



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

# SELECTRODE

## 3470

Blue 14" 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>	3470	B	} Stocked at all times	* All other colors can be special ordered in quantities of 300lbs (140kg)
	3475	Pink		
	3479	Bare		

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

### TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	71,000 PSI (490 MPa)
Yield Strength	64,000 PSI (440 MPa)
Elongation	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

