

Induction Brazing Copper Tube

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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Objective To braze a copper tube (3/8" OD by 2-4" long) into a 3/8" fitting in less than 10 seconds. Heating must take place in a channel type coil to allow for easy loading of parts.

Material Copper Tubing and Fitting with Braze and Stay Silv White Flux

Temperature 1300°F

Frequency 105 kHz

Equipment Power of 10 kW output solid state induction power supply equipped with a standard heat station containing eight 0.33 μF capacitors for a total of 0.66μF, a step down transformer, and a specifically designed induction heating coil.

Process Power of 10 kW solid state induction power supply was setup to achieve the following results:

- 2.0 kW of power was directly loaded into the copper tube resulting in a heating time of 7.2 seconds to reach the necessary 1300°F for brazing.

Results Processing ease was achieved through the design of a unique channel type coil comprised of three turns of 1/8" copper brazing-copper

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