



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

# SELECTRODE 2111

A Rub-on Solder for Aluminum  
without Flux

## INTERNATIONAL CLASSIFICATIONS

DIN: 1707: L-Zn Sn20

## FEATURES & APPLICATIONS

Ideal for joining aluminum extrusions used in the manufacture and repair of aluminum doors and windows. Also for repairing leaders, gutters, siding, aluminum boats and instrument boxes. Most kirksite and zinc base die castings can be repaired with this alloy. Can also be used as a wearfacing alloy on aluminum.

Maximum strength, self fluxing solder for joining, build-up and hardfacing aluminum.

- High zinc content gives good color match to aluminum.
- No flux required - post cleanup is eliminated.
- Low working temperature prevents warpage, distortion and discoloration.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Zn	Cu	Al
Bal	9	10

## TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	35,000 PSI (260 MPa)
Working Temperature	approx. 710°F (375°C)
Corrosion Resistance	Very Good
Color Match Very	Very Good

## SOLDERING INSTRUCTIONS

**Soldering Techniques:** Joint area should be thoroughly cleaned, preferably by mechanical means (scraping, filing, etc.). Bevel heavy sections. Use jigs or clamps to hold parts in alignment. With a carburizing flame, heat base metal to approximately 750°F (400°C), rub alloy in the joint. Do not heat rod with flame but let the heat from the part to be soldered melt the rod. Vigorous rubbing of the base metal surface allows the rod to break through the tough oxide and bond to the sound metal. Higher strengths and better bonds may be obtained by using a clean stainless steel wire brush through the molten solder to the base metal surface. Allow part to cool slowly.