



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

**SELECTRODE**  
**2191**  
**Torch Brazing Alloy for**  
**Aluminum**

**INTERNATIONAL CLASSIFICATIONS**

**AWS A5.10 ER 4047**  
**DIN 1732: SG-AL Si12**

**EN ISO 18273 SAL 4047**

**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.

All purpose brazing/welding alloy for aluminum

- Designed for joining all brazable grades of aluminum sheet, plate, tubing and piping, extrusions, rod and wire
- To be used with aluminum powdered flux product code 5190

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

Si	Fe	Cu	Mg	Mn	Zn	Ti	Al
12	.3	.001	.003	.04	.001	.004	Bal

**TYPICAL MECHANICAL PROPERTIES**

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	up to 35,000 PSI (250 MPa)
Bonding Temperature	800° - 1000°F

## BRAZING INSTRUCTIONS

**Brazing Techniques:** Clean the surface and preheat heavy sections. Use a powdered aluminum brazing flux. Heat the first 2"-3" of the rod and dip it into the jar of flux. Adjust the torch to a neutral to slightly carburizing mixture face feed into the flame. 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.