

**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 3922

(278)

General Characteristics and Uses

AMCO 3922 is a general, all-purpose silver brazing flux designed specifically for industrial applications. This smooth, creamy paste provides excellent results when used with most ferrous and non ferrous metals, in any combination. Proven performance with stainless steel, tungsten, copper, brass, bronze, steel and iron, among others. Commonly used in torch, furnace and induction applications at a range of 1050° F to 1600° F. Conforms to: Federal Spec. OF-499D / Type B. AWS Brazing Class - Type FB3A
AWS 3410-J.

Physical Data

- Smooth, white paste
- Specific gravity: 1.55 @ 72 F
- Weight per gallon: 12.9
- pH: 7 - 7.5

Performance Criteria

- Residue - easily removed while hot, use water
- Superior wetting and dispersing action
- Completely cleans surface while protecting from re-oxidation during heating
- Will retard discoloration of braze area if temperature is uniform
- Not to be used with aluminum or aluminum alloys

Storage and Handling

- Ready for use as received
- Shelf life: one year in un-opened container keep from freezing
- Packaging: 1 and 5 lbs jars
25 and 50 lb pails

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