AEROSPACE MATERIAL SPECIFICATION

AMS2673™	REV. F

Issued 1960-06
Reaffirmed 2018-02
Revised 2022-08

Superseding AMS2673E

Brazing, Aluminum and Aluminum Alloys Molten Flux (Dip)

RATIONALE

AMS2673F results from a Five-Year Review and update of this specification with the addition of ordering information, added reference to destructive testing to coverage (3.6.2), reworded and clarified chlorides (3.6.5.1) and fluorides (3.6.5.2) to state the same requirements as in AMS2472, changed flux removal to halide test in acceptance tests (4.3.1), deleted destructive coverage test from periodic testing (4.2.2) as it is a required acceptance test, added suspension of periodic testing per general agreement, added note 2 to Table 1 sampling for acceptance testing that requires sampling to be agreed upon when lot sizes are less than 40, and revised dimensions and properties statement to reflect that some SI units are primary (8.4).

NOTICE

ORDERING INFORMATION: The following information shall be provided to the brazing processor by the purchaser.

1. Purchase order shall specify not less than the following:
   - AMS2673F
   - Quantity of pieces to be brazed
   - Method for determining area joined by filler metal (3.6.2)
   - Standards for acceptance and method of test when proof test is required (3.6.3)
2. Parts manufacturing operations such as heat treating, forming, joining and media finishing can affect the condition of the substrate for brazing, or if performed after brazing, could adversely affect the brazed part. The sequencing of these types of operations should be specified by the cognizant engineering organization or purchaser and is not controlled by this specification.

1. SCOPE

1.1 Purpose

This specification covers the requirements for producing brazed joints of aluminum and aluminum alloys by immersion in a molten flux bath.

1.2 Application

This process has been used typically for joining aluminum and selected aluminum alloys.

TO PLACE A DOCUMENT ORDER: **Tel: 877-606-7323 (inside USA and Canada)**
Tel: +1 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: CustomerService@sae.org
SAE WEB ADDRESS: **http://www.sae.org**

For more information on this standard, visit
https://www.sae.org/standards/content/AMS2673F/