

# Induction Soldering Steel 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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Soldering Steel Tube Objective Heat a. 1.25" (3.175mm) diameter stainless steel tube to a 1" diameter cylinder 1" (25.4mm) tall for a soldering application

Material Stainless steel cylinder and tube

Temperature indicating paint Lead free solder preform rings

Temperature 300-400 °F (150-205 °C)

Frequency 235 kHz

Equipment Power of 6KW, 6kW, 150-400 kHz induction power supply, equipped with a remote heat station containing two 0.66 µF capacitors (total 1.32 µF).

A three-turn pancake coil induction heating coil designed and developed specifically for this application.

Process Initial tests without solder ensured that the metal reaches the required temperature and the heating pattern on the part.

Solder preform rings are placed onto the tube at the joint. The part is placed inside the induction-heating coil heated until the solder melts.

Results/Benefits Programmable and adjustable heating ramp rates achieve the desired heat profile. Too fast a heat profile does not conduct the heat through the joint and too slow a heat cycle vaporizes or dries the flux causing poor solder flow. Soldering Steel Tube

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