

Induction Soldering brass and copper

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>

Soldering brass and copper Objective To heat brass and copper for soldering application on medical equipment

Material Brass ring, brass and copper pieces 5.11" (130mm) long, 4.3" (110mm) OD & 0.3" (7mm) at thickest point and solder rings

Temperature 392 °F (200 °C)

Frequency 306 kHz

Equipment • Power of 20kW induction heating system, equipped with a remote workhead containing two 0.33µF capacitors for a total of 0.66µF

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

Process This process is completed in two steps that use a 3 turn helical coil. The first process is to solder the brass ring to the copper piece which takes 85 seconds. The second step is to solder a large brass piece to the first assembly. This process takes 50 seconds for a total process time of two minutes 15 seconds.

Results/Benefits Induction heating provides:

- Hands-free heating that involves no operator skill for manufacturing
- Even distribution of heating
- Faster process time, current process takes 5 minutes
- Consistency by using solder rings

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3 Components for soldering application



Brass ring and copper piece that will be soldered together for the 1st step