



## MANGALAM® Mig Wire IS

### High-Quality MIG Wire For Versatile Applications

Mangalam MIG Wire is a double deoxidized, copper-coated carbon steel filler wire designed for MIG/MAG welding of carbon steels in general and structural engineering. It offers smooth feeding, a stable arc, and minimal spatter under optimal welding conditions. Its high deoxidizer content makes it ideal for environments with dust, rust, or mill scale.

### Designed For Efficiency, Durability, And Precision

- Double deoxidized for enhanced performance in challenging conditions
- Uniform copper coating ensures smooth wire feeding
- Stable arc with minimal spatter under optimal settings
- Suitable for high-speed robotic, automatic, and semi-automatic welding
- Works well on surfaces with dust, rust, or mill scale

### Built For Diverse Industrial And Structural Uses



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% CO<sub>2</sub>

Flow Rate: 10 – 25 LPM

### Chemical Composition Of Weld Metal (%)

Element	Typical Value (%)
Carbon (C)	0.07 - 0.15
Manganese (Mn)	1.40 - 1.85
Silicon (Si)	0.80 - 1.15
Sulfur (S)	0.025 Max
Phosphorus (P)	0.025 Max
Copper (Cu)	0.50 Max

### Mechanical Properties Of All Weld Metal

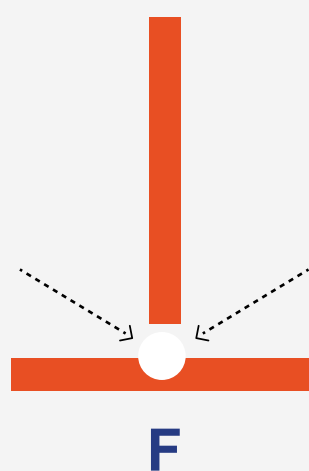
Property	Value
Ultimate Tensile Strength (UTS)	500 - 640 N/mm <sup>2</sup>
Yield Strength (YS)	420 N/mm <sup>2</sup> Min
Elongation	22% Min
CVN Impact at -30°C	27 J Min

### Current Conditions

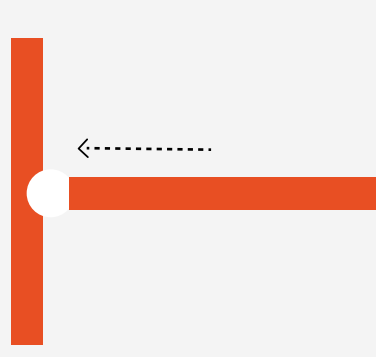


Operates on **DC** current.

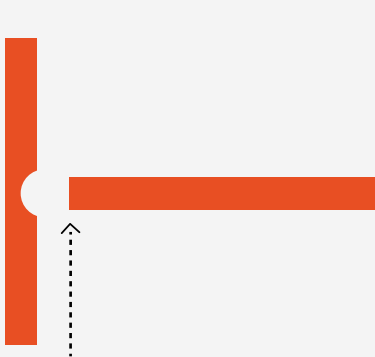
### WELDING POSITIONS: F, H, V - Down, V - Up, OH



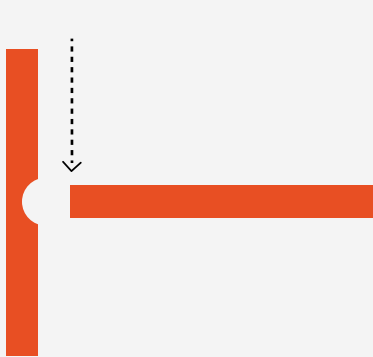
F



H



V-u



V-d



OH