

# Stickmate® 160i

## DC Stick (SMAW) Welding Power Source



279109  
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500570

### Quick Specs



**Welding Amp Range**  
20–80 A (120 V)  
20–160 A (240 V)

**Maximum Mild Steel Thickness**  
1/8 in. (120 V)  
3/8 in. (240 V)



### Works the first time. Every time.

From the brand you know comes the most dependable, portable, powerful stick welder — even if you don't use it every day.

Easy, quick and reliable arc starts with Hot Start™ technology. Preferred DC output for the stick welding process means fewer arc outages, less sticking, less spatter and best arc control.

Nearly 100 pounds lighter means you can work smarter not harder by bringing the welder to the work. Its portability makes it easier to carry and store.

More powerful — up to 85 more amps — compared to leading competitive machine so you can weld thicker materials.

#### Applications

- DIY
- Farm/ranch
- Metal art
- Maintenance/repair

#### Includes

- 10 ft. (3 m) electrode cable with heavy-duty holder
- 10 ft. (3 m) work cable with clamp
- 6.5 ft. (2 m) power cord with MVP™ adapters for 120 V and 240 V

| Features                                         | Benefits                                                                                                                                                                                         |
|--------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Hot Start™ technology</b>                     | Provides easy, quick and reliable arc starts.                                                                                                                                                    |
| <b>Infinite amperage control</b>                 | Precise and accurate amperage control and heat output. Adjust output by as little as one-amp increments.                                                                                         |
| <b>Adjustable shoulder strap</b>                 | Easy to carry and move.                                                                                                                                                                          |
| <b>Dual-voltage capability with MVP adapters</b> | Allows connection to 120 or 240 V receptacles without tools — choose the adapter cord with the right plug that fits the receptacle, and connect it to the power cord with the L6-30R twist lock. |
| <b>Hobart 5/3/1 industrial warranty</b>          | 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.) |                   |                         |                           |                            |                           |                                                                         |                 |
|----------------------------------------------------|-------------------|-------------------------|---------------------------|----------------------------|---------------------------|-------------------------------------------------------------------------|-----------------|
| Input Power                                        | Welding Amp Range | Rated Output            | Max. Mild Steel Thickness | Amps Input at Rated Output | Max. Open-Circuit Voltage | Dimensions                                                              | Net Weight      |
| 120 V                                              | 20–80 A           | 65 A at 20% duty cycle  | 1/8 in. (3.2 mm)          | 20.7                       | 91 V                      | H: 10.5 in. (267 mm)<br>W: 7.125 in. (181 mm)<br>D: 13.375 in. (340 mm) | 15 lb. (6.8 kg) |
| 240 V                                              | 20–160 A          | 160 A at 30% duty cycle | 3/8 in. (9.5 mm)          | 27.8                       |                           |                                                                         |                 |



Conforms to ANSI/IEC Std. 60974-1.  
Conforms to CSA Std. E60974-1.



#### Hobart Welding Products

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

#### HobartWelders.com



## Electrode Charts

### Electrode Polarity Chart

| ELECTRODE | DC*    | AC | POSITION           | PENETRATION | USAGE                          |
|-----------|--------|----|--------------------|-------------|--------------------------------|
| 6010      | EP     | —  | ALL                | DEEP        | MIN. PREP, ROUGH, HIGH SPATTER |
| 6011      | EP     | ✓  | ALL                | DEEP        |                                |
| 6013      | EP, EN | ✓  | ALL                | LOW         | GENERAL                        |
| 7014      | EP, EN | ✓  | ALL                | MED.        | SMOOTH, EASY, FAST             |
| 7018      | EP     | ✓  | ALL                | LOW         | LOW HYDROGEN, STRONG           |
| 7024      | EP, EN | ✓  | FLAT HORIZ. FILLET | LOW         | SMOOTH, EASY, FASTER           |
| Ni-CI     | EP     | ✓  | ALL                | LOW         | CAST IRON                      |
| 308L      | EP     | ✓  | ALL                | LOW         | STAINLESS                      |

\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

### Electrode/Amperage Chart

| ELECTRODE       | DIAMETER |     | AMPERAGE RANGE |     |      |      |      |      |
|-----------------|----------|-----|----------------|-----|------|------|------|------|
|                 | IN       | MM  | MIN.           | 50A | 100A | 150A | 200A | MAX. |
| 6010 & 6011     | 3/32     | 2.4 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/16     | 4.8 |                |     |      |      |      |      |
| 6013            | 1/16     | 1.6 |                |     |      |      |      |      |
|                 | 3/32     | 2.4 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/16     | 4.8 |                |     |      |      |      |      |
| 7014            | 1/16     | 1.6 |                |     |      |      |      |      |
|                 | 3/32     | 2.4 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/16     | 4.8 |                |     |      |      |      |      |
| 7018 & 7018 AC* | 1/16     | 1.6 |                |     |      |      |      |      |
|                 | 3/32     | 2.4 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/16     | 4.8 |                |     |      |      |      |      |
| 7024            | 3/32     | 2.4 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/32     | 2.4 |                |     |      |      |      |      |
| Ni-CI           | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/16     | 4.8 |                |     |      |      |      |      |
|                 | 3/32     | 2.4 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
| 308L            | 5/32     | 4.0 |                |     |      |      |      |      |
|                 | 3/16     | 4.8 |                |     |      |      |      |      |
|                 | 1/8      | 3.2 |                |     |      |      |      |      |
|                 | 5/32     | 4.0 |                |     |      |      |      |      |

\*7018 AC recommended for use with AC welders.

**Ideal performance for most 6010, 6011, 6013 and 7018 rods.**

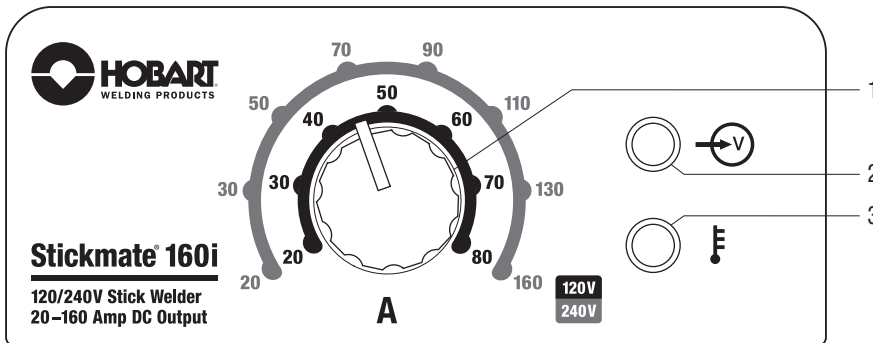
*Note: 6010 not recommended for open root welding.*

**120 V:** 1/16–1/8 in.

*(some limitations with 3/32-inch rods and very limited with 1/8-inch rods based on rod/amperage)*

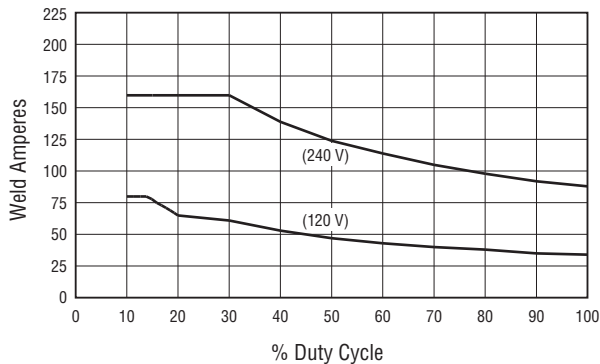
**240 V:** 1/16–5/32 in. *(some limitations with 5/32-inch rods based on amperage)*

## Control Panel



## Performance Data

### Duty Cycle Chart



## Basic Equipment Setup (DCEP)

