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MILWAUKEE VALVE

TECHNICAL BULLETIN

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UltraPure – Installation of Cast Bronze, ASTM B584 Alloy C89833, Solder End Connection Valves

This technical bulletin provides information regarding installation of Milwaukee Valve's UltraPure Bronze Solder End Valves.

This technical bulletin is in conjunction with previously released information available on our website regarding considerations when soldering our UltraPure bronze valves. Low/no lead alloys have lower thermal conductivity and heat transfer coefficients. This means it takes extra time to properly apply the heat and for the heat to be distributed when soldering. Heat should be applied evenly to the joint, not just in one area, as issues could develop if overheated. Please refer to the Two Piece Ball Valve IOM or Three Piece Ball Valve IOM for installation instructions .

Industry best practices need to be used when soldering at installation, whether the material is a standard bronze or a low lead bronze. For low lead bronze, Milwaukee Valve continues to recommend low melt temperature solders whenever possible.

The effects of overheating the valve / solder joint during installation could result in altering the bronze low lead material that can potentially diminish the performance of the valve / solder joint. For this reason, **Milwaukee Valve UltraPure bronze solder end valves are not to be installed by brazing** due to the high heat input required for the brazing process.

Milwaukee Valve has used ASTM B584, Alloy C89833 to manufacture our UltraPure bronze valves from the initial UltraPure product launch to comply with state and federal laws for use in potable water systems.

With dependence on design/configuration, valves manufactured with our standard bronze alloys (non-UltraPure alloy) are suitable to be brazed. Fully assembled valves cannot be brazed as internal components will be damaged from the high heat input. 3-Piece standard bronze alloy valves are best recommended for brazing due to their capability to be dis-assembled and re-assembled in the field.

Please consult the factory with further installation questions or for additional information.