



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE

3185

**Pink 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 times	* All other colors can be special ordered in quantities of 300lbs (140kg)
	3186	White Si		
	3189	Bare		

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

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	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