



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

**SELECTRODE**  
**3170**  
**Blue 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>	3170	B	}	Stocked at	special ordered in quantities	of 300lbs (140kg)	* All other colors can be
	3175	Pink					
	3176	White al					
	3179	Bare					
	3379	Bare 36" length					

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