

Induction Brazing stainless steel joint

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 Braze an end plug on a stainless steel joint of the car grill before powder coating application

Material Stainless steel car grill 0.5" x 0.19" (12.7mm x 4.8mm), end plugs and braze ring

Temperature 1350 °F (732°C)

Frequency 267 kHz

Equipment • Power of 10kW induction heating system, equipped with a remote workhead containing one 0.66µF capacitor.

• An induction heating coil designed and developed specifically for this application. Process A three turn square shaped helical coil is used to heat the end of the grill. End plugs are inserted into the grill and the assembly is inserted into the coil for 30 seconds. The braze flows to create a neat and clean leak-proof joint.

Results/Benefits Induction heating provides:

- Rapid localized heat to joint area only
- Minimized oxidation reduces cleaning time
- Hands-free heating that involves no operator skill for manufacturing
- Even distribution of heating

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