

**FORCE
INDUSTRIES
DIVISION**

American Solder & Flux Co., Inc. □ 28 Industrial Boulevard □ Paoli, PA 19301-0947 □ (610) 647-3575 □ FAX (610) 647-2375

PRODUCT INFORMATION

AMCO 2213 ALUMINUM SOLDERING FLUX

(113)

GENERAL CHARACTERISTICS AND USES

Amco 2213 is a chloride free liquid, low viscosity flux designed specifically for soldering to aluminum, to copper and to stainless steel. This flux is formulated with amines and complex inorganic fluorides with an optimal temperature range of 350F - 550F. Excellent results when used with 91Sn/9Z, 63Pb/34/Sn/3Zn or 50Sn/50Zn soldering alloys.

PHYSICAL DATA

- Clear to hazy, amber colored, syrup.
- Specific Gravity: 1.30 @ 68 °F
- Working Temp. 350°F to 550 °F
- Weight per gallon: 10.8 lbs
- pH 7 - 9

PERFORMANCE CRITERIA

- Residue is slightly corrosive - remove with hot water.
- Rapid cleaning and de-oxidation of surface area
- Excellent dispersion properties
- Proven performance on aluminum cable and wire connector.
- Chars and deteriorates near 600 °F with loss of fluxing action. Avoid overheating.

STORAGE AND HANDLING

- Shelf Life: At least one year in the unopened original and undamaged container stored at room temperatures.
- Keep from freezing. The product will increase in viscosity at low temperatures. Warming will restore it to normal working viscosity.

PACKAGING

- 1 lb. bottles - 12 per case
- 10 lb. bottles - 4 per case Gallon jugs - 4 per case
- 50 lb. Pail