

**FORCE  
INDUSTRIES  
DIVISION**

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

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**PRODUCT INFORMATION**

**PETERSON #3**

(594)

**Cast and Malleable Iron Brazing Flux**

**GENERAL CHARACTERISTICS AND USES.**

**Peterson #3** is a two-component powder flux for brazing cast and malleable iron at low and medium heat. When constituted, the flux cleans fast and promotes extra strong bonds. The flux provides both oxidizing and reducing agents to effectively clean the metal surface to be brazed. The flux generates an inert atmosphere above the fluxed area and hinders re-oxidation of the metal.

**APPLICATION**

- ◆ BAg series filler metals are recommended as they melt and flow at low temperature. Type BCu may also be used but at higher temperatures. Some applications may find BNi or RBCuZn suitable.
- ◆ Mix equal amounts of flux portion before use.
- ◆ Heat joint area with torch and apply flux. Continue heating until filler metal wets the surface of the metal.
- ◆ In addition to dipping the heated end of the filler rod, sprinkling the flux into the molten puddle will float oxides.

**RESIDUE**

- ◆ Glassy residue can be removed mechanically by chipping.

**PACKAGING**

- ◆ 1 lb. can each of part A and part B

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