

Rebel™ EMS 215ic

Dual-voltage machine for MIG and Stick welding



Rebel EMS 215ic

Industry

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

The Rebel™ EMS 215ic offers 120/230 V flexibility and some of the most innovative welding technology available. A breakthrough design inspired by professional welders, the Rebel EMS 215ic is a complete MIG/Stick welding package for mild steel, aluminum and stainless steel that goes where you go.

- Excellent performance for best-in-class MIG, Flux-Cored and Stick welding, including 6010 Stick electrodes
- 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 Series models come ready to weld out of the box with Professional Grade TWECO accessories and Victor gas regulator; shielding gas not included

Visit esab.com for more information.



Rebel EMS 215ic complete package.

When choosing a top-performing welding machine you need top-performing ESAB Filler Metals. Learn more at esab.com/fillermetals today.

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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
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 Stainless Steel Aluminum Flux-Cored	.023 – .035 in. (0.6 – 0.9 mm) .030 – .035 in. (0.8 – 0.9 mm) .030 – .045 in. (0.8 – 1.2 mm) .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)

Ordering Information	
Description	Part Number
Rebel EMS 215ic MIG/Stick Package	0558102239

Includes 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, Tweco electrode holder and sample electrodes, power adapter and operator's manual.

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Options & Accessories	
Description	Part Number
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
Ground Clamp 200 A and Lead Assembly, 3 m (10 ft.), 50 mm	WS200G10
Victor Argon Flow Gauge Regulator GF-250-50-580	0781-9411
Gas Hose, 3.8 m (12.5 ft.), Male 5/8-18UNF	W4013900
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
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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Process
MIG/Flux-Cored
Stick
Material
Mild Steel
Stainless Steel
Aluminum - Spool Gun Ready
Package Features
sMIG .023-.035 in. (0.6-0.9 mm)
4.3 in. Colour LCD/TFT Display
90-270 V Dual Voltage (extended range)
Ready-to-Weld (all accessories included - including sample filler metals)
Auto-Detect Spool Gun Capable
4 in. (100 mm) Spool Capable
8 in. (200 mm) Spool Capable
Four Memory Settings (per process)
Multi-lingual Display
Built-In Instruction Manual and Spare Parts List
Built-In Weld Parameters
Inductance Control (MIG mode only)
Trigger Lock (2T, 4T)
Voltage Trim Adjustment (MIG mode only)
SCT (Short Circuit Termination)
Burn-Back Adjustment
Pre-flow/Post-flow Adjustment
Spot Timer Capable
Automatic Hot Start
Arc Force Adjustment

When choosing a top-performing welding machine you need top-performing ESAB Filler Metals.
Learn more at [esab.com/fillermetals](https://www.esab.com/fillermetals) today.



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