

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

AMCO 22

(579)

General Characteristics and Uses

Amco 22 is a high-activity flux for oxyacetylene and oxyhydrogen gas welding aluminum. This flux is used with pure aluminum filler such as 1100 and the aluminum-silicon alloy fillers such as 4043 and 4047. It meets the requirements of Aerospace Military Specification 3414. Use with the 5xxx series aluminum filler alloys is not recommended.

Physical Data

- General description: Made from high purity metal chlorides and fluorides
- Color: White
- Particle size: 80% min through 100 mesh
- Specific gravity, molten: 1.67 @ 1190 °F
- Melting range: 1,120 – 1,150 °F

Application

- AMCO 22 is mixed with distilled or de-ionized water to form a paste consistency. Normally, three parts flux are mixed with one part water by weight.
- Application of the flux to the filler rod is usually adequate for gas welding. This is accomplished by brushing the flux onto the rod or by dipping the rod into the flux-water mixture. In some cases, application of the flux to the joint edges is also beneficial.
- Flux will promote corrosive attack on the aluminum parts if the residues are not removed after welding. Good flux welding practices dictate that all flux residues be removed from welding parts using recommended flux removal practices.

Precaution

Amco 22 may exhibit slight hygroscopic property. It could absorb moisture and “cake” into hard lumps if exposed to ambient air for extended periods of time. The flux container should be kept sealed until used and when not in use.

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