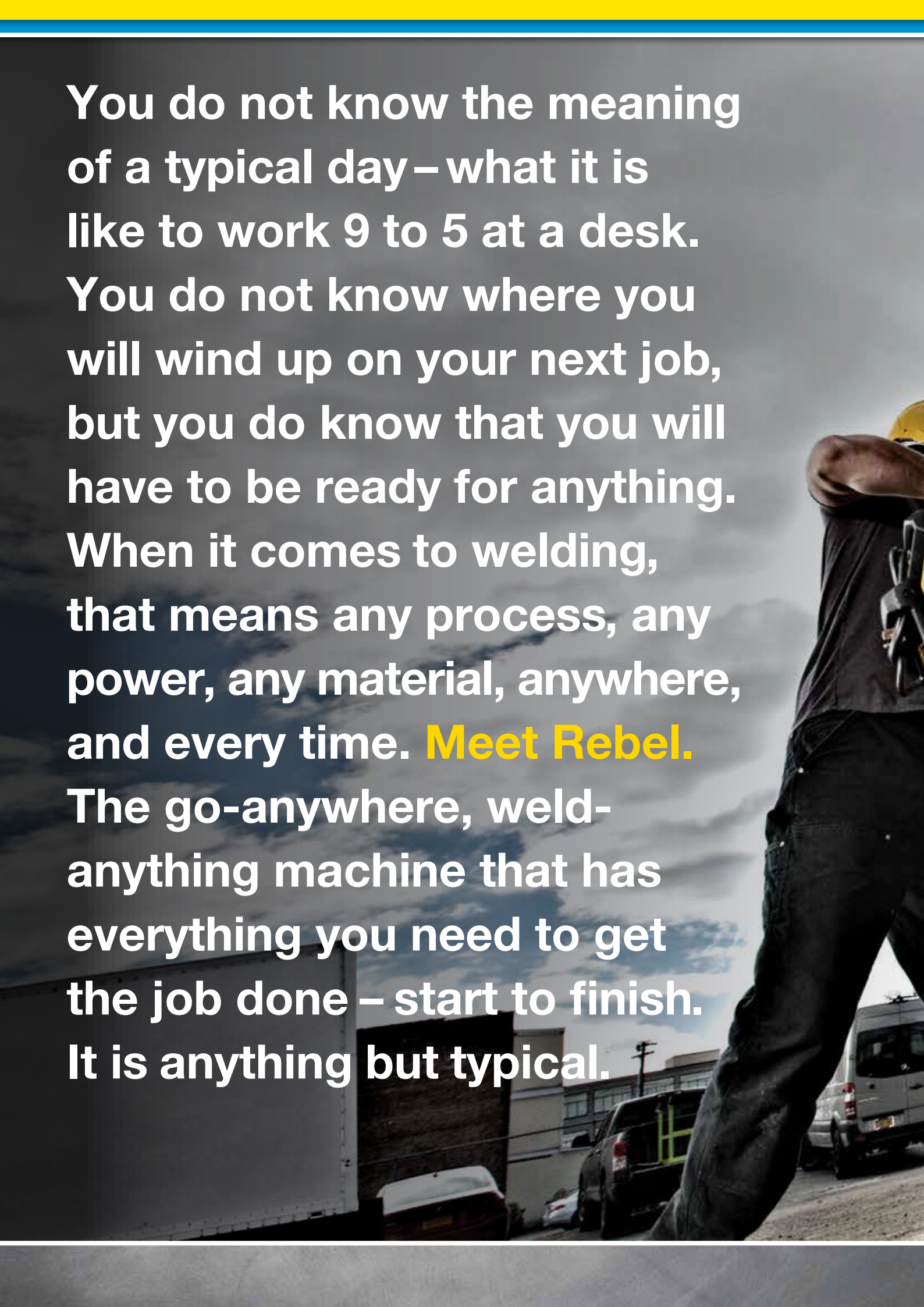




REBEL EMP 215ic
THE **TRUTH** ABOUT REBEL.

Ver. 2.0

You do not know the meaning of a typical day – what it is like to work 9 to 5 at a desk. You do not know where you will wind up on your next job, but you do know that you will have to be ready for anything. When it comes to welding, that means any process, any power, any material, anywhere, and every time. **Meet Rebel.** The go-anywhere, weld-anything machine that has everything you need to get the job done – start to finish. It is anything but typical.





GET OUT THERE AND WELD SOMETHING.

TRUTH // HIGH PERFORMANCE

Many machines claim they are multi-process, but are little more than a MIG machine in disguise. Rebel is a true multi-process welder, which means whether you are welding MIG/MAG with solid or Flux-Cored wire, MMA – even the most tricky electrodes – or Lift TIG, Rebel will perform like it was born to run that process.

TRUTH // SMART MIG TECHNOLOGY

Whether you have been welding for two years or 20, Rebel can make your job easier with sMIG (smartMIG). For the novice, there is basic mode, which makes setup simple. For the experienced, the exclusive, built-in arc control that constantly monitors your weld and adapts for superior, repeatable welds.





TRUTH // VERSATILITY

You never know what welding process your next job will require, or what kind of input power you will have available. That is why we have packed Rebel with the kinds of features that give you the flexibility to go anywhere and weld anything.

TRUTH // UNMATCHED TOUGHNESS

You are on-site, out in the field, and in the shop. So you need a machine that you can move around and that can withstand some serious wear and tear. Rebel can. With a sturdy, five-handle roll cage, steel unibody construction, and IP23S-level protection, it is the go-anywhere machine for a reason.

TRUTH // THE TOTAL PACKAGE

It takes more than a machine to get up and welding. So when you buy a Rebel, you can expect all the equipment you need to get going – right out of the box.

THE MOST INCREDIBLE MACHINE ON-SITE.

TRUE MULTI-PROCESS.

- Professional-grade MIG performance, including flux-cored
- Excellent MMA performance, including stainless steel
- Exceptional lift TIG performance down to 5A



DUAL VOLTAGE.

- 120V–230V single-phase input power
- Top-level performance across all processes – even on 120V power
- Auto-detect knows what type of input power the machine's connected to
- Runs off a 3.7 KW (120V) or 7.5 KW (230V) generator



LARGE, 4.3-IN. (86MM) COLOUR SCREEN.

- Intuitive LCD/TFT display
- Well protected by front handles and a hefty composite bezel
- Easily switch from one process to the next
- Built-in on-screen manual, spare parts listing, and welding parameters guide
- Multi-lingual capabilities

RUGGED CASE DESIGN.

- Five-handle roll cage for easy transport and handling
- Steel unibody housing for increased protection and superior durability
- Recessed body panels for increased strength



READY-TO-WELD.

- TWECO Fusion 250 MIG Torch, 3m
- Electrode Holder Kit, 3m
- Work Lead, 3m
- Gas Hose including quick connector, 4.5m
- 200mm Spool OK AristoRod 12.50, 0.8mm wire
- Feed Rolls and Contact tips to suit



sMIG TECHNOLOGY.

- Exclusive, built-in dynamic arc control that constantly monitors complex arc characteristics adapting to your technique to provide a smooth, stable arc and superior, repeatable welds
- Produces less spatter
- Two modes – basic and advanced

Basic mode reduces the MIG learning curve – set wire diameter and material thickness and you are ready to weld

Advanced mode gives full control to adjust the arc characteristics to your liking

SELECT WIRE DIAMETER



SET MATERIAL TYPE AND THICKNESS



START WELDING AND sMIG DOES THE REST



THE DRIVE TO DO IT ALL.

SOLID CAST ALUMINIUM FEEDER.

The design of this cast feeder mechanism increases durability, decreases wire shavings and bird nesting, provides for easy drive roll changes (no tools required), and delivers consistent feeding performance. All in all it has optimised alignment and long-life drive stand components that ensure accurate, smooth wire feeding.

LIGHTWEIGHT.

Rebel's 18kg design makes it easy to carry from jobsite to jobsite.



MULTI-MATERIAL.

Weld steel, stainless, and even aluminium.

WELD PARAMETER STORAGE.

Save up to four welding parameters per process; ideal for switching between jobs.

TRIGGER HOLD FUNCTION 2T/4T.

Reduces operator fatigue when MIG or TIG welding.

INFINITE VOLTAGE CONTROL.

Fine-tune the arc characteristic by adjusting the voltage setting.

ADJUSTABLE INDUCTANCE.

Perfect for fine-tuning arc stability and controlling spatter.

ADJUSTABLE BURN-BACK CONTROL.

Prevents wire from sticking in the weld pool or burning back, damaging the contact tip.



ADJUSTABLE ARC FORCE CONTROL.

Optimises MMA electrode performance and allows the operator to increase the arc voltage for a short period of time to avoid arc outs and “sticking” when the arc is too short.

ADJUSTABLE HOT START CONTROL.

Increases the initial welding current to avoid the electrode sticking to the workpiece; particularly useful for difficult-to-start electrodes.

LIFT TIG ARC STARTS.

Provides TIG arc starts without the use of high frequency. Ideal for the shop or site application where sensitive electronic devices operate.

GAS PRE- AND POST-FLOW TIME ADJUSTMENT.

Purges gas line and prevents porosity at the start and end of welding; especially useful when MIG welding aluminium.

IP23S.

The enclosure is built to protect you and your machine. Designed to a higher standard, Rebel can withstand harsh outdoor environments.

VRD.

Standards compliant Voltage Reduction Device
Virtually eliminates electric shocks when not welding (Stick Mode).

WARRANTY.

Rebel comes backed with a rock-solid, three-year, handle-to-handle warranty.



GET TO KNOW YOUR REBEL.

PROCESS

MIG/MAG and Flux-Cored
MMA
Lift TIG

MATERIAL

Mild Steel
Stainless Steel
Aluminium

REBEL FEATURES

sMIG
4.3-in. (86 mm) Colour LCD/TFT Display
Ready-to-Weld (accessories included – including sample filler metals)
230V/120V Dual Voltage Input
Weld Parameter Storage
Hot Start (MMA mode only)
Arc Force (MMA mode only)
Lift Arc (TIG mode only)
Trigger Lock (2T, 4T)
Voltage Trim Adjustment (MIG mode only)
Inductance Adjustment (MIG mode only)
Burn Back Adjustment (MIG mode only)
Pre-Flow/Post-Flow Adjustment (MIG mode only)
Spool Gun Ready (Compatible with Tweco SGT250 Spool Gun)
VRD (Voltage Reduction Device)
Over Temp Cut Out
Euro Torch Connection
Integrated Wire Feed Unit
5 Handle Roll Cage

TECHNICAL DATA

Current Range	5-150A (120V), 5-240A (230V)
Supply Lead	15A
MIG (MAG) Welding Output	205A/24.3V (230V) @ 25% 130A/20.5V (120V) @ 20%
MMA (SMAW) Welding Output	180A/27.2V (230V) @ 25% 90A/23.6V (120V) @ 40%
TIG (GTAW) Welding Output	180A/17.2V (230V) @ 30% 130A/15.2V (120V) @ 40%
Max Plate Thickness	9.5mm
Protection Class	IP23S
Approvals	IEC/EN 60974-1, 5, 7, 10, 12, 13. RoHS
Generator Size Recommendation	7.5 KW (230V); 3.7 KW (110V)
Weight	18.2kg
Dimensions	(H 406mm x W 229mm x D 584mm)
Warranty	3 Years – handle to handle



ORDERING INFORMATION

Tweco Fusion 250 MIG Torch (Euro), 3m	W4013701
Stick electrode holder with 3m lead	0700006900
Work Lead, 3m	0700006901
Nozzle 13mm	OTW22/50
Nozzle 16mm	OTW22/62
Contact Tip 0.6mm	OTW14/23
Contact Tip 0.8mm	OTW14/30
Contact Tip 0.9mm	OTW14/35
Contact Tip 1.0mm	OTW14/40
Contact Tip 1.2mm	OTW14/45
Insulator	OTW32
Gas Diffuser	OTW52
Liner 0.8-0.9mm Hard Wire	OTW42/3035
Liner 1.0-1.2mm Hard Wire	OTW42/4045
Liner 0.9-1.2mm Soft Wire	OTW42N/3545
Wire Outlet Guide - Steel Fe/SS/Flux Cored: 1.0-1.2mm	0558102460
Wire Outlet Guide - Steel Fe/SS/Flux Cored: 0.6-0.8mm	0558102461
Wire Outlet Guide - Teflon Aluminium: 1.0-1.2mm	0464598880
Wire Inlet Guide Fe/SS/Flux Cored: 0.6/0.8/0.9/1.2mm	0558102328
Feed Roll 'V' Groove Fe/SS: 0.6/0.8mm	7977036
Feed Roll 'V' Groove Fe/SS: 0.9/1.2mm	7977660
Feed Roll 'V' Knurled Flux Cored: 0.8/0.9mm	7977732
Feed Roll 'V' Knurled Flux Cored: 1.2/1.6mm	704277
Feed Roll 'U' Groove Aluminium: 0.8/0.9mm	7977731
Feed Roll 'U' Groove Aluminium: 1.0/1.2mm	7977264

DARE // MAKE THE MOVE TO ESAB. PICK UP THE MOST INCREDIBLE GO-ANYWHERE, WELD-ANYTHING MACHINE. FIND OUT MORE AT ESAB.COM/REBEL.

ESAB REBEL EMP 215ic PACKAGE INCLUDES:

0700300993

- Tweco Fusion 250 MIG Torch (Euro), 3m
- Stick electrode holder with 3m lead
- Work Lead, 3m
- CIGWELD COMET Professional Argon Regulator/Flowmeter
- Gas hose includes quick connector, 4.5m
- OK AristoRod 12.50, 200mm Spool, 0.8mm wire, 5kg (1A5008460H)
- Contact Tips & Feed Rolls to suit



OPTIONAL ACCESSORIES.

**TIG Torch ET 17V,
4m with 8-Pin Plug**
(0700300869)



Foot Control for TIG applications,
4.5m cable (W4014450)



Rebel Single Cylinder Trolley
(0558102491)



Sentinel A-50 Welding Helmet
(0700000800)



Tweco SGT250 Spool Gun
(W4011250)



Tweco Organiser Box, consumables
for Fusion 150/250 MIG Torches and
SGT250 Spool Gun (W4012300)



A Complete Line of Filler Metals Including:

- **Solid Wire**
OK Aristorod 12.50
- **Stainless Steel**
OK Autrod 309LSi
OK Autrod 316LSi
- **Cored Wire**
Coeshield 15
OK Tubrod 15.15
- **MMA Electrodes**
OK 46.00
OK 63.30
OK 53.16





UNRIVALED SERVICE AND SUPPORT.

Rebel, like every ESAB machine, is backed by our commitment to superior customer service and support. Our skilled customer service department is prepared to quickly answer any questions, address problems, and help with maintenance and upgrading of your machines. Our products are backed with the most comprehensive warranty in the business.

With ESAB, you can be sure that you purchased a machine that will meet your needs today and in the future. Product and process training is also available. Ask your ESAB sales representative or distributor for a complete ESAB solution.

For more information, visit esab.com/dare.

3-YEAR WARRANTY.

ESAB's industry-leading service and support means that if you do need help, you will be protected by the most comprehensive warranty in the business.



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