

Handler® 140

115-Volt Wire Feed Welder



217919
September 2022

115 V



500559

Quick Specs

Welding Amp Range

25–140 A

Rated Output

90 A at 18.5 VDC, 20% duty cycle

Mild Steel Thickness Range

24 ga.–1/4 in.



**5/3/1
INDUSTRIAL
WARRANTY**

Reliable. Durable. Superior arc with 140 A of power.

The Handler 140 operates on common 115-volt power. Simply plug it in and weld — no additional power needed.

Weld as thin as 24 gauge and up to 1/4 inch in a single pass, with a broad output range of 25–140 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 five output voltage settings.

Applications

- Maintenance/repair
- DIY
- Metal art
- Auto body
- Farm/ranch
- Construction

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
Five-position voltage control and infinite wire feed speed	Five voltage ranges allow you to fine-tune the arc.
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	Access makes it quick and easy to change polarity for solid or tubular wire.
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).

Specifications (Subject to change without notice.)						DC	CV	1 Phase
Welding Amp Range	Rated Output	Amps Input at Rated Output, 60 Hz			Max. Open Circuit Voltage	Wire Feed Speed Range	Dimensions	Net Weight
		115 V	KVA	KW				
25–140 A	90 A at 18.5 VDC, 20% duty cycle	20	2.9	2.5	28 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)	57 lb. (26 kg)

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



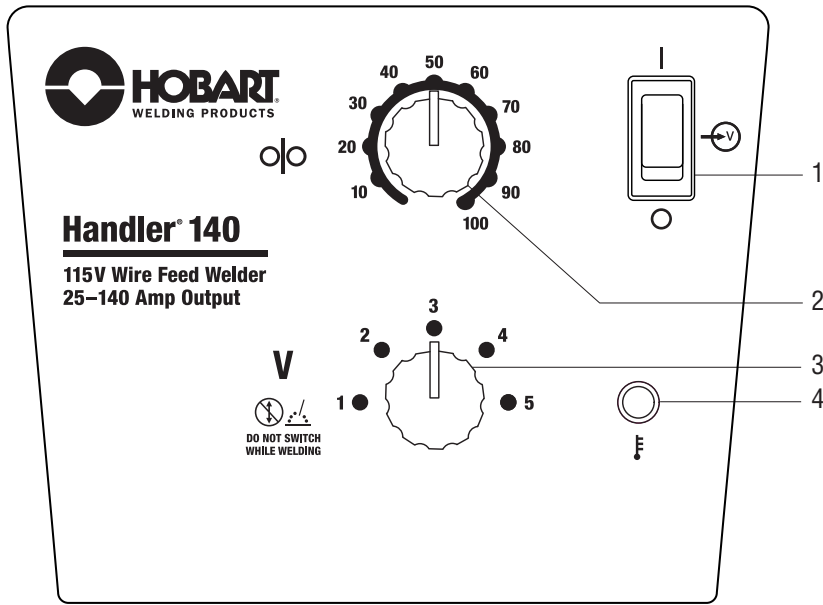
Hobart Welding Products

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

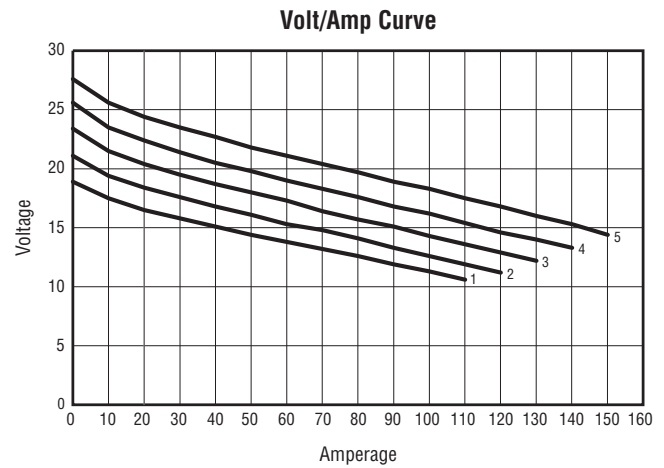
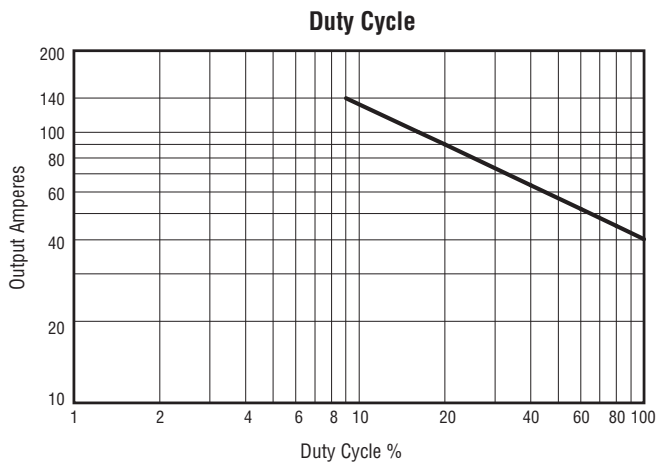
HobartWelders.com



Control Panel



Performance Data



Accessories



HR-100 Replacement MIG Gun 285033
Comes in 10 ft. (3 m) length with liner for .030–.035 in. (0.8–0.9 mm) diameter wire.



Small Cart/Cylinder Rack 194776
Designed for portable MIG welders. Accommodates large and small gas cylinders.



Protective Cover 195186
Weather-resistant nylon resists stains and mildew while protecting the finish of your welder.

Consumables

Item	Hobart Package Part #	Miller Package Part #
Contact Tips		
.023/.025 in. (0.6 mm)	770174 (5 per package)	087299 (10 per package)
.030 in. (0.8 mm)	770177 (5 per package)	000067 (10 per package)
.035 in. (0.9 mm)	770180 (5 per package)	000068 (10 per package)
MIG Nozzle (Standard)		
	770404	169715
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-knurl drive roll for .030–.035 in. (0.8–0.9 mm) and .045 (1.2 mm) flux-cored wire	202926	202926

Handler® 140 Welding Guide

The Handler 140 is capable of running the following wires: .023–.035 in. (0.6–0.9 mm) mild steel or stainless steel
 .030–.035 in. (0.8–0.9 mm) flux-cored
 .030 (0.8 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)	12 ga. .105 in. (2.7 mm)	10 ga. .135 in. (3.4 mm)	3/16 in. (4.8 mm)	1/4 in. (6.4 mm)	
Steel	Flux Core E71T-11 (DCEN)	No Shielding Gas Required Good for windy or outdoor applications.	.030" (0.8 mm)	—	—	1/30	2/30	3/40	3/45	4/50	5/50*	DCEN Electrode Negative for Flux-Cored Wire
			.035" (0.9 mm)	—	—	—	2/25	3/35	4/35	5/35	5/40*	
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	2/50	3/50	4/55	—	—	—	DCEP Electrode Positive for Solid Wire
			.030" (0.8 mm)	1/25	2/30	2/35	3/35	4/40	4/50	5/45	5/50*	
			.035" (0.9 mm)	—	—	2/30	3/30	4/35	4/40	5/40	5/45*	
Steel	Solid Wire ER70S-6 (DCEP)	100% CO ₂	.024" (0.6 mm)	1/25	2/35	3/30	3/40	4/50	5/50	—	—	DCEP Electrode Positive for Solid Wire
			.030" (0.8 mm)	—	2/30	3/30	3/35	4/30	4/35	5/35	5/40*	
			.035" (0.9 mm)	—	—	—	3/25	4/30	4/35	5/30	5/35*	
Stainless Steel	Stainless Steel (DCEP)	Tri-Mix 90% He/7.5% Ar/2.5% CO ₂	.024" (0.6 mm)	—	—	3/30	4/50	—	5/50	—	—	DCEP Electrode Positive for Solid Wire
			.030" (0.8 mm)	—	—	3/20	4/40	—	5/40	—	—	
		98% Ar/2% CO ₂	.024" (0.6 mm)	—	—	1/45	2/60	—	4/70	—	—	
			.030" (0.8 mm)	—	—	1/40	2/50	—	4/60	—	—	
Aluminum	Aluminum** 4043 AL (DCEP)	100% Argon**	.030" (0.8 mm)	—	—	—	3/90**	5/90**	—	—	—	DCEP Electrode Positive for Solid Wire
	Aluminum** 5356 AL (DCEP)		.030" (0.8 mm)	—	—	—	2/100**	4/100**	—	—	—	

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 required.

**Aluminum wire is soft so feedability is not as good. Make sure that hub tension is not too tight and keep the torch as straight as possible. A "push angle" for the torch is recommended.