

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

AMCO 1970

(133)

General Characteristics And Uses

AMCO 1970 is a brazing flux for cast iron. It is designed specifically for torch brazing.

Physical Data

- General description: Red powder
- Specific Gravity: 1.87
- Particle size: Average 270 microns
- Bulk density: 55 lbs. cu. ft.
- AWS Brazing Classification: Type 5
- Shelf life: 1 year in unopened container stored at room temperature

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Application

- Good results obtained using BA_g – 3 & 4 filler metal
- Working range: 1270 – 1500 °F
- Brazing can be accomplished by dipping the heated end of the filler rod into the powdered flux and melting it off onto the casting with a torch.

Residue

- Warm water will normally remove the residual flux.
- In case of overheating, etc., the flux is more difficult to remove. Quenching may be necessary to crack off the residue.

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