

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

AMCO 446 Black

(199)

High Temperature Silver Brazing Flux

General Characteristics and Uses

Amco 446 Black is a silver brazing flux designed for extended heating times or temperature through the use of metallic boron additive. This smooth, creamy paste provides excellent results when used with most ferrous and non-ferrous metals, in any combination. Commonly used in torch, furnace and induction applications at a range of 1050° F to 1600° F. Proven performance with stainless steel, tungsten, copper, brass, bronze, steel and iron, among others. The flux belongs to AWS Brazing Class - Type FB3C and AMS 3411.

Physical Data

- Smooth, black paste
- Specific gravity: 1.55 - 1.65 @ 72 F
- 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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