



AMTEC 435 FC FLUX CORED ALUMINUM

FOR USE WITH OXY-ACETYLENE TORCH

General Characteristics

Amtec 435 FC aluminum torch rod is a unique product that contains a highly active flux core, sealed inside the alloy, which allows for easy application and very economical use. The melting range of this flux is controlled to ensure that the alloy yields dense, non-porous deposits with minimum flux residue. Its fluidity at higher temperatures enables it to have free flowing characteristics when used on lap joints or around tubing. Likewise, its high viscosity at lower temperatures allows it to fill gaps or build up sections. Color match is good on most aluminum.

Procedure

Clean the weld zone of all contaminants. Bevel parts thicker than 3/16 inch to form a 60° Vee. With oxy/fuel torch adjusted to a slightly carburizing flame, heat workpiece broadly to about 1000°F. Melt ¼ inch of the rod off onto the workpiece, and watch the flux turn to a liquid, then continue to heat until the alloy flows out. Lower the angle of the torch and continue to add the alloy a drop at a time until the weld is complete. Allow the part to cool slowly, and remove the flux residue with a stiff brush and warm water. When finished with project, crimp the end of the rod to seal in the flux.

Application

For all weldable grades of aluminum, sheet, cast and pipe. "Thin Flowing" for tight fitting joints or "Bead Forming" for fitting applications. Excellent for fabrication and repair of aluminum furniture, fans, window frames, truck and trailer bodies, and appliances. Also does an excellent job on aluminum pipe.

Tensile Strength	34,000 PSI
Compressive Strength	20,000 PSI
Elongation	15-25%
Hardness (HB)	40-55
Melting Point	1100°F (598°C)

Diameter (Inch)	1/8 X 28 inch lengths
(mm)	3.25

CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color – Plain
No Imprint – Bare Rod