



PROCESSES



Flux Cored (FCAW) Welding



MIG (GMAW) Welding
(with optional MIG Kit)



Handler 125

5/3/1 INDUSTRIAL WARRANTY

MADE IN **USA**

The Handler 125 is a rugged constant-voltage DC welder with built-in wire feeder, that operates off 115-volt household current. It comes ready to weld, without shielding gas, using .030–.035 in (0.8–0.9 mm) self-shielding flux cored wire. This is a great unit for outdoor applications when shielding gas could be blown away. Welds up to 3/16 in steel with flux-cored wire.

For greater versatility, install an optional MIG Conversion Kit. Unit with kit installed can weld with .023–.030 in (0.6–0.8 mm) solid wire and gas

shielding. Use C-25 gas (75% Argon/25% CO₂) on 22 gauge – 1/8 in steel for a cleaner weld with less spatter. Use Tri-Mix gas and stainless wire for welding on 16–12 gauge stainless steel.

Comes Complete With:

- Comfortable H-9B gun, 8 ft (2.4 m) with liner for .023–.035 in (0.6–0.9 mm) diameter wire
- .030 in (0.8 mm) contact tips
- Work clamp and cable
- Sample spool of .030 in (0.8 mm) self-shielding flux cored wire
- Spool shaft to accommodate 4 in spools. (Optional hub kit available for 8 in spools.)
- Power cord with plug
- Weld set-up chart
- Owner's manual with parts lists, installation, operation, maintenance and wire welding guidelines

Applications

- Farm/Home
- Light Maintenance and Repair
- Light Fabrication

FEATURES

BENEFITS

Broad output range of 30–125 A	Allows you to weld up to 3/16 in steel with flux cored wire.
Four output voltage settings with wire feed speed tracking	Provides a broader operating window for each wire, with quick and easy adjustment for different thicknesses and joints.
Built-in contactor	Eases use and excellent safety feature which makes wire electrically “cold” until trigger is pulled.
Durable feed head with quick-release drive roll tension lever	Positive feed with adjustable tension plus easy accessibility to thread new wire.
Dual-groove quick-change drive roll	Makes it easy to change from one wire size to another. One knurled groove for .030–.035 in (0.8–0.9 mm) wire, and one smooth groove for .023/.025 in (0.6 mm) wire.
Short circuit protection	Protects unit against current overload.
Self-resetting thermal overload	Protects power transformer to ensure reliability.
Self-resetting motor protection	Protects wire feed system from overload, no fuses to change or circuit breaker buttons to reset.
Upgradeable for welding with gas	Easy-to-install MIG Conversion Kit available.
Hobart's 5/3/1 Industrial Warranty	Five-year warranty on transformers, three years on electronics (drive motors, rectifiers) and one year on guns.

SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

DC **CV** **1**
Phase

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, 19 VDC, at 20% Duty Cycle	30–125 A	29 V	0–415 IPM (0–11 MPM) 0–500 IPM (0–13 MPM) at no load	20	2.9	2.5	H: 16-7/8 in (429 mm) W: 9-7/8 in (251 mm) D: 12-1/8 in (308 mm)	50 lb (22.7 kg)
63 A, 21 VDC at 20% Duty Cycle*			15*	2.2*	1.77*			

*CSA rating.

Certified to both the Canadian and U.S. Standards for welding equipment.



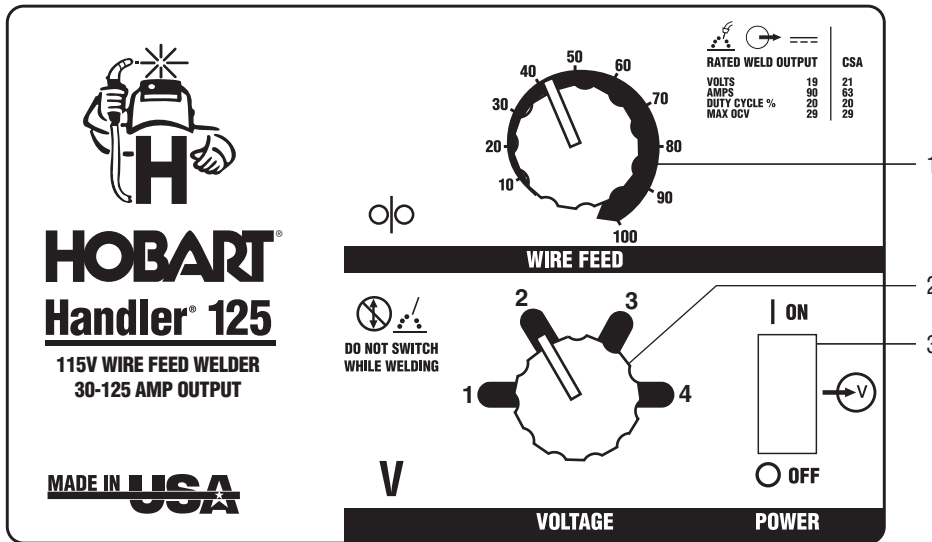
Hobart Welders An Illinois Tool Works Company

U.S. Distributor Sales Phone 920-735-4576 FAX 800-637-2315
 Hobart Retail Sales Phone 800-332-3281 FAX 937-332-4161
 Canadian Sales Phone 888-489-9353 FAX 519-421-0480
 International Sales Phone 920-735-4509 FAX 920-735-4125

Web Site HobartWelders.com



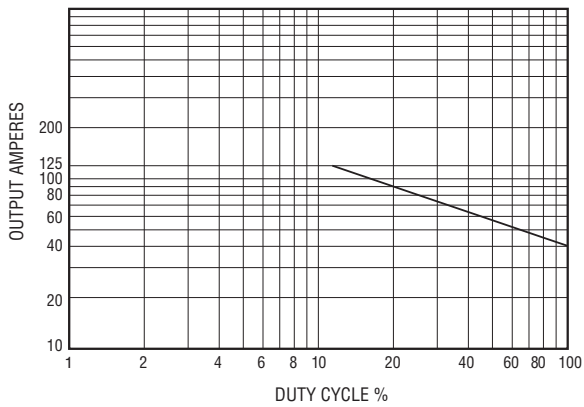
CONTROL PANEL



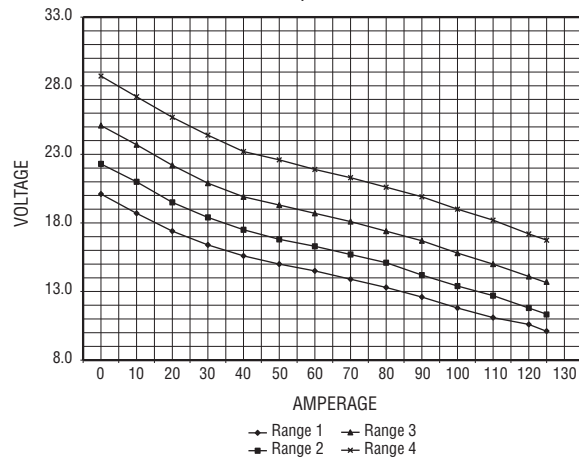
1. Wire Speed Control
2. Voltage Control Switch
3. Power Switch

PERFORMANCE DATA

DUTY CYCLE CURVE



VOLT/AMP CURVE



ACCESSORIES



MIG Conversion Kit #195158

Includes regulator, 5 ft (1.5 m) gas hose, solenoid valve and connecting leads, hose adapter, three .023/.025 in contact tips, one spool of .024 (0.6 mm) ER70S-6 solid wire, and installation instructions.

Hub Kit #195216

For using 8 in (51 mm) spools.

Replacement Drive Roll #212379

Dual-groove, one smooth groove for .023/.025 in (0.6 mm) wire and one knurled groove for .030-.035 in (0.8-0.9 mm) wire.



Small Running Gear/Cylinder Rack #194776

Durable construction. For gas cylinders no larger than 7 in (178 mm) diameter, maximum weight 75 lb (34 kg).



Protective Cover #195186

Weather-resistant nylon resists stains and mildew, and protects the finish of your welder.

H-9B Replacement MIG Gun #225397

Comes in 8 ft (2.4 m) length with liner, for .023-.035 in (0.6-0.9 mm) diameter wire.



Contact Tips (See chart below)



MIG Nozzle (See chart below) Protects tip adapter and focuses gas coverage.



Gasless Flux Cored Nozzle (See chart below) For use with self-shielding flux cored wires.

Improves visibility, eases access in tight corners, protects tip adapter/gas diffuser from spatter and from shorting to the work piece. Usable with H9, H10, M10, and M15 torches.



Tip Adapter (See chart below)



Replacement Liner (See chart below)

CONSUMABLES

Item	Hobart Package Part #*	Miller Package Part #**
Contact Tips		
.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)
MIG Nozzle	#770404	#169 715
Gasless Flux Cored Nozzle	#770487	#226 190
Tip Adapter	#770402	#169 716
Liner	#210970R	#210 970

*Available at farm and tool supply retailers.

**Available at Hobart/Miller welding distributors.

ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source	Stock No.	Description	Qty.	Price
Handler 125	#500487	115 VAC flux cored wire welding package		
UPC: #715959298711; Shipping Weight: 55 lb (25 kg); Carton Dimensions: 23-3/4 x 11-1/4 x 18-1/2 in (603 x 286 x 470 mm); Pallet Qty: 12; Pallet Dimensions: 35 x 48 x 39 in (889 x 1219 x 991 mm)				
Accessories				
MIG Conversion Kit	#195158	Includes regulator, 5 ft (1.5 m) gas hose, solenoid valve and connecting leads, hose adapter, 3 contact tips (.023/.025 in), spool of ER70S-6 solid wire, and install instructions		
Hub Kit	#195216	For 8 in spools		
Replacement Drive Roll	#212379	Dual-groove, one smooth groove for .023/.025 in (0.6 mm), and one knurled groove for .030/.035 in (0.8/0.9 mm)		
Small Running Gear/Cylinder Rack	#194776	For cylinders no larger than 7 in (178 mm), maximum weight 75 lb (34 kg)		
Protective Cover	#195186			
Replacement Gun	#225397	H-9B MIG Gun, 8 ft (2.4 m) with liner for .023-.035 in (0.6-0.9 mm) diameter wire		
Contact Tips		See chart on pg 3		
Nozzles		See chart on pg 3		
Tip Adapter		See chart on pg 3		
Replacement Liner		See chart on pg 3		
Tools and Safety Items				

Date:

Total Quoted Price:

HOBART[®]

W E L D E R S

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