

Handler® 190

230-Volt Wire Feed Welder



251091
March 2020

230 V

Spool Gun Ready



IMPROVED!

Now with **NEW!**
HR-100 MIG gun.

Quick Specs

DC CV 1 Phase

Welding Amp Range

25–190 A

Rated Output

130 A at 21.5 VDC, 30% duty cycle

Mild Steel Thickness Range

24 ga.–5/16 in.

5/3/1
INDUSTRIAL
WARRANTY

Reliable. Durable. Superior arc with 190 A of power.

Weld as thin as 24 gauge up to 5/16 inch in a single pass with a broad output range of 25–190 amps. Easily weld thicker materials with multiple passes.

Quick and easy setup with Quick Select™ drive rolls which offer three grooves — two for different sizes of solid wire and a third for flux-cored wire.

Easy to set and adjust for different materials and thicknesses — features seven output voltage settings for finer control, less spatter and cleaner welds.

The Handler 190 also features a direct plug-in for the optional SpoolRunner 100 spool gun. The use of a spool gun eliminates wire feed problems associated with soft aluminum wire and other mild or stainless steel wires.

Applications

- Maintenance/repair
- Auto body
- DIY
- Farm/ranch applications
- Metal art
- Home repair

500554 (machine only)
500554001 (with SpoolRunner™ 100)

Includes

- 10 ft. (3 m) HR-100 MIG gun with ergonomic, rubber-padded handle
- 10 ft. (3 m) work cable with clamp
- Power cord with plug
- Built-in gas solenoid valve and dual-gauge regulator with gas hose
- .030 in. (0.8 mm) contact tips
- Quick Select™ drive roll for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire
- Sample spool of .030 in. (0.8 mm) self-shielding flux-cored wire
- Material thickness gauge

Features	Benefits
Seven-position voltage control and infinite wire feed speed	Offers easier fine control of the output parameters for improved arc performance with less spatter, and better bead appearance with less clean up.
Spool gun ready	Spool guns enhance feedability and reduce “bird-nesting” associated with soft aluminum wires. No additional control box or adapter is required to connect the SpoolRunner 100 spool gun.
Built-in wire feeder with quick-release drive roll lever	Positive feed with adjustable tension plus easy accessibility to thread new wire.
Spool hub assembly accommodates 4- or 8-inch spools	Offers you flexibility to use small or large spools of wire to better suit your welding needs.
Convenient polarity changeover with tip holder	Access makes it quick and easy to change polarity for solid or tubular wire. Includes convenient storage holes for spare tips.
Quick Select drive roll	Makes setup quicker by offering three grooves — two for different sizes of solid wire and a third for flux-cored wire.
Hobart 5/3/1 industrial warranty	Five-year warranty on transformers, stabilizers and main rectifiers; three years on generators, PC boards and drive systems; and one year on guns (MIG, plasma and TIG torches).



Hobart Welding Products

An ITW Welding Company
Sales: 800-626-9420
Service: 800-332-3281

HobartWelders.com



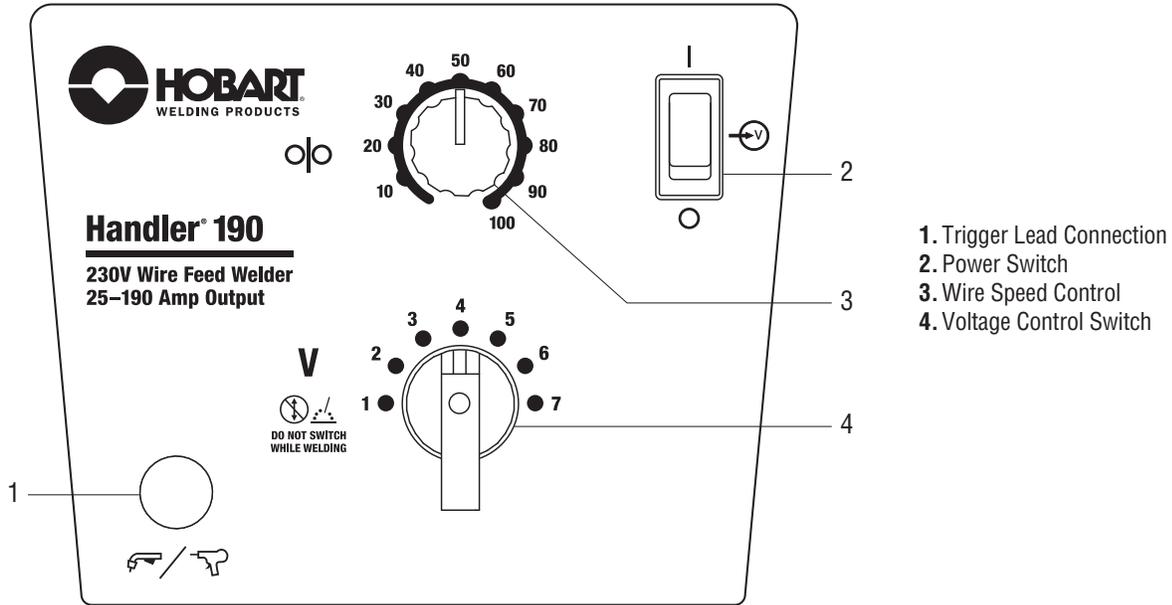
Specifications (Subject to change without notice.)



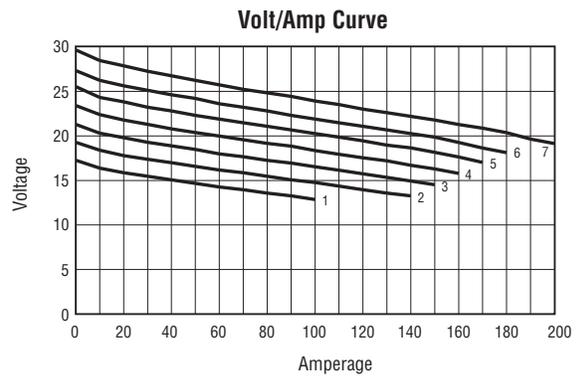
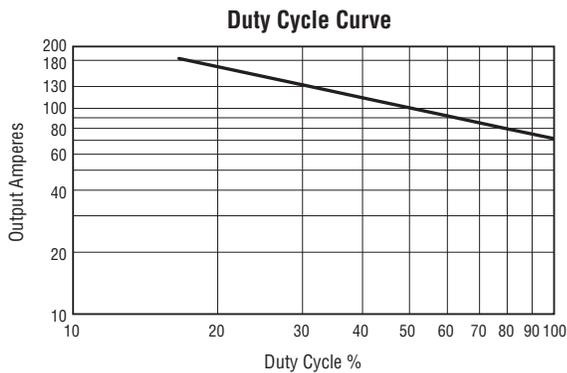
Welding Amp Range	Rated Output	Amps Input at Rated Output, 60 Hz			Max. Open Circuit Voltage	Wire Feed Speed Range	Dimensions	Net Weight
		230 V	KVA	KW				
25–190 A	130 A at 21.5 VDC, 30% duty cycle on 60 Hz	20.5	4.7	3.88	31 VDC	40–700 ipm 50–740 ipm at no load	H: 12.375 in. (315 mm) W: 10.625 in. (270 mm) D: 19.5 in. (495 mm)	68 lb. (31 kg)

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

Control Panel



Performance Data



Accessories



SpoolRunner™ 100 Spool Gun 300796

- 10 ft. (3 m) cable
- Weld 16 gauge–3/16 in. (1.6–4.8 mm) aluminum with the Handler 190
- Rated at 150 amps at 60-percent duty cycle
- For .023–.035 in. (0.6–0.9 mm) aluminum, steel and stainless steel wire on 4 in. (102 mm) diameter spools
- Includes rugged plastic carrying case
- Shipped with three .030 in. (0.8 mm) and three .035 in. (0.9 mm) contact tips



HR-100 Replacement MIG Gun 284546

Comes in 10 ft. (3 m) length with liner for .030–.035 in. (0.8–0.9 mm) diameter wire.



Protective Cover 195186

Weather-resistant nylon resists stains and mildew while protecting the finish of your welder.



Small Cart/Cylinder Rack 194776

Designed for portable MIG welders. Accommodates large and small gas cylinders.

Consumables

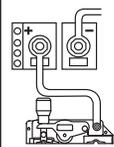
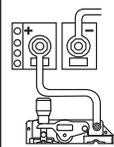
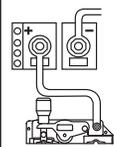
Item	For HR-100 Gun/Power Source — Hobart Package Part #	For HR-100 Gun — Miller Package Part #	For SpoolRunner 100 — Hobart Package Part #
Contact Tips			
.023/.025 in. (0.6 mm)	770174 (5 per package)	087299 (10 per package)	199730 (5 per package)
.030 in. (0.8 mm)	770177 (5 per package)	000067 (10 per package)	186419 (5 per package)
.035 in. (0.9 mm)	770180 (5 per package)	000068 (10 per package)	186406 (5 per package)
.045 in. (1.2 mm)	770183 (5 per package)	000069 (10 per package)	—
MIG Nozzle	770404	169715	186405
Gasless Flux-cored Nozzle	770487	226190	—
Tip Adapter	770402	169716	—
Liners			
.023/.025 in. (0.6 mm)	196139	194010	—
.030/.035 in. (0.8/0.9 mm)	196139	194011	—
.035/.045 in. (0.9/1.2 mm)	196140	194012	—
Power Source Drive Rolls			
Quick Select™ drive roll for .024 in. (0.6 mm) or .030/.035 in. (0.8/0.9 mm) solid wire, and .030/.035 in. (0.8/0.9 mm) flux-cored wire	261157	261157	—
Dual-groove, V-knurled drive roll for .030–.035 in. (0.8–0.9 mm) and .045 (1.2 mm) flux-cored wire	202926	202926	—
SpoolRunner 100 Drive Roll			
For .023 in. (0.6 mm) wire	—	—	199731
For .030/.035 in. (0.8/0.9 mm) wire	—	—	186413
SpoolRunner 100 Push Roll			
For .023 in. (0.6 mm) wire	—	—	199732
For .030/.035 in. (0.8/0.9 mm) wire	—	—	186414

Handler® 190 Welding Guide

The Handler 190 is capable of running the following wires: .023–.035 in. (0.6–0.9 mm) mild steel or stainless steel
 .030–.045 in. (0.8–1.2 mm) flux-cored
 .030–.035 in. (0.8–0.9 mm) aluminum

Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

Recommended Voltage and Wire Speed Settings for thickness of metal being welded.
 Number on left of slash is Voltage Setting/Number on right of slash is Wire Feed Setting.

Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas 20–30 CFH Flow Rate	Diameter of Wire Being Used	Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting/Number on right of slash is Wire Feed Setting.								CHANGING POLARITY
				24 ga. .024 in. (0.6 mm)	20 ga. .036 in. (0.8 mm)	18 ga. .048 in. (1.2 mm)	16 ga. .060 in. (1.6 mm)	11 ga. 1/8 in. (3.2 mm)	3/16 in. (4.8 mm)	1/4 in. (6.4 mm)	5/16 in. (8.0 mm)	
Steel	Solid Wire ER70S-6 (DCEP)	C ₂₅ Gas Mixture 75% Argon/25% CO ₂ Produces less spatter. Better appearance.	.024" (0.6 mm)	1/30	2/40	3/50	4/60	5/80	6/90	—	—	DCEN Electrode Negative for Flux-Cored Wire 
			.030" (0.8 mm)	—	1/40	2/50	3/50	5/60	6/60	6/70*	7/80*	
			.035" (0.9 mm)	—	3/40	4/40	5/40	5/50	6/50	7/50*	7/60*	
Steel	Solid Wire ER70S-6 (DCEP)	100% CO ₂	.024" (0.6 mm)	—	—	3/35	5/40	5/60	6/80	7/90*	—	
			.030" (0.8 mm)	—	—	4/40	5/40	5/50	6/50	7/50*	7/50*	
			.035" (0.9 mm)	—	—	3/25	4/25	5/40	6/40	7/40*	7/40*	
Stainless Steel	Stainless Steel (DCEP)	Tri-Mix 90% He/7.5% Ar/2.5% CO ₂	.024" (0.6 mm)	—	3/40	3/40	4/50	6/60	7/70	—	—	
			.030" (0.8 mm)	—	3/30	3/35	4/30	5/35	6/50	7/50*	—	
			.035" (0.9 mm)	—	3/15	3/35	4/30	5/40	7/40	7/50*	—	
Steel	Flux Core E71T-11 (DCEN)	No Shielding Gas Required Good for windy or outdoor applications.	.030" (0.8 mm)	—	1/35	1/40	2/40	4/60	5/40	6/40*	—	DCEN Electrode Positive for Solid Wire 
			.035" (0.9 mm)	—	1/30	1/35	2/40	3/50	5/50	6/60	7/60*	
			.045" (1.2 mm)	—	—	—	1/25	3/30	4/35	5/35	6/35*	
Aluminum with Optional SpoolRunner™ 100 Spool Gun	Aluminum** 4043 AL (DCEP)	100% Argon**	.030" (0.8 mm)	—	—	—	1/55	5/80	6/85	—	—	
	.035" (0.9 mm)		—	—	—	—	5/60	6/70	7/80	—		
Aluminum with Optional SpoolRunner™ 100 Spool Gun	Aluminum** 5356 AL (DCEP)	100% Argon**	.030" (0.8 mm)	—	—	—	1/75	5/95	6/100	—	—	
	.035" (0.9 mm)		—	—	—	—	5/75	6/90	7/100	—		

Match feed roll groove to diameter of wire being used.
 Set tension knob setting to 3 at start.
 Adjust tension per instructions in the manual.

CAUTION! Do not change voltage switch position while welding. See owners manual for more information.

Wire speed listed is a starting value only. Wire speed setting can be fine-tuned while welding. Wire speed also depends on other variables such as stick out, travel speed, weld angle, cleanliness of metal, etc.

*Multiple passes may be required depending on the application and joint design.

**Aluminum wire settings are with the SpoolRunner™ 100 spool gun attached. A spool gun eliminates many feedability issues associated with the soft aluminum wire. A "push angle" for the torch is normally recommended for aluminum.

Typical Installation for Optional SpoolRunner™ 100 Spool Gun to Handler 190

It's quick and easy to install the SpoolRunner 100 spool gun on the Handler 190. Just plug the power pin of the spool gun into the feedhead, attach the trigger lead and flip the switch on the inside panel for spool gun operation. Install the correct wire and gas for the job and it's ready to go.

