



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 2182

High Strength Self Fluxing
15% Silver Torch Alloy for
Copper to Copper

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.8 B CuP-5

FEATURES & APPLICATIONS

- High Strength, high silver, self-fluxing torch alloy for copper to copper and copper to brass.
- For smooth ductile deposits that will not leak and will withstand severe vibrations.
- Silver content provides thin flowing properties and low application temperature which prevents scaling on inside of tubing and minimizes annealing of copper
- Provides excellent corrosion resistance and can be applied to copper without flux
- Can be applied to dirty copper if necessary.
- Leaves no flux residue on copper to copper joints and has 98% to 99% conductivity on pure copper
- Excellent capillary action

High strength, self-fluxing torch alloy for copper to copper; and copper to brass with flux.

- Electrical wiring
- Air conditioning and refrigeration
- Motors, brewery coils, armatures and electrical contacts
- Bus bars, instruments, plumbing, brass or copper fittings

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

P	Ag	Cu
5	15	Bal.

Undiluted Weld Metal

Tensile Strength

Melting Temperature

Maximum Value Up to:

up to 60,000 PSI (400 MPa)

1300°F (700°C)

BRAZING INSTRUCTIONS

Welding Techniques: Clean joint area well. When joining copper to copper use without flux. Use a large size tip, carburizing flame and heat area broadly. Keep flame 2" to 3" from base metal and keep torch in constant motion.

When joining brass or bronze to copper or brass to bronze, use 5130 flux. Paint paste along joint line and heat broadly until flux first dries and then melts. Feed rod into the joint, keeping torch in constant motion. When a continuous fillet is observed, remove flame and allow molten metal to solidify. Flux residue should be removed by washing in warm water.