



Manufacturers of Custom Welding Lines for Resale  
[www.selectrode.com](http://www.selectrode.com)

# SELECTRODE

## 3379

Bare 36" Low Fuming Bronze –  
 No Glare Flux

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME RB CuZn-C  
 DIN S-CuZn40Si

EN ISO 3677: B Cu60ZnSi 870-890  
 NF EN 1044: Cu304

### FEATURES & APPLICATIONS

Torch brazing most steels and cast irons. Especially suited for joining thin sections.

Triple deoxidized bronze brazing alloy with "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>	3370	B	} Stocked at	* All other colors can be special ordered in quantities of 300lbs (140kg)
	3375	Pink		
	3376	White al		
	3379	Bare 36" length	nes	

Al	Sn	Mn	Si	Fe	Cu	Zn
.005	1.0	.35	.12	1.1	57.8	Bal.

### TYPICAL MECHANICAL PROPERTIES

**Undiluted Weld Metal**

Tensile Strength

Yield Strength

Elongation

**Maximum Value Up to:**

71,000 PSI (490 MPa)

64,000 PSI (440 MPa)

27%

**Recommended Torch Setting:** Neutral flame**Temperature Ranges:**

Working Temperature:	1595°F (878°C)
Melting Range:	1583° - 1620°F (870° - 885°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

