

**FORCE  
INDUSTRIES  
DIVISION**

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## **PRODUCT INFORMATION**

### **AMCO 4674 ALUMINUM BRAZING FLUX**

(249)

#### **GENERAL CHARACTERISTICS & USES**

*AMCO 4674* is an aluminum brazing flux formulated from various alkali chlorides and fluorides. When used on brazeable aluminum, the flux displaces the oxide layer and protects the metal from oxidation. It lowers the metal's surface tension and enhances the wetting of the surface by the filler alloy.

#### **PROPERTIES**

Form	White, fine powder.
Odor	None
Bulk Density:	45 lbs. cu. ft.
Working Temp.	1050-1180°F
pH (2% in Water)	6
Recommended Filler Metal.	BAISi

#### **APPLICATION**

Amco 4674 is best applied as a slurry. To make the slurry mix 3 parts flux with 2 parts water. Use of non-metal tools and container, such as plastic, is recommended. Apply the flux to the cleaned aluminum surface by brushing, spray or via a dispenser on to the area to be brazed. The flux slurry is better applied when used with Amco 4917 surfactant. For every one gallon of slurry add 1 oz of Amco 4917 and mix thoroughly. The flux residues after brazing are easily removed by water. The removal of the residues is enhanced by the mechanical action of pressurized water spray.

Caution: Brazing may generate toxic fumes. Brazing should only be done in a place where any fumes generated can be exhausted.

#### **STORAGE AND HANDLING**

Store in sealed airtight container. Specks of dirt or metal in the flux may cause pinholes in brazed joints.

**PACKAGING** 35 lb bags

While we believe all information presented herein is accurate and reliable, the data are not to be taken as a guarantee or representation of any kind for which Force Industries assumes legal responsibility. They are offered solely for your consideration, investigation, and verification.