235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2000
Certified

PRODUCT: **ULTRA FLUX**
SILVER BRAZING FLUX

TECHNICAL DATA:

Composition	Potassium salts of fluorine and boric acid
Type	Paste – Particle size #325 mesh or finer
Ph	8.0
Water Content	35% or less
Dilution	Water (60cc/lb) Heat 150-170ºF
Application	Brush, dip, or spray
Containers	½ lb., 1 lb., and 5 lb. jars 30 lb. and 65 lb. pails
Specifications	AWS Brazing Flux FB3-A OF499c, Type B AMS 3410
Effective Range	1100ºF-1600ºF

ULTRA FLUX is a water base paste consisting of a unique combination of potassium salts of fluorine and boric acid. It is recommended for use with torch, induction, furnace, resistance, dip and other heating methods. Our quality control ensures a creamy consistency, with no grittiness. **ULTRA FLUX** can be used in the concentrated form or can be diluted. Heating the flux to 150ºF - 175ºF dilutes it to a thin consistency without water. **ULTRA FLUX** also readily dilutes to a thin consistency using 60cc of cold or hot water per pound of flux.

5 lbs. flux & 300 cc water = 1/3 quart
30 lbs. flux & 1800 cc water = 2 quarts
65 lbs. flux & 3900 cc water = 1 gallon

Water diluted flux retains good suspension without settling.

ULTRA FLUX can be applied using a brush, dip or spray. The wetting ability is excellent. Vertical adherence as applied and upon heating is excellent. There is no spatter on heating with concentrated flux, slight spatter will occur with water diluted flux due to escaping steam. **ULTRA FLUX** has excellent adhesion without cracking when applied to parts which are air dried or heat dried before brazing. It also has a long storage life without crystallizing or caking.

PRODUCT: **ULTRA FLUX - CONTINUED**
SILVER BRAZING FLUX

Protection of parts and flux life under heating are excellent. Oxide absorption and brazing alloy flow are also excellent on all metals when **ULTRA FLUX** is used. Flux residue removal is easy with hot water. This feature saves time and problems with corrosion later on.

When brazing with **ULTRA FLUX**, the braze joint quality is excellent. **ULTRA FLUX** conforms to the various AMS, AWS and Government specifications which are listed on the flux label.

LIABILITY-DISCLAIMER:

Wolverine Joining Technologies, LLC, seeks to represent reliable information concerning the composition, properties and use of its products. The technical information provided in this publication is provided at no charge and is without guarantee, warranty or responsibility of any kind, expressed or implied.

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