

**FORCE  
INDUSTRIES  
DIVISION**

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**PRODUCT INFORMATION**

**AMCO 444 Powder**

**Brazing Flux**

**GENERAL CHARACTERISTICS AND USES**

- AMCO 444 Powder is a powder flux formulated from boron compounds for oxyfuel welding (OFW) of gray and malleable cast iron. 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): 1.62
- Melting Points (°F): 850
- Bulk density: 51 lbs. Per cubic feet
- AWS Brazing Classification: Type B
- Shelf Life: At least one year in unopened container store under room conditions.

**APPLICATIONS**

- Flux may be applied by dipping the heated rod into the powder 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

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