate a Distributor, retail or service location:

Call 1-877-Hobart1 or visit our website at
www.HobartWelders.com

For technical assistance:

Call 1-800-332-3281

Contact your Distributor for:

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Training (Schools, Videos, Books)

Technical Manuals (Servicing Information
and Parts)

Circuit Diagrams

Welding Process Handbooks

Contact the Delivering Carrier to:

File a claim for loss or damage during
shipment.

For assistance in filing or settling claims, contact
your distributor and/or equipment manufacturer's
Transportation Department.

Hobart Welding Products

An Illinois Tool Works Company
600 West Main Street
Troy, OH 45373 USA

For Technical Assistance:

Call 1-800-332-3281

For Literature Or Nearest Dealer:
Call 1-877-Hobart1