



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

# SELECTRODE 2195

Flux Coated Bead Forming  
Aluminum Brazing Alloy

## INTERNATIONAL CLASSIFICATIONS

AWS A5.10 ER 4043  
DIN 1732: SG-AL Si5

EN ISO 18273 SAL 4043

## FEATURES & APPLICATIONS

Applications:

- Repairing all brazable aluminum castings – filling in holes, building up worn or missing sections and joining cast to wrought parts.
- General purpose outdoor use on repairing aluminum skids, platforms, loading docks, truck bodies, irrigation piping, fences and railings.
- Joining thick to thin sections requiring a combination of braze-welding and brazing techniques.

Features:

- Can both build up (bead form) or thin flow due to the specially designed orange flux coating
- Flux residue washes off easily with warm water

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

| Si | Fe | Cu   | Mg   | Mn  | Zn   | Ti   | Al  |
|----|----|------|------|-----|------|------|-----|
| 5  | .3 | .001 | .003 | .04 | .003 | .004 | Bal |

## TYPICAL MECHANICAL PROPERTIES

**Undiluted Weld Metal**  
Tensile Strength  
Bonding Temperature

**Maximum Value Up to:**  
up to 35,000 PSI (250 MPa)  
800° - 1000°F

## BRAZING INSTRUCTIONS

**Brazing Techniques:** Clean the surface and preheat heavy sections. Adjust the torch to a neutral to slightly carburizing mixture. Once piece is preheated simply allow a small amount of the flux coating to melt off the rod. When the flux flows out apply the alloy drop by drop, moving the torch constantly. Allow to cool and thoroughly remove all flux residues by scrubbing in warm water.

For thin flowing, adjust the torch to 3X carburizing and preheat to a higher temperature. Then touch the end of the rod to the work and continue heating, forcing the molten flux through the joint. Allow the rod to melt off and flow through the fluxed area. Keep the torch moving constantly.

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

|               |            |           |
|---------------|------------|-----------|
| Diameter (mm) | 3/32 (2.4) | 1/8 (3.2) |
| Length (mm)   | 18" (456)  | 18" (456) |

The ALUMA FLOW rods will be packaged in our new seamless aluminum pull ring moisture barrier can. The contents will be 4 each heat sealed 1.1 pound (.5kg.) heat sealed polyethylene bags for a total can contents weight of 4.4 pounds (2kgs.)