



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE

3147

45% Silver Flux Coated
Orange

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.8 BAg-5

FEATURES & APPLICATIONS

Low temperature joining of dissimilar metals. Excellent where tolerances and fit are not perfect.

Super active flux coated cadmium free silver brazing alloy with 45% silver content

- Special "Fast Flow" flux coating provides twice the base metal cleansing action of conventional silver flux coatings.
- No odors from rubberized compounds yet the flux coating is totally flexible and non-fragile.
- The only flux coated silver flux strong enough to clean oxidized stainless steel.
- Available bare as item 3149 for use with 5130 flux

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Orange or Custom Colors

Ag	Cu	Zn
45	30	25

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	68,000 PSI (465 MPa)
Yield Strength	54,000 PSI (372 MPa)
Elongation	2.5%
Conductivity	13.5
Density	9.49/cm ³
Hardness Brinell	120

Torch Setting: Slightly carburizing

Temperature Ranges:

Working Temperature:	Liquidus	Solidus
1195°F (646°C)	1235°F (668°C)	1175°F (635°C)

BRAZING INSTRUCTIONS

Welding Techniques: After cleaning metal, preheat generally to 350°F (200°C) then heat the joint area to 800°F (420°C). Melt off some flux and allow it to flow throughout the joint. Then add alloy.

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Rod	Joint Length/ 1" (25mm) of Rod
1/16 (1.6)	18" (450)	.33 oz (9.2g)	24" (600mm)
3/32 (2.5)	18" (450)	.65 oz (18g)	44" (1100mm)

APPROXIMATE ROD PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	3/32 (2.5)
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Length (mm)	18" (450)	18" (450)
Rods / lb	32	16
Rods / kg	70	35
Feet / lb	48	24
Cm / kg	3150	1575