

# Induction Brazing Steel Tube with Copper Ring

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** To heat an oil suction assembly (steel tubing and filter cap) to 1,850°F (1010°C) within 15 seconds for a brazing application.

**Material** 0.125" (3.2mm) diameter steel tube and filter cap assembly, high temperature brazing flux, copper ring.

**Temperature** 1850°F(1010°C)

**Frequency** 281 kHz

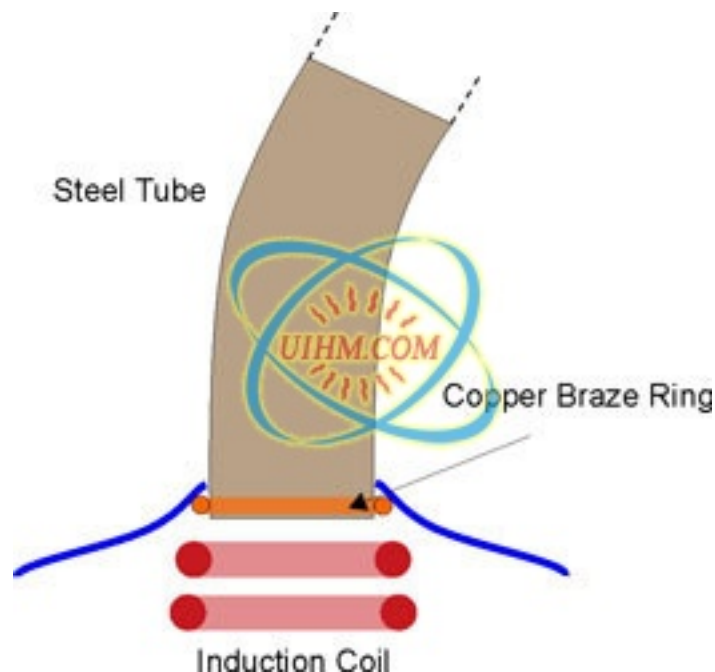
**Equipment** • Power of 10KW induction heating system equipped with a remote workhead containing 0.66 μF capacitors

- An induction heating coil designed and developed specifically for this application.

**Process** A two-turn, specially-contoured helical induction coil is used to heat the tube assembly near the joint area. A copper ring and high temperature flux are then applied to the joint area. Power is applied for 15 seconds until the braze flows.

**Results/Benefits** Induction heating provides:

- Easy loading and unloading of parts
- Heat very precise areas within production tolerances
- Hands free heating that involves minimal operator skill for manufacturing



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

United Induction Heating Machine Limited