

FABRICATOR® 211i

Multi-Process Welding System



Part No. W1004201

Comes Complete with:

- Fabricator 211i Power Supply
- Tweco Fusion™ 220 Amp MIG Gun with 12 ft (3.6 m) Cable
- Contact Tips (1 each):
 - .023" (0.6 mm)
 - .030" (0.8 mm)
 - .035" (0.9 mm) Installed
 - .045" (1.2 mm)
- Victor® Argon Flowgauge Regulator & 12.5 ft (3.8 m) Hose
- Tweco® 200 Amp Electrode Holder with 13 ft (4 m) Lead
- Tweco 200 Amp Ground Clamp with 10 ft (3 m) Lead
- Drive Rolls:
 - .023"/.030" (0.6/0.8 mm) V Groove
 - .023"/.035" (0.6/0.9 mm) V Groove (Installed)
 - .030"/.035" (0.8/0.9 mm) for Flux Cored Wire
- 4 General Purpose Stick Electrodes (E6013)
- Operator's Manual & CD
- 10 ft (3 m) Power Cord and NEMA 6-50P 230V AC Plug
- 230V-115V Adapter Plug & Cable



Complies with US and Canadian Standards

QUICK SPECIFICATIONS	
PROCESSES	
MIG (GMAW) Flux Cored (FCAW) Lift TIG (GTAW) STICK (SMAW)	
APPLICATIONS	
Mechanical Contractors Maintenance & Repair Farms & Ranches Auto Repair & Customization Garage & Job Shops Training Institutions Home Hobbyists (DIY)	
RATED OUTPUT	
210A / 23.5V @ 20% Duty Cycle (230V) 110A / 19.5V @ 45% Duty Cycle (115V)	
MAX. OPEN CIRCUIT VOLTAGE	
62V DC	
AMPERAGE RANGE	
10 – 150 Amp (115V), 10 – 210 Amp (230V)	
WIRE FEED SPEED	
100 – 400 IPM (2.5 – 10.2 m/min) @ 115V 100 – 600 IPM (2.5 – 15.2 m/min) @ 230V	
WEIGHT	
57.3 lb (26.5 kg)	
ORDER INFORMATION	
Part No: W1004201	Description: Fabricator 211i Package
Part No: W1004202	Description: Fabricator 211i Package w/Cart
Part No: W1004203	Description: Fabricator 211i Package w/Single Cylinder Cart

Three Process Capability:

MIG (GMAW/FCAW), STICK (SMAW), TIG (GTAW).

MIG

- **Infinite Voltage Control** for precise voltage settings.
- **Inductance Control** for arc stability and spatter control.
- **Tweco Fusion 220 Amp MIG Gun** with 12 ft (3.6 m) cable and industry standard #4 connection.
- **Durable Metal Feed Plate** features 2 roll drive system, reversible drive rolls and easy-to-set single scaled wire tension knob.
- **4", 8" & 12" Spool Capacity** allows easy installation of all wire spool sizes.
- **Spool Gun** ready.
- **Adjustable Burnback Control.**

STICK

- **Adjustable Arc Force Control** for optimum STICK electrode performance.
- Built in **Hot Start** for easy arc starting.

TIG

- **Lift TIG Start:** Provides TIG arc starting without use of high frequency.
- **Downslope:** Eliminates the crater that can form at the completion of a weld.

Other Features:

- **PFC Power Factor Correction:** Up to 40% power savings compared to conventional MIG welders.
- **Multi-Voltage Input Power:** 115 & 208/230 VAC.
- **Digital Meters:** Voltage and Amperage; Preview and Hold capability.
- **Excellent Portability:** Lightweight, less than 58 lbs.
- **Comprehensive Setup Chart:** Weld set up guide for optimum welding performance over a wide range of materials and shielding gases.
- **Trigger Control:** 4T (Latch) eliminates operator fatigue.
- **Remote Receptacle:** Enables connection of remote control devices and Spool Gun.
- **Quick Change Polarity:** Simple quick change polarity (no tools required) from the front of the power source.
- **Overload Protection:** Shuts down the power source to protect the internal electrical components from overheating.
- **IP23S:** Suitable for outdoor use.
- **Intelligent Fan Control:** Operates when welding commences to cool components & reduce airborne contaminants pulled through the power source.



CONTROL PANEL

Digital Meters WFS / Amps and Volt Meters

WFS / Amps Control Knob

Voltage / Arc Force Control / Down Slope Control Knob



Process Button Select MIG, STICK or Lift TIG

Trigger 2T (ON/OFF) or 4T (Trigger Hold) selection

Inductance Control Knob

SYSTEM FEATURES

Local/Remote Switch

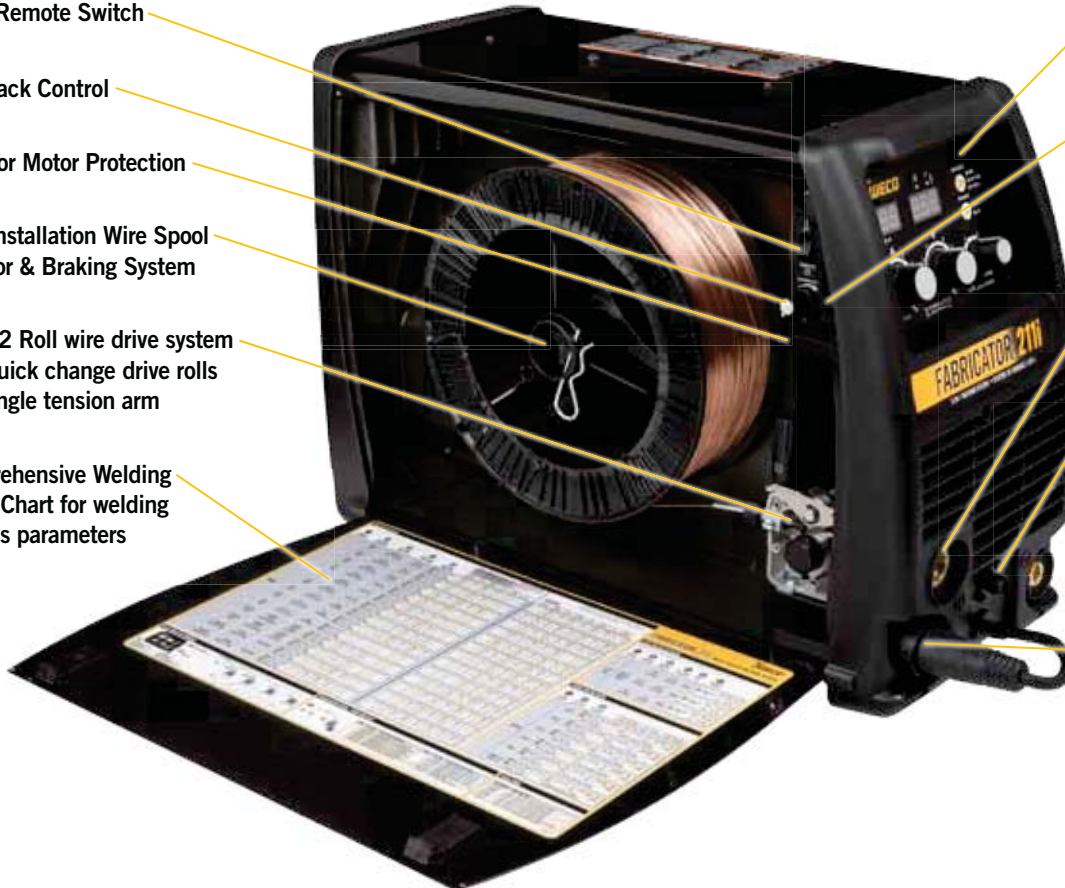
Burnback Control

Fuse for Motor Protection

Easy installation Wire Spool Adaptor & Braking System

Metal 2 Roll wire drive system with quick change drive rolls and single tension arm

Comprehensive Welding Setup Chart for welding process parameters



Control Panel (Refer Above)

MIG Gun/Spool Gun Switch

MIG Gun Connection, Tweco® #4

8 pin Remote Receptacle for remote devices & Spool Gun

Heavy Duty Welding output terminals with polarity reversal capability

SPECIFICATIONS

WELDING DC	
Maximum Output	210 Amp
MIG (GMAW/FCAW) Welding Output @104°F (40°C)	110A / 19.5V @ 45% Duty Cycle (115V) 210A / 23.5V @ 20% Duty Cycle (230V)
STICK (SMAW) Welding Output @104°F (40°C)	110A / 24.8V @ 35% Duty Cycle (115V) 200A / 25V @ 25% Duty Cycle (230V)
TIG (GTAW) Welding Output @104°F (40°C)	150A / 16V @ 35% Duty Cycle (115V) 200A / 18V @ 25% Duty Cycle (230V)
Current Range	10 – 150 Amp (115V), 10 – 210 Amp (230V)
MIG Welding Voltage Range	14 – 30 Volt
Wirefeed Speed Range	100 – 400 IPM (2.5 – 10.2 m/min) @ 115V 100 – 600 IPM (2.5 – 15.2 m/min) @ 230V
Nominal OCV Volt/DC	62V
Maximum Plate Thickness	3/8" (12.7 mm)
Wire Diameter Range	
Mild Steel:	.023" – .035" (0.6 – 0.9 mm)
Stainless Steel:	.023" – .035" (0.6 – 0.9 mm)
Aluminum:	.035" – 3/64" (0.9 – 1.2 mm)
Flux cored:	.030" – .045" (0.8 – 1.2 mm)
Spool Size Capacity	4", 8" & 12" (100, 200 & 300 mm)
Warranty Period	3 Years*
Approvals	IEC 60974-1, CSA E60974-1, UL 60974-1
Protection Class	IP23S
Power Source Dimensions (H x W x D)	17.32" x 10.23" x 23.62" (440 mm x 260 mm x 600 mm)
Power Source Weight	57.3 lb (26 kg)

PRIMARY POWER	
Primary Voltage	115VAC, 208/230VAC
Supply Voltage Range	103 – 126VAC, 208 – 265VAC
Number of Phases	Single Phase
Supply Frequency	50/60Hz
Supply Plug	NEMA 6-50P
Rated kVA @ Maximum	4.5 kVA (115V), 7 kVA (230V)
Lead Cord Length	10 ft (3 m)
Maximum Input Current	36.7 Amp (115V), 30 Amp (230V)

REPLACEMENT ITEMS & CONSUMABLES	
Tweco Fusion™ 220 Amp MIG Gun, with 12 ft (3.6 m) Cable	1023-1261
Velocity™ Nozzle 1/2" Bore	1220-1200
Universal Conduit Liner	1420-1113
Velocity Contact Tip, .023"	1110-1308
Velocity Contact Tip, .030"	1110-1309
Velocity Contact Tip, .035"	1110-1310
Velocity Contact Tip, .045"	1110-1312
Tweco® 200 Amp Electrode Holder, with 13 ft (3.8 m) Lead, 50 mm Dinse	9110-1177
Tweco 200 Amp Ground Clamp, with 10 ft (3 m) Lead, 50 mm Dinse	9255-1140
Victor® Argon Flowgauge Regulator	0781-9411
Gas Hose, 12.5 ft (3.6 m) Male 5/8-18UNF	W4013900
Parts Storage Box	W4016200
Retaining Spring used with 8" (200 mm) Spool	797844PKD

* Limited Warranty, refer to warranty schedule.

FABRICATOR 211i Multi-Process Welding System Package Part No. W1004201



Comes Complete with:

- 1 Fabricator® 211i Power Supply
- 2 Victor Argon Flowgauge Regulator & 12.5 ft (3.8 m) Hose
- 3 Tweco Fusion 220 Amp MIG Gun with 12 ft (3.6 m) Cable
- 4 Bonus Contact Tips (1 each):
.023" (0.6 mm)
.030" (0.8 mm)
.035" (0.9 mm) Installed
.045" (1.2 mm)
- 5 Drive Rolls:
.023"/.030" (0.6 mm/0.8 mm) V Groove
.023"/.035" (0.6 mm/0.9 mm) V Groove (Installed)
.030"/.035" (0.8 mm/0.9 mm) for flux cored wire
- 6 Tweco 200 Amp Electrode Holder with 13 ft (4 m) Lead
- 7 4 General Purpose Stick Electrodes (E6013)
- 8 Tweco 200 Amp Ground Clamp with 10 ft (3 m) Lead
- 9 230V-115V Adapter Plug & Cable
- 10 Operator's Manual & CD
- 10 ft (3 m) Power Cord and NEMA 6-50P 230VAC Plug (not shown)
- Retaining Spring used with 8" (200 mm) Spool (not shown)

OPTIONAL AND REPLACEMENT ACCESSORIES

ORDERING INFORMATION		
Equipment Option	Part No.	Description
Fabricator® 211i Package 	W1004201	Includes Fabricator 211i, Tweco Fusion™ 220 Amp MIG Gun, Victor® Argon Flowgauge Regulator & 12.5 ft (3.8 m) Hose, Tweco® Electrode Holder & Ground Clamp, Drive Rolls & Contact Tips, Sample Electrodes and Shoulder Strap, Operator's Manual & CD
Product	Part No.	Description
TIG Torch & Accessories <i>(required for TIG welding)</i> 	W4014603	TIG Torch, 26V, 12.5 ft (3.8 m), 8 pin and accessory kit with 1/16", 3/32", 1/8" thoriated tungstens; 1/16", 3/32", 1/8" collets; 1/16", 3/32", 1/8" collet bodies; No. 5, 6, 7 Alumina nozzle; short back cap; long back cap
Spool Gun <i>(required for aluminum MIG welding)</i> 	1027-1390	Tweco Spool Gun 160A, 12 ft (3.6 m) Length, suits 4" (100 mm) spools
Tweco 200A Electrode Holder 	9110-1177	Tweco 200A Electrode Holder & Lead Assembly, 13 ft (4 m), 50mm
Tweco 200A Ground Clamp 	9255-1140	Tweco 200A Ground Clamp & Lead Assembly, 10 ft (3 m), 50mm
Victor Argon Flowgauge Regulator 	0781-9411	Victor GF250-50-580 Argon Flowgauge Regulator
Gas Hose 	W4013900	Gas Hose, 12.5 ft (3.8 m), Male 5/8-18UNF
Foot Control 	600285	Contacter On/Off and current control with 15 ft (4.6 m) cable and 8-pin male plug
Power Adapter 	W4014000	Power Adapter - 230V to 115V, 15A

ORDERING INFORMATION		
Equipment Option	Part No.	Description
Fabricator 211i Package with Cart	W1004202	Includes contents of W1004201 with Basic Utility Cart (W4014700)
Fabricator 211i Package with Single Cylinder Cart	W1004203	Includes contents of W1004201 with Single Cylinder Cart (W4015001)
Product	Part No.	Description
Basic Utility Cart 	W4014700	Utility Cart, accommodates maximum 7" (177.8 mm) diameter cylinder
Single Cylinder Cart 	W4015001	Single Cylinder Cart accommodates up to 9" (228.6 mm) diameter cylinder with accessory drawer plus 1 Parts Storage Box
Dual Cylinder Cart 	W4015002	Dual Cylinder Cart accommodates up to two 9" (228.6 mm) diameter cylinders with accessory drawer plus 2 Parts Storage Boxes
Roll Cage 	W4015104	Protective Roll Cage for skidding or carrying <i>(power supply not included)</i>
Parts Storage Box 	W4016200	Parts Storage Box and organizer
Tweco Helmets 	4100-1002 4100-1004 4100-1008	Tweco Helmet, New Patriot Eagle Tweco Helmet, New Skull & Fire Tweco Helmet, New Dragon
Drive Rolls	Part No.	Description
Drive Roll .023" / .035" (0.6/0.9 mm)	W4014800	V groove for steel & stainless steel
Drive Roll .023" / .030" (0.6/0.8 mm)	7977036	V groove for steel & stainless steel wires <i>(Installed)</i>
Drive Roll .030" / .035" (0.8/0.9 mm)	7977732	V knurled groove for flux cored wires
Drive Roll .045" (1.2 mm)	704277	V knurled groove for flux cored wires