



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

SELECTRODE
3157
56% Silver Flux Coated
Orange

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.8 BAg-7
NF EN 1044: AG102

EN ISO 3677: BAg56 ZnCuSn620-655

FEATURES & APPLICATIONS

For color matching stainless steel and for low temperature high strength joints in the food, medical and pharmaceutical industries.

Super active flux coated cadmium free silver brazing alloy with 56% silver content

- Rare flux coated silver available in 3/64" (1.2mm) diameter for precision work.
- 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 are totally flexible and non-fragile.
- The only flux coated silver flux strong enough to clean oxidized stainless steel.
- Available bare as 3159 for use with 5130 flux

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Orange

Ag	Cu	Zn	Sn
56	22	17	5

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	71,000 PSI (490 MPa)
Yield Strength	60,000 PSI (415 MPa)
Elongation	25%
Conductivity	14.3
Density	9.59/cm ³
Hardness	Brinell 130

Torch Setting: Slightly carburizing

Temperature Ranges:

Working Temperature:	Liquidus	Solidus
1210 °F (655 °C)	1200°F (650°C)	1140°F (620°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
3/64 (1.2)	18" (450)	.25 oz (7.1g)	17" (431mm)
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)	3/64 (1.2)	1/16 (1.6)	3/32 (2.5)
Length (mm)	18" (450)	18" (450)	18" (450)
Rods / lb	55	32	16
Rods / kg	121	70	35
Feet / lb	82.5	48	24

Cm / kg	5445	3150	1575
---------	------	------	------