

# Induction Soldering brass tubes

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>

**Soldering brass tubes Objective:** Soldering two brass tubes measuring 3/4 and 1/4 together for use as cellular phone antennas. The lengths of tubes range from four (4) feet to twelve (12) feet, and must be soldered along the axial side. The joint is to be made using 60/40 Tin Lead Solder and Kestor Rosin paste flux.

**Material:** Brass Tubes measuring 3/4 and 1/4 60/40 Tin Lead Solder Kestor Rosin Flux  
**Temperature:** 375°F

**Application:** Through the use of the the Power of 15KW, 15kW output solid state induction power supply along with a unique five (5) turn 12 long channel coil, the following results were achieved:

- \* 375°F was reached and the solder flowed after a heating period of 35 seconds.
- \* A production rate of 24 per minute was determined to be adequate.
- \* A quality solder fillet was observed after heating and cooling

**Equipment:** Power of 15KW, 15kW output solid state induction power supply including one (1) remote heat station containing two (2) capacitors, and a unique five (5) turn channel coil made from 3/16 copper tubing and measuring 1 1/4 by 12.

**Frequency:** 75 kHz Soldering brass tubes

[service@uihm.com](mailto:service@uihm.com)

United Induction Heating Machine Limited

