



MANGALAM® Mig Wire DIN

Reliable And Versatile Wire For Smooth Welding Operations

Mangalam MIG Wire - DIN is a copper-coated carbon steel filler wire designed for MIG/MAG welding of carbon steels across general and structural engineering applications. With double deoxidization, uniform copper coating, smooth wire feeding, stable arc, and minimal spatter, it ensures clean, efficient welds under optimal conditions. The higher deoxidizer content makes it suitable even for applications involving dust, rust, or mill scale.

Built For Efficiency, Durability, And Precision

- ✓

Double deoxidized copper-coated carbon steel wire
- ✓

Stable arc and smooth feeding for precise welds
- ✓


Minimal spatter and uniform copper coating
- ✓

Suitable for welding in dusty, rusty, or mill-scaled environments
- ✓


Compatible with automatic, semi-automatic, and robotic welding
- ✓

Versatile welding positions: Flat, Horizontal, Vertical (Up/Down), and Overhead


Wide-Ranging Applications For Structural And Industrial Welding




Construction And Mining Equipment




Pressure Vessels, Pipelines, And Ductwork



LPG Cylinders And Thin Sheet Auto Body Fabrication



Shipping Containers, Railway Wagons, And Coaches



High-Speed Robotic, Automatic, And Semi-Automatic Welding Setups

Packing Data

Size (Mm)	KG/Spool	Component	Current In Amps
0.80	15	17 – 24	70 - 220
1.00	15	20 – 28	100 - 275
1.20	15	24 – 30	150 - 300
1.60	15	24 – 36	150 - 450

Shielding Gas: 100% CO₂

Flow Rate: 10 – 25 LPM

Chemical Composition Of Weld Metal (%)

Element	Typical Value (%)
Carbon (C)	0.06 - 0.13
Manganese (Mn)	1.30 - 1.60
Silicon (Si)	0.70 - 1.00
Sulfur (S)	0.025 Max
Phosphorus (P)	0.025 Max
Copper (Cu)	0.30 Max

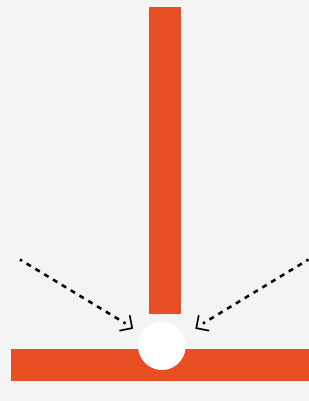
Mechanical Properties Of All Weld Metal

Property	Value
Ultimate Tensile Strength (UTS)	490 N/mm² Min
Yield Strength (YS)	400 N/mm² Min
Elongation	22% Min
CVN Impact at -30°C	27 J Min

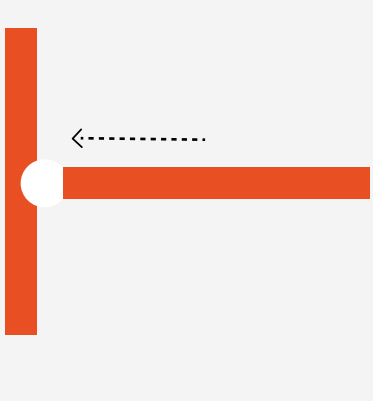
Current Conditions

Operates on **DC** current.

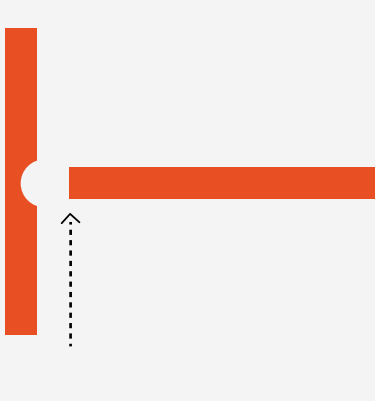
WELDING POSITIONS: F, H, V - Down, V - Up, OH



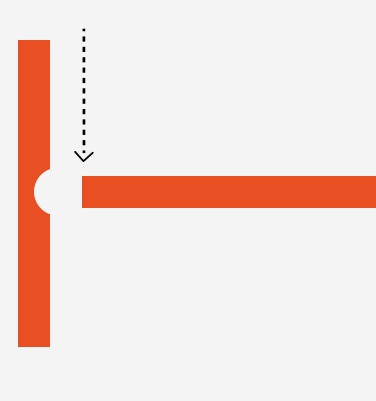
F



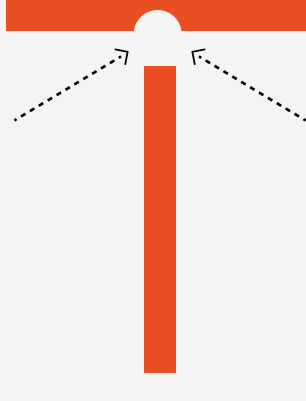
H



V-u



V-d



OH