

**FORCE  
INDUSTRIES  
DIVISION**

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## **PRODUCT INFORMATION**

**AMCO 121**  
**LIQUID SOLDERING FLUX**

(514)

### **GENERAL CHARACTERISTICS AND USES.**

*Amco 121* is a highly activated, inorganic, water base flux specifically designed for stainless steel alloys containing 11-27% chromium. Excellent low to medium range temperature characteristics, used with soft solder. A balanced blend of zinc and ammonium chlorides, wetting agents and activator. Conforms to OF-506c, Type II, Form B, superseded by AA51145, Type 1 Form B

### **PHYSICAL DATA**

- ◆ Water clear liquid.
- ◆ Specific Gravity: 1.34 @ 72 °F
- ◆ Weight per gallon: 11.1 lbs

### **PERFORMANCE CRITERIA**

- ◆ Residues are water soluble, slightly corrosive. Remove with warm rinse.
- ◆ Excellent wetting properties.
- ◆ Can be applied to faying surface without prior treatment of metal.
- ◆ Operating temperature range: 350 – 550 °F

### **STORAGE & HANDLING**

- ◆ Shelf life. Indefinite in the unopened original container stored at room temperature.
- ◆ Use as received, no mixing required

### **PACKAGING**

- ◆ Quart bottles – 12 per case
- ◆ Gallon jugs – 4 per case
- ◆ 5 gallon jugs
- ◆ 55 gallon drums

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