

**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 341

(583)

General Characteristics and Uses

Amco 341 flux is an all-purpose dip flux well established in the industry with years of excellent service. It is a specially compounded, high-activity flux suited for brazing all brazeable aluminum alloys, including wrought products, forgings, extrusions and certain castings. The coarse particle size of this flux permits makeup additions to the dip pot with less dusting.

Physical Data

- General description White powder consisting of alkali metal chlorides with small amount of aluminum fluoride
- Density 1.67 gms/cc (104 lbs/ft³)
- Melting range 900 – 1035 °F
- Specific heat (approx) 0.2 Btu/lb/°F
- Heat of fusion (approx) 168 Btu/lb
- Heat requirement to heat 1 lb
Flux from solid at 70 °F to
Liquid at 1105 °F (approx) 385 Btu
- Resistivity, ohm-cm at 1080 °F 0.43 +/- 0.01
1130 °F 0.36
1150 °F 0.33
- Solubility – Water, Boiling 94 – 95%
- Effect of exposure to:
 - Air None
 - Water None, but absorbs moisture from air
 - Strong oxidizers None
 - Heat and fire Metal halide fumes and, in presence of water vapor,
possibly HCl and HF
- Corrosivity Corrosive to steel, brazed joints and surrounding metal

Application

- AMCO 341 flux is more chemically active than AMCO 501 flux. It possesses good activity over a wide brazing temperature range and, therefore, is well suited for brazing difficult-to-braze casting alloys. Brazing with 341 flux can be accomplished using any type of dip brazing equipment. However, for consistent brazing results, dip pots should have the ability to maintain temperature with a +/- 5 °F range. Normal pot operating temperature range should be between 1050 – 1150 °F, depending on the alloy being brazed.

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Residue

- Flux will promote corrosive attack if left on brazed aluminum assemblies. Good brazing practice dictates that all flux residues be removed from brazed parts using recommended flux removal practices.

Caution

- AMCO 341 flux is manufactured in a closely controlled low-humidity environment. The dry powdered flux is hygroscopic and will pick up moisture if exposed to ambient air. The flux container should be kept sealed until used.

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