



MAILAM INDIA LIMITED

PUDUCHERRY

MGA – 14

MAILAM MGA-14 is a rutile based flux cored wire conforming to AWS A5.29 E 81 T1-Ni2.

Applications & Characteristics	:	All position wire for welding of high tensile steels used in machinery, structures, bridges requiring service applications down to – 60°C. Rutile based flux cored wire suitable for all position welding with DC electrode positive. The wire produces a full slag coverage and excellent slag detachability. The welding arc is smooth and stable with low spatter and good bead appearance.		
Weld Metal Chemistry (With CO₂ shield)	:	C = 0.10% Max Ni = 1.75-2.50% Mn = 0.90 to 1.50% S = 0.03% Max Si = 0.55% Max P = 0.03% Max		
Typical all weld Mechanical properties (With CO₂ shield)	:	U.T.S. = 590 N/mm ² Y.S. = 510 N/mm ² Elongation (%) = 20 Typical Charpy Vnotch Impact value at minus 40°C = 40 J		
Shielding gas	:	CO ₂ or Argon +20% CO ₂ gas with Flow rate of 10-15 liters/ minute		
Polarity	:	DC Wire positive		
Size	:	1.20 mm, 1.60 mm		
Welding Position	:	All position		
Packing	:	12.50 Kgs spool sealed in polythene bag and shrink wrapped in a corrugated box.		
Welding parameter Guidelines (With CO₂ shield) (F-Flat, P-Position)	:	Size	Range	Recommended
		1.20 mm	90-300 A, 18-28V	180-300A, 22-26V (F) 100-150A, 18-22V (P)
		1.60 mm	125-400 A, 18-30V	220-350A, 25-30V (F) 125-200A, 18-22V (P)
Wire Extension (Stick out)	:	15 – 20 mm		

Mixed gases like Argon +20% CO₂ should be used with 1-2 Volts less than for CO₂