Brazing a Brass Trap Block

Objective Block is heated to 1400°F to braze trap tube to assembly

Material brass block and pre-formed tubes
braze pre-forms

Temperature 1400 ºF (760°C)

Frequency 357 kHz

Equipment Ambrell 8.3kW induction heating system including
- Coil: custom-designed 2-turn split-helical
- Workhead: contains two 1.0µF capacitors (0.5 µF total)

Process The brass parts, braze pre-form and flux are assembled and located within the custom-designed coil. Induction heating of the joint is accomplished in 45 seconds.

Results/Benefits **Economy:** induction heats only the material within the coil; no energy is wasted heating the surrounding materials and air; no flame or gasses required for heating
Control: process lends itself to the use of braze pre-forms; process easily adapted to automation
Efficiency: energy is expended only during the joint formation

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