

**FORCE
INDUSTRIES
DIVISION**

American Solder & Flux Co., Inc. • 28 Industrial Boulevard • Paoli, PA 19301-0947 • (610) 647-3575 • FAX (610) 647-2375

PRODUCT INFORMATION

AMCO 3922 BLUE

(453)

General Characteristics And Uses

AMCO 3922 Blue is a general, all-purpose silver brazing flux designed specifically for industrial applications. This smooth, creamy paste provides excellent results when used with most ferrous and non-ferrous metals, in any combination. Proven performance with stainless steel, tungsten, copper, brass, bronze, steel and iron, among others. Commonly used in torch, furnace and induction applications at a range of 1050 °F to 1600 °F. Conforms to: Federal Spec. OF-499D / Type B; AWS Brazing Class – Type FB3A; AWS 3410-J.

Physical Data

- General description: Smooth blue paste
- Specific gravity: 1.55 @ 72 °F
- Weight per gallon: 12.9
- 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: 1 year in un-opened container
- Keep from freezing

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