



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 2140

Low Melting Aluminum Solder
for Joining Aluminum to Itself
and Other Metals

INTERNATIONAL CLASSIFICATIONS

NONE

FEATURES & APPLICATIONS

With a lower bonding temperature than silver brazing alloys, it is ideal as an intermediate alloy for joining.

Excellent for low temperature joints on:

- Aluminum tube, copper tube, and refrigeration and air conditioning units
- Aluminum radiators
- Sheet metal work
- Manufacturing and repair of instruments
- Zinc base die casting
- Joining of dissimilar metals
- Can also be used on anodized aluminum

Strong low temperature solder for joining aluminum to other metals

- Excellent wetting and flow characteristics on almost all ferrous and non-ferrous metals.
- Retains high strength even at temperatures up to 350°F (175°C).
- Better corrosion resistance and higher strength than ordinary soft solders.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
Electrical Conductivity
Corrosion Resistance
Color Match

Maximum Value Up to:

up to 20,000 PSI (145 MPa)
Good
Good
Very Good on Aluminum

SOLDERING INSTRUCTIONS

Soldering Techniques: Joint area should be thoroughly cleaned. Best results are obtained when maintaining a joint clearance of no more than .006". The entire joint area should be completely covered with 5140 flux. Heat part indirectly with a soft flame being careful not to burn the flux. As soon as flux starts to bubble, dip solder into flux and transfer it to joint. Continue heating until solder flows through the entire joint. Allow to cool slowly. Flux residue can be removed with hot water and stiff brush.