

Induction Brazing Copper Fittings

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 Copper 'tees' and 'ells' are to be brazed to the aluminum body of a refrigeration valve

Material customer's valve

copper fittings

braze

Temperature 2550 °F (1400°C)

Frequency 285 kHz

Equipment Power of 15KW induction heating system including a workhead containing two 1.5 μ F capacitors (total 0.75 μ F) and a three-turn helical coil

Process The valve is placed inside the coil and RF power is applied until the part is heated to the required temperature and the braze is seen to flow into the joint.

Two tube sizes were run using the same induction system settings with differing cycle times.

Results/Benefits • energy is applied only to the zone to be heated

• heating of the joint/braze is uniform and repeatable

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