



Manufacturers of Custom Welding Lines for Resale
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 %)

Flux Color:	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

Undiluted Weld Metal	Maximum Value Up to:
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

