

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

**AMCO 38
Brazing Flux**

(373)

GENERAL CHARACTERISTICS AND USES

AMCO 38 is a powder flux formulated from boron compounds for oxyfuel welding (OFW) of gray and malleable cast iron. The flux protects the molten metal from oxidation, increases the fluidity of the slag, and helps dissolve oxides and other impurities. This allows for control of the size and shape of the weld bead.

PHYSICAL DATA

Specific Gravity (g/cc):	1.625
Melting Points (°F):	850
Bulk density:	51 lbs. Per cubic feet
Particle size:	270 microns
AWS Brazing Classification:	Type B
Shelf Life:	At least one year in unopened container store under room conditions.

APPLICATIONS

Flux may be applied by dipping the heated rod into the powder flux.
Working temperature: 1300-1800°F.
Good results obtained using AWS RC1, RC1-A, RC1-B filler metal.

RESIDUE

Glassy residue can be removed with water. Removal of residue may be accelerated by immersing in water before it has fully cooled from the brazing temperature.

PACKAGING

1 lb. and 50 lbs. Units