

# Induction Soldering Steel to Brass

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering induction melting and induction surface treatment applications  
<http://www.uihm.com>

## Objective

Heat an assembly of small, gold-plated steel connectors to a brass block.

Approx. 1/8" (3.2mm) diameter gold-plated steel connectors,

1" (25.4mm) square x 1/4" thick brass block, 600°F (315.6°C), 240 kHz

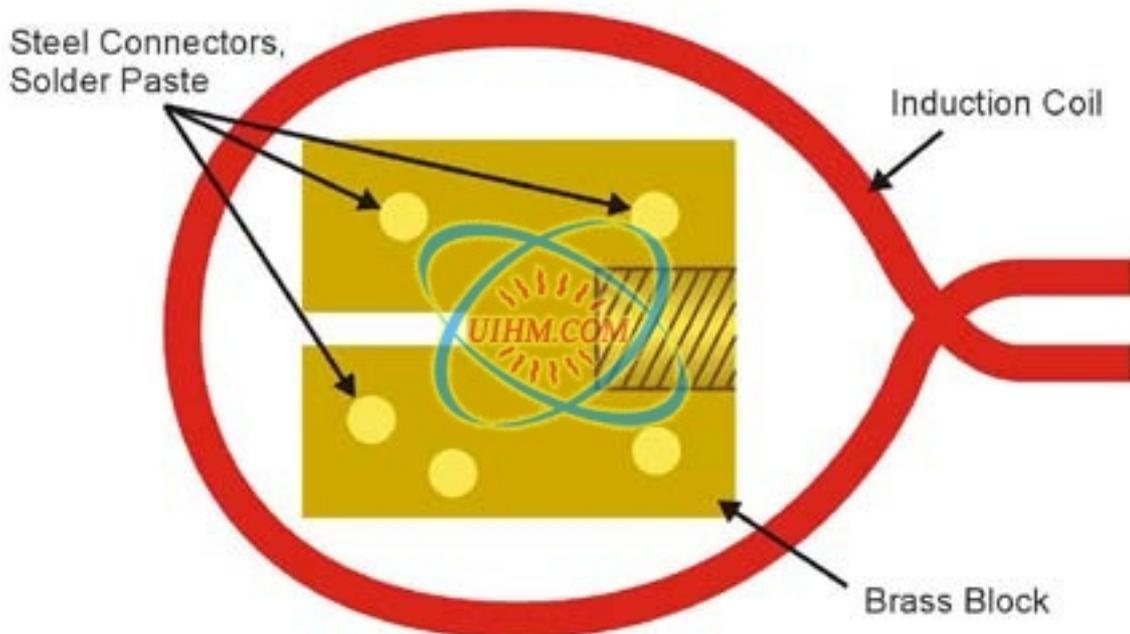
Temperature, Frequency, Equipment

6 kW induction heating system equipped with a remote workhead.

An induction heating coil designed and developed specifically for this application.

## Process

A two-turn helical coil is used to provide uniform heat to parts assembly. Solder paste and flux are applied to the joint area and power is applied for 20 seconds to solder the parts. Proper fixturing is needed to hold the parts in position.



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