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SELECTRODE 5138 Silver Brazing Powder

INTERNATIONAL CLASSIFICATIONS

AMS 3410

AWS A5.31-91 Type FB3F, 0F499, Type B

FEATURES & APPLICATIONS

A white silver powdered flux used for brazing copper, copper based alloys, steel, nickel, stainless steel and precious metals. It is highly active in dissolving refractory oxides and is especially effect on stainless steels, carbides and heat-resistant alloys. It can be used as supplied or mixed with water to form a paste.

PHYSICAL PROPERTIES

Form and Color	White Powder
Bulk Density	1.2
Water Content	<1.0%
Lower Explosion Limit	None
Freezing Effects	None
Humidity Effect	Slight Moisture Pickup
Active Temperature Range	485°C-815°C/ 900°F-1500°F.

Brazing Techniques: Clean base metal thoroughly to remove any contaminates. Heat the end of filler metal rod and dip into flux or sprinkle flux on work piece. At temperature the flux liquefies and flows into the joint, removing surface oxides and tarnish. Continue heating until the filler metal melts and fills the joint. Flux residue is soluble in hot water.

