

AERONAUTICAL MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
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AMS 3410 A

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F L U X Brazing (Silver)

1. ACKNOWLEDGMENT: Vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase order.
2. USE: Silver brazing non-ferrous and ferrous materials, including austenitic steels, at temperatures between 1200 and 1600 F.
3. FORM: Paste containing not more than 30% water, by weight.
4. REQUIREMENTS:
 - (a) Flux shall withstand heating in a ceramic container to 1600°F. and holding at this temperature for 30 minutes without appreciable change in chemical characteristics, except for loss of water. On heating, flux shall fuse at 1150°F or lower; on cooling from 1600°F, flux shall remain in the liquid state until temperature drops to 1150°F or lower.
 - (b) A sample of flux as received, when placed on a 40-mesh sieve and worked lightly with a brush, shall pass completely through the sieve.
 - (c) Flux shall not produce, during use, a flame or smoke of sufficient intensity to obscure the work.
 - (d) A mixture of 3 parts water and 1 part of flux shall have acceptable fusibility and acceptable application and fluxing characteristics, and shall produce satisfactory brazed joints of any type on copper base alloys and all types of steels, including corrosion resistant types, when used in conjunction with silver brazing alloys.
 - (e) Flux shall be readily soluble in water at 175°F after being subjected to brazing operations.
5. QUALITY:
 - (a) Flux shall be an intimately blended mixture of uniform consistency. It shall not separate in container to such an extent that it can not be restored to uniform consistency by stirring.
 - (b) Flux shall be free from all substances which might affect its serviceability.
6. REPORTS: Vendor shall furnish, with each shipment, three copies of a notarized report stating that flux conforms to all requirements of this specification. Report shall include the purchase order number, material specification number and title, batch number, date of manufacture, and quantity.
7. PACKAGING:
 - (a) Flux shall be supplied in 8-ounce, 16-ounce, or 5-pound glass containers, as ordered.