



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

**SELECTRODE**  
**3189**  
**Bare 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 %)**

<b>Flux Color:</b>	3182	R	}	ed at all times	* All other colors can be special ordered in quantities of 300lbs (140kg)
	3186	White Sil			
	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**

Tensile Strength

Yield Strength

Elongation

Hardness

Work Hardness

**Maximum Value Up to:**

102,000 PSI (700 MPa)

90,000 PSI (630 MPa)

28%

Rockwell B 96 Brinell 210

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