



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

## SELECTRODE

# 2180

High Strength Self Fluxing  
Torch Alloy for Copper to  
Copper

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.8 B CuP-2

### FEATURES & APPLICATIONS

- Fabricate and repair copper air conditioning components, refrigeration components, radiators, heat exchangers, and other devices made from copper sheet and fittings.
- Join copper busbars, electrical conduit, cable, and fabricated copper vessels.
- Join copper without flux in applications where flux is detrimental.

High strength, self-fluxing torch alloy for copper to copper; and copper to brass with flux.

- Designed to produce smooth thin fillets in clean copper-to-copper joints without flux.
- Provides excellent corrosion resistance and will withstand severe vibrations.
- Use with flux for joining copper to brass or bronze.
- Not recommended for steel or nickel alloys.

### ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

P	Ag	Cu
7.5	Tr.	Bal.

### TYPICAL MECHANICAL PROPERTIES

#### Undiluted Weld Metal

Tensile Strength

Melting Temperature

#### Maximum Value Up to:

up to 60,000 PSI (400 MPa)

1300°F (700°C)

### BRAZING INSTRUCTIONS

**Welding Techniques:** Clean joint area well. When joining copper to copper use without flux. Use a large size tip, carburizing flame and heat area broadly. Keep flame 2" to 3" from base metal and keep torch in constant motion.

When joining brass or bronze to copper or brass to bronze, use 5130 flux. Paint paste along joint line and heat broadly until flux first dries and then melts. Feed rod into the joint, keeping torch in constant motion. When a continuous fillet is observed, remove flame and allow molten metal to solidify. Flux residue should be removed by washing in warm water.