

Fabricator[®] 210



250
AMP

CV

DC

208
V

230
V

60Hz

1
PHASE

GOLD WARRANTY
5 Year*



Power, Performance, Features... and Reliability

Fabricator 210 comes with:

- Power cord and plug
- 15ft (4.5m), 250 Amp WeldSkill MIG gun
- 10ft (3m) work cable and clamp
- Gas regulator/flowmeter
- Factory fitted gear/cylinder rack
- .035"/.045" reversible drive roll
- Cable storage hook

New Gun. 15ft (4.5m) heavy duty Tweco[®] WeldSkill MIG gun.

Overload Protection. Shuts down the power source to protect the internal electrical components from over heating.

Heavy Duty Transformer. The transformer is built to last using premium quality 428°F materials and fully dip varnished then baked for 4 hours.

New Cylinder Rack. Drop down cylinder rack allows for easy cylinder mounting.

New Storage Box. Conveniently located in the wire compartment for all your drive rolls and gun consumable parts.

New Dual Cylinder Option. Optional dual cylinder rack for mounting two cylinders.

Heavy Duty Drive Rolls. Professional heavy duty 2-roll drive system featuring quick change reversible drive rolls (no tools required) and easy-to-set single scaled wire tension knob for smooth repeatable performance.

Improved. Wire compartment design allows easy installation of the wire spool.

ISO 9001 Quality System. The certified quality management system guarantees the manufacture and distribution processes of this product.

NEW 16 Voltage Taps. Providing a wider operating range of 20 to 250 Amp with an extremely smooth and stable arc characteristic. Unbeatable performance from 24 gauge to 1/2" (12.7mm) thick in a single pass.

Simple Operation. Just refer to our comprehensive weld set up guide for optimum welding performance over a wide range of materials and shielding gases.

Dual Gas Valves. Twin gas valves ready for spool gun welding.

Spool Gun Ready. New factory fitted 'run ready' with 10 pin receptacle, just 'plug 'n play'.

Timer Kit. Standard feature adding 2-step, 4-step trigger interlock, spot, dwell and stitch weld timer.

Higher Output. The Fabricator 210 now punches out 250 Amp maximum output.

Quick Change Polarity. Simple, quick change (no tools required) polarity and spool gun change-over from the front of the power source.

Quick Specifications

Processes

MIG (GMAW)
Flux Cored (FCAW)

Industrial Applications

Maintenance and Repairs
Auto Body Repairs
Technical Schools
Farm/Ranch

Rated Output

210 Amp at 25.3V, 40% Duty Cycle
176 Amp at 23.6V, 60% Duty Cycle

Max. Open Circuit Voltage

42V DC

Amperage Range

20 - 250 Amp

Wire Feed Speed

80 - 800 IPM (2 - 20 m/min)

Weight

200 lb (91 kg)

Order Information

Part No: 100047B-001

Description: Fabricator 210
208/230/1/60

* Limited warranty, refer to warranty schedule

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THERMAL ARC
Professional



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Features*



Our comprehensive set-up chart explains how to produce optimized welding parameters



Easy installation wire spool compartment



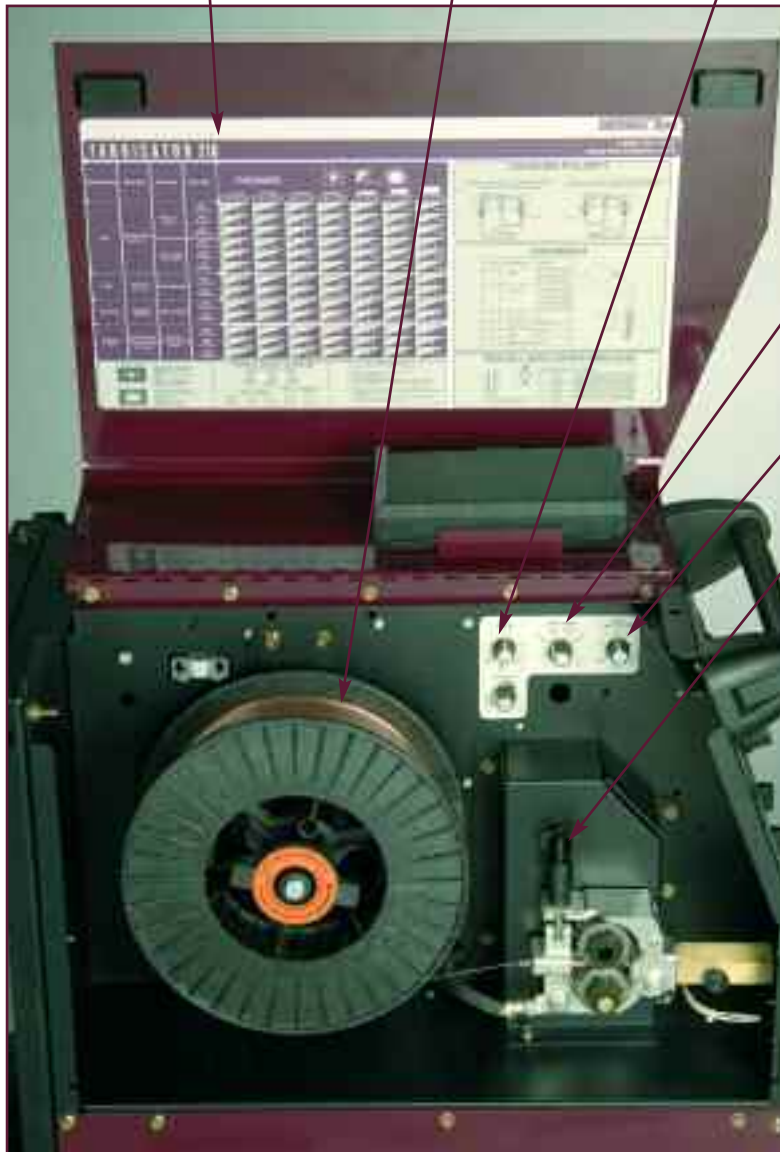
Burnback control



Dwell control, off weld time for stitch welding and weld mode selector control



Spot weld control or on weld time for stitch welding



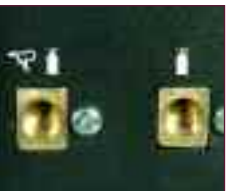
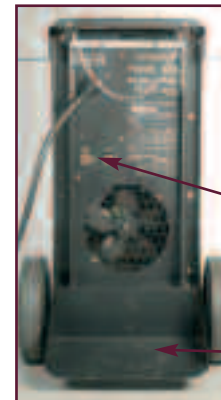
The 2 roll wire drive system with quick change drive rolls & single tension knob



TWECO[®] No. 4 gun connection



Fully varnished and baked mains transformer is built to last



The additional gas valve is designed to accommodate spool gun gas

Cylinder stand allows easy loading for cylinder

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Specifications*

Welding DC

Maximum output	250 Amp
Maximum duty cycle @ 104°F	30% @ 250 Amp at 26.2V
Output at 40% Duty Cycle @ 104°F	210 Amp at 25.3V
Output at 60% Duty Cycle @ 104°F	176 Amp at 23.6V
Output at 100% Duty Cycle @ 104°F	137 Amp at 21.0V
Current Range	20-250 Amp
Number of Voltage Settings	16
Welding Voltage Range	15.2-26.2 Volt
Maximum Plate Thickness	1/2" (12.7mm)
Wire Diameter Range	
Mild Steel: .023" - .045"	(0.6 - 1.2mm)
Stainless Steel: .023" - .045"	(0.6 - 1.2mm)
Aluminum: .030" - .045"	(0.8 - 1.2mm)
Flux cored: .030" - .045"	(0.8 - 1.2mm)
Fitted Feedroll Suits MIG Wire	.035" - .045" (0.9 - 1.2mm)
Warranty Period	5 Years*
Approvals	CSA (Pending); IEC 60974-1 (CE)

Primary Power

Primary Voltage	208/230 Volt
Supply Plug	NEMA 6-50P
Rated kVA @ 250 Amp	11.2 kVA
Rated Input Current	54/49 Amp

MIG Guns

Gun Type	250 Amp TWECO WeldSkill
Gun Length	15ft (4.5m)
Part Number	20584
Nozzle	Part No: 22-50 Size: 1/2" (12.7mm)
Contact Tip	Part No: 14-35 Size: .035" (0.9mm)
Diffuser	Part No: 52
Nozzle Insulator	Part No: 32
Liner	Part No: 42-3035-15 Size: .030" - .035" (0.8-0.9mm)



Dimensions & Weight

Dimensions	HxWxD	32" x 21" x 36.8"	(813 x 533 x 935mm)
Weight		200 lb (91 kg)	

Process Capabilities*

Process	Electrode Wire	Electrode Polarity	Shielding Gas	Min Thickness	**Max Thickness
MIG (GMAW) Mild Steel	.023", .030", .035", .040", .045" (0.6, 0.8, 0.9, 1.0, 1.2mm) Autocraft 70S-6	DC+	CO ₂ (100%) or Argon/CO ₂	22 gauge (0.8mm)	1/2" (12.7mm)
MIG (GMAW) Stainless Steel	.030", .035", .040", .045" (0.8, 0.9, 1.0, 1.2mm)	DC+	Argon/CO ₂ or Tri-Mix	22 gauge (0.8mm)	1/2" (12.7mm)
MIG (GMAW) Aluminum	.030", .035", .045" (0.8, 0.9, 1.2mm)	DC+	Argon (100%)	18 gauge (1.2mm)	1/2" (12.7mm)
Flux Cored Gas Shielded Mild Steel	.035", .045" (0.9, 1.2mm)	DC+	CO ₂ (100%) or Argon/CO ₂	16 gauge (1.6mm)	1/2" (12.7mm)
Flux Cored Self Shielded Mild Steel	.030", .035", .045" (0.8, 0.9, 1.2mm)	DC-	N/A	18 gauge (1.2mm)	1/2" (12.7mm)

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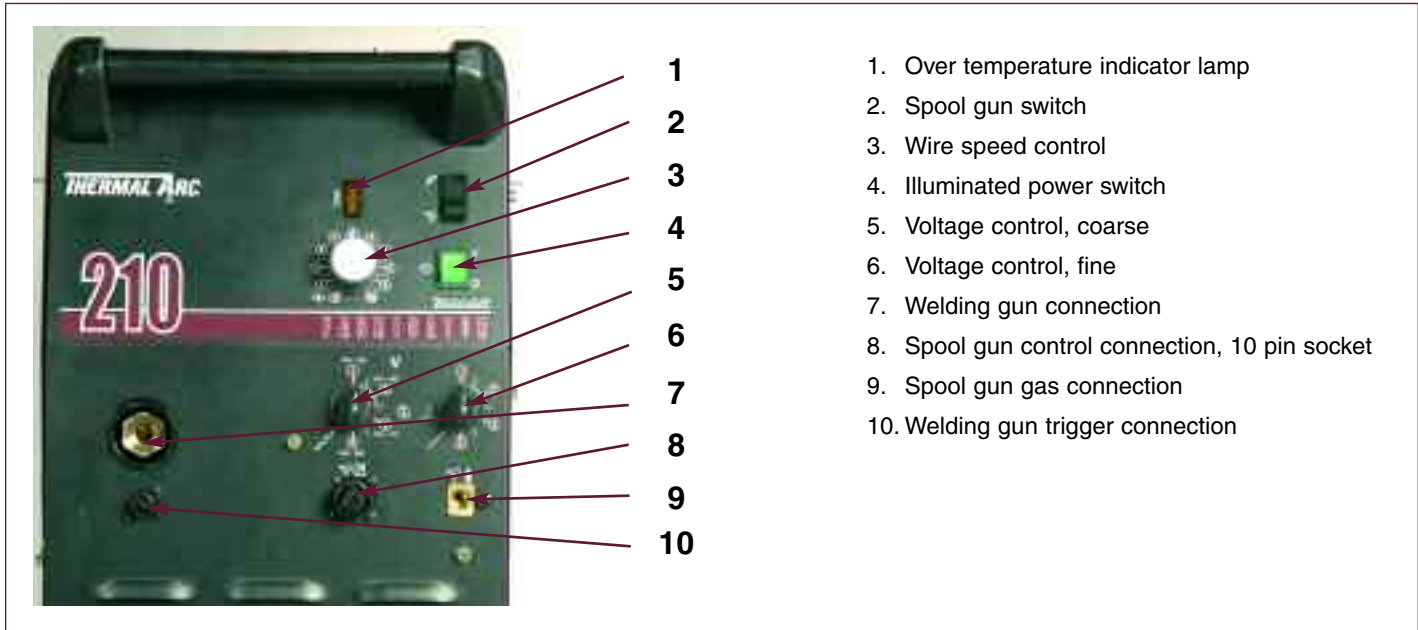
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Key Control*



1. Over temperature indicator lamp
2. Spool gun switch
3. Wire speed control
4. Illuminated power switch
5. Voltage control, coarse
6. Voltage control, fine
7. Welding gun connection
8. Spool gun control connection, 10 pin socket
9. Spool gun gas connection
10. Welding gun trigger connection

Accessories*



Dual Cylinder Rack
Part No. W4010002

Optional dual cylinder rack provides easy loading for two gas cylinders. Allows both the push gun and a spool gun to be connected to the same machine.

Optional MIG Guns*



Tweco[®] Spray Master™ 250 MIG Gun
Part No. MS212-3545 12ft (3.6m)
Part No. MS215-3545 15ft (4.5m)

The 250 Amp Tweco Spray Master is the coolest MIG gun for your hottest spray welding applications. Rated at 80% duty cycle using Argon/CO₂.

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Tweco No. 2 MIG Gun
Part No. 212-3035 12ft (3.6m)
Part No. 212-4045 15ft (4.5m)

Tweco No. 2 is the professional's choice MIG gun. It's rated at 250 Amp at 60% duty cycle using CO₂ gas.



Tweco Spool Gun
Part No. 90906

Tweco spool gun is ideal for welding .023-.035in (0.6-0.9mm) filler metals such as aluminum, stainless steel and most other MIG wires. Rated at 300 Amp @ 60% duty cycle.

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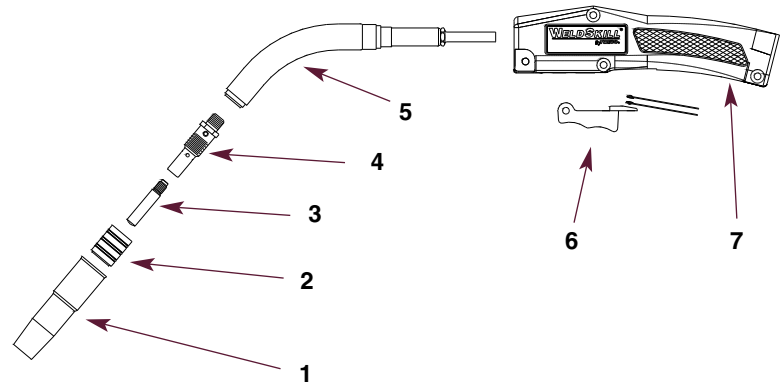
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250 Amp TWECO[®] WeldSkill[®] MIG Gun* Part No. 20584

Item	Part No.	Description	Qty
1	22-50	Nozzle	1
2	32	Nozzle Insulator	1
3	14-35	Contact Tip	1
4	52	Gas Diffuser	1
5	WM62J-50	Conductor Tube	1
6	WM91	Trigger	1
7	TA1-80	Handle Assembly	1



Contact Tips

14-23	.023" (0.6mm)
14-30	.030" (0.8mm)
14-35	.035" (0.9mm)
14-40	.040" (1.0mm)
14-45	.045" (1.2mm)

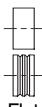

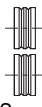



Nozzles

22-37	3/8" (9.5mm)
22-50	1/2" (12.7mm)
22-62	5/8" (16mm)

Conduits

42-23-15	.023", 15ft (7.6m)
42-3035-15	.030"- .035", 15ft (4.5m)
42-4045-15	.040"- .045", 15ft (4.5m)
42N-3545-15	.035"-3/64", 15ft (4.5m)

Drive Roll Kits (#375980-Series) 2 Roll

	Style 1	Style 2	Style 3	Style 4	Style 5	Style 6
Top	 Flat	 Flat Knurled	 Double Smooth 'V'	 Double Knurled 'V'	 Double Cog	 Double 'U'
Bottom	Double Smooth 'V'	Double Smooth 'V'	Double Smooth 'V'	Double Knurled 'V'	Double Cog	Double 'U'
Wire Type	Hard	Hard	Soft/Hard/Tubular	Hard/Tubular	Tubular	Soft (Aluminum)
Wire Size						
.023" / 0.6mm	375980-031	-	-	-	-	-
.030", .035" / 0.8, 0.9mm	375980-001	375980-003	375980-010	-	-	-
.030", .035", .045" / 0.8, 0.9, 1.2mm	375980-028*	375980-029	-	-	-	-
.035" / 0.9mm	375980-040*	-	-	-	-	375980-032
.035", .045", 3/64" / 0.9, 1.2, 1.2mm	-	-	375980-030	-	-	-
.045" / 1.2mm	375980-002*	375980-004	-	375980-092	375980-022	-
3/64" / 1.2mm	-	-	375980-011	-	-	375980-033
.052" / 1.3mm	375980-090*	-	-	-	-	-
.052", 1/16" / 1.3, 1.6mm	-	-	375980-012	375980-017	375980-023	-
1/16" / 1.6mm	375980-005*	-	-	-	-	375980-034
.068" / 1.7mm	-	-	-	-	-	-
5/64" / 2.0mm	375980-006*	-	-	375980-018	-	-
3/32" / 2.4mm	-	-	-	375980-019	-	-
7/64" / 2.8mm	-	-	-	375980-020	-	-
1/8" / 3.2mm	-	-	-	375980-021	-	-

NOTE: 1. Drive roll kits include: drive rolls and wire guides. 2. Drive roll kits with * have a narrow 30° 'V'.

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Ordering Information

EQUIPMENT OPTIONS	PART NO.	DESCRIPTION	QTY	PRICE
Fabricator[®] 210 Package	100047B-001	Fabricator 210, 250 Amp Tweco [®] Weldskill MIG gun, 2 roll wire feed system, single cylinder rack, 6ft (1.8m) gas hose, gas regulator/flowmeter, 10ft (3m) work lead		
GUNS				
Tweco [®] WeldSkill 12ft	20584	Gun assembly with 12ft cable (supplied with package), 250 Amp @ 30%		
Tweco No. 2 12ft	212-3035	Gun assembly with 12ft cable, 250 Amp @ 60%; gun lead MSAK-354 required		
Tweco No. 2 15ft	212-4035	Gun assembly with 15ft cable, 250 Amp @ 60%; gun lead MSAK-354 required		
Tweco Spray Master [™] 12ft	MS212-3545	Gun assembly with 12ft cable, 250 Amp @ 80%		
Tweco Spray Master 15ft	MS215-3545	Gun assembly with 15ft cable, 250 Amp @ 80%		
Spool Gun 25ft	W4011000	Gun assembly with 25ft cable, 200 Amp @ 60%		
Tweco Spool Gun 25ft	90906	Gun assembly with 25ft cable, 300 Amp @ 60%		
ACCESSORIES				
MIG gun control lead & 4 pin plug	MSAK-354	Connection lead between TWECO MIG guns & Fabricator 210		
Dual Cylinder Rack	W4010002	Easy fit, dual cylinder rack mounts 2 cylinder		
Victor Regulator/Flowmeter Mixed Gases	0781-2723	Medalist [™] 1400 Series, HRF Flowmeter Regulator, Argon-Argon/CO ₂ mix gases		
Victor Regulator/Flowmeter CO ₂	0781-2725	Medalist 1400 Series, HRF Flowmeter Regulator, CO ₂ gas		
Helmet/Gloves				
CONSUMABLES				
Drive Roll Kit .023" (0.6mm)	375980-031	1 smooth double V grooved drive roll, 1 flat pressure roll, input & output guides		
Drive Roll Kit .030"-.035" (0.8-0.9mm)	375980-001	1 smooth double V grooved drive roll, 1 flat pressure roll, input & output guides		
Drive Roll Kit .045" (1.2mm)	375980-002	1 smooth double V grooved drive roll, 1 flat pressure roll, input & output guides		
Drive Roll Kit .052" (1.3mm)	375980-090	1 smooth double V grooved drive roll, 1 flat pressure roll, input & output guides		
Drive Roll Kit .035" (0.9mm)	375980-010	2 smooth double V grooved drive rolls, input & output guides		
Drive Roll Kit 3/64" (1.2mm)	375980-011	2 smooth double V grooved drive rolls, input & output guides		
Drive Roll Kit .052"-1/16" (1.3-1.6mm)	375980-012	2 smooth double V grooved drive rolls, input & output guides		
Drive Roll Kit .045" (1.2mm)	375980-092	2 knurled double V grooved drive rolls, input & output guides		
Drive Roll Kit .030"/.035"-.045" (0.8/0.9-1.2mm)	375980-029	1 smooth double V grooved drive roll, 1 flat knurled pressure roll, input & output guides		
Drive Roll Kit .052"-1/16" (1.3-1.6mm)	375980-017	2 knurled double V grooved drive rolls, input & output guides		
Drive Roll Kit .045" (1.2mm)	375980-022	2 double V grooved drive rolls, input & output guides		
Drive Roll Kit .035" (0.9mm)	375980-032	2 double U grooved drive rolls, input & output guides		
Drive Roll Kit 3/64" (1.2mm)	375980-033	2 double U grooved drive rolls, input & output guides		
Contact Tips				
Gas Diffusers				
Nozzles				
Conduits				
Filler Metals				
Shielding Gas				

TOTAL QUOTE PRICE

U.S. Customer Care (TX): 800-426-1888 / FAX 800-535-0557 • U.S. Customer Care (NH): 800-752-7621 / FAX 800-221-4401
International Customer Care: 905-827-9777 / FAX 905-827-9797 • Canada Customer Care: 905-827-1111 / FAX 905-827-3648
www.thermalarc.com



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