



UltraFlux – DATA SHEET

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Description

UltraFlux is water based active fluoride/borate-type flux in paste form. It is formulated to ensure a creamy consistency and to provide excellent adhesion when dipped or brushed on components. UltraFlux is best used with filler metals that flow between 1100°F (593°C) – 1600°F (871°C). The flux provides excellent protection of components up to 1600°F (871°C).

Application

UltraFlux is general purpose brazing flux primarily used in applications involving brazing of steel, stainless steel, copper, copper alloys, nickel, and nickel alloys. It is not recommended for use in aluminum bronze or other aluminum alloy brazing applications. UltraFlux is suitable for use with most heating methods including torch, furnace or induction. This product exhibits excellent adhesion, oxide absorbing capabilities, and minimal splattering during the brazing process. Flux may require mixing, dilution or warming to regain its normal consistency prior to use.

Post Cleaning

This product is corrosive, and post-braze cleaning or rinsing is required. The flux residue is easily dissolved in hot water at temperatures of 120°F (50°C) or higher.

Storage

If stored for an extended period of time some separation within the flux may occur. In such case stir the flux until proper consistency is restored. UltraFlux readily dilutes to slurry consistency (per AWS A5.31M/A5.31 *Specification for Fluxes for Brazing and Braze Welding*) using 60cc of cold or hot water per pound of flux. Care must be exercised when adding water as the concentration of fluxing salts is reduced and spitting may increase. Water concentration of original product is 35% by weight of flux.

UltraFlux is warranted for twelve months from the date of shipment if stored in the original, unopened container. Optimal storage condition is dry, cool ambient temperature 65°F (18°C) – 75°F (24°C). Twelve months should not be interpreted as the shelf or useful life of the product unless actual test results indicate unsatisfactory performance for the intended application. Flux stored beyond the warranty period may be reconstituted to a working consistency by warming in a water bath and/or by adding distilled or de-ionized warm water.

Flux, when placed on a U.S. standard 40 mesh (425 micron) sieve conforming to ASTM E11 and worked lightly with a brush shall pass completely through the sieve. If the flux has coagulated partially in the container, prior to testing, the flux may be warmed in a water bath until it has returned to its normal consistency.

Available Packaging

UltraFlux is available in a number of packaging options including: ½ lb, 1 lb, 5 lb, 25 lb and 50 lb containers.

Specifications

UltraFlux conforms to the following specifications:

- American Welding Society (AWS) A5.31 FB3A
- Society of Automotive Engineers (SAE) / AMS 3410
- Federal Specifications O-F-499D, Type B

Safety Information

The operation and maintenance of brazing equipment or facility should conform to the provisions of the American National Standard (ANSI) Z49.1, *Safety in Welding and Cutting*. Refer to the Safety Data Sheet for more information.