



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

SELECTRODE
3182
Red Nickel Silver – No Glare
Flux

INTERNATIONAL CLASSIFICATIONS

AWS/ASME RB CuZn-D
DIN L-CuNi10Zn42

EN ISO 3677: B Cu 49 ZnNiSi 890-920
NF EN 1044: Cu 305

FEATURES & APPLICATIONS

High strength joining of steels using both the thin flow and bead form techniques.

Ultra high purity nickel silver alloy featuring "Safe Vue" moisture sealed flux coating

- Unique "Safe Vue" flux coating eliminates harsh chemical odors and the bright orange visibility blocking glare of conventional sodium type flux coatings.
- Slick, smooth moisture sealed flux has tripled the shelf life of similar products.
- Flux cleansing action is exceptional on dirty steels and cast irons.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

| | | | | | |
|--------------------|------|----------|---|-----------|-------------------------------|
| Flux Color: | 3182 | R | } | ed at | * All other colors can be |
| | 3186 | White Si | | all times | special ordered in quantities |
| | 3189 | Bare | | | of 300lbs (140kg) |

| Al | Sn | Si | Ni | Pb | P | Cu | Zn |
|-----|------|-----|------|-----|-----|------|-----|
| .01 | .002 | .21 | 10.5 | .02 | .15 | 48.5 | bal |

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

| | |
|------------------|---|
| Tensile Strength | Maximum Value Up to: 102,000 PSI (700 MPa) |
| Yield Strength | 90,000 PSI (630 MPa) |
| Elongation | 28% |
| Hardness | Rockwell B 96 Brinell 210 |
| Work Hardness | Rockwell C 25 Brinell 265 |

Recommended Torch Setting: Neutral flame

Temperature Ranges:

| | |
|----------------------|-------------------------------|
| Working Temperature: | 1595°F (878°C) |
| Melting Range: | 1583° - 1640°F (870° - 895°C) |

BRAZING INSTRUCTIONS

Welding Techniques: Insure that parts to be joined are clean. Pre-heat the general area to 700°F (400°C) and then specific area to 1200°F (650°C). Melt off flux and apply alloy.

Deposition Rates:

| Diameter (mm) | Length (mm) | Weldmetal/ Rod | Rods per lb (kg) of Weldmetal |
|---------------|-------------|----------------|-------------------------------|
| 1/16 (1.6) | 18" (450) | .3 oz (8.6g) | 53 (117) |
| 3/32 (2.5) | 18" (450) | .6 oz (17.5g) | 27 (59) |
| 1/8 (3.25) | 18" (450) | 1.1 oz (31g) | 15 (33) |
| 3/16 (5.0) | 18" (450) | 2.4 oz (67g) | 7 (15) |

APPROXIMATE ROD PACKAGING & DIMENSIONS

| Diameter (mm) | 1/16 (1.6) | 3/32 (2.5) | 1/8 (3.25) | 3/16 (5.0) |
|---------------|------------|------------|------------|------------|
| Length (mm) | 18" (450) | 18" (450) | 18" (450) | 18" (450) |

| | | | | |
|-----------|-----|----|----|----|
| Rods / lb | 47 | 23 | 13 | 6 |
| Rods / kg | 103 | 51 | 29 | 13 |