

**AMTEC 1028 FC YELLOW BRASS BRAZING**  
**LOW FUMING ALLOY FOR USE WITH TORCH**

**General Characteristics**

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Amtec 1028 FC is a triple deoxidized bronze brazing alloy with a moisture sealed flux coating. It eliminates the harsh chemical odors and normal glare of conventional type products. The smooth moisture sealed flux has extremely good shelf life, and the flux is designed for exceptional cleansing on dirty steel and cast iron. As a general rule, preheat wide area to be welded to 700°F, and then the specific area to be welded to 1200°F prior to adding filler metal.

**Procedure**

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Clean the weld zone of all contaminants. A rough ground surface will produce the best results. This flux coated alloy does not need extra flux and will break down tough oxides that normally form. Use a slightly oxidizing flame, and concentrate on the base metal and not the rod. Keep the torch in constant motion to prevent overheating of local areas. Do not overheat the base metal. The base metal should only become molten when fusion welding bronze parts. Direct the flame where you want the alloy to flow, and the alloy will follow the heat. Allow part to cool slowly when done, and remove flux with a stainless steel wire brush.

**Application**

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Amtec 1028 FC is excellent for production fabrication and maintenance repair of most ferrous and nonferrous metals, except the white metals. Ideal for joining metal furniture parts, galvanized steel, automobile body work. Can also be used on brass and bronze castings.

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<b>Tensile Strength</b>			<b>71,000 PSI</b>
<b>Yield Strength</b>			<b>64,000 PSI</b>
<b>Elongation</b>			<b>27%</b>
<b>Melting Point</b>			<b>1583-1620°F</b>
<b>Working Temperature</b>			<b>1595°F</b>

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<b>Diameter (Inch)</b>	<b>3/32</b>	<b>1/8</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.25</b>

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**CONFIDENTIAL INFORMATION**  
Subject to change without notice

**White Flux Coating**  
**18 Inch Rod**