

Induction Soldering 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
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Soldering brass **Objective** To solder a brass end cap to a series of copper tubes
Material Preassembled heat exchanger with copper tubes and 2 brass end caps 2.36" (60mm) OD, 0.08" to 0.12" (2 to 3mm) thick at both ends, liquid solder
Temperature 302°F (150°C)
482°F (250°C)
Frequency 237kHz

Equipment • Power of 30kW induction heating system, equipped with a remote workhead containing one 1.0μF capacitor

- An induction heating coil designed and developed specifically for this application. Process A dual four turn pancake coil is used to solder 2 brass caps per cycle. Liquid solder is squirted onto the end cap and is heated for 18 seconds at 302°F (150°C) to burn off the flux. Then the heat is increased to 482°F (250°C) for 15 seconds to solder the parts.

Results

Induction heating provides:

- Even distribution of heating
- Compared to hot plate, induction heating is able to heat two parts in 30 seconds vs. one part in 60 seconds
- Increased production
- No discoloration with the slow heating process

brass end cap

Soldering

brass end cap



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