

FORCE INDUSTRIES DIVISION

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PRODUCT INFORMATION

AMCO 444 Green Brazing Flux

GENERAL CHARACTERISTICS AND USES

- AMCO 444 Green is a paste flux formulated from boron compounds for oxyfuel welding (OFW) of gray and malleable cast iron as well as non-ferrous metals. 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): 1.36
- Melting Points (°F): 850
- Bulk density: 84.9 lbs. Per cubic feet
- AWS Brazing Classification: Type D
- Shelf Life: At least one year in unopened container store under room conditions.

APPLICATIONS

- Flux may be applied by dipping or brushing the heated rod with the paste 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

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