



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 2197

Green Flux Coated Thin
Flowing Torch Brazing Alloy
for Aluminum

INTERNATIONAL CLASSIFICATIONS

AWS A5.10 ER 4047
DIN 8513: L AL Si 12

EN ISO 3677: B AL 88 Si

FEATURES & APPLICATIONS

Applications:

- 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:

- Extremely thin flowing alloy with excellent capillary action
- Flux residue washes off easily with warm water

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Si	Fe	Cu	Mg	Mn	Zn	Ti	Al
11-13	.8	.03	.05	.015	.20	.15	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal
Tensile Strength
Bonding Temperature

Maximum Value Up to:
up to 44,000 PSI (315 MPa)
800° - 1000°F

BRAZING INSTRUCTIONS

Brazing Techniques: Clean the surface and preheat heavy sections. For thin flowing, adjust the torch to 3X carburizing and preheat to a higher temperature. Once the piece is preheated simply allow some of the flux to melt off the rod. When the flux flows through the joint melt off some of the alloy and keep the torch moving constantly until the alloy flows throughout the joint.

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.)