

Joining Techniques

For Solder Ring fittings with Copper Tube to BS EN1057

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| 1. | Equipment used when joining Solder Ring fittings:
Blow Lamp
Wire Brush
Steel Wool
Flux |
| 2. | Ensure the tube conforms to BS EN1057. |
| 3. | Select the correct fitting for the size of the tube to be connected. |
| 4. | Ends of the tube for joining must be cut cleanly across the tube diameter and be free from contamination, surface damage or defects. |
| 5. | Clean the socket of the fitting with a wire brush. |
| 6. | Clean the outside diameter of the tube with a fine steel wool. |
| 7. | Apply flux to the socket and the outside diameter of the tube. |
| 8. | Push fittings onto copper tube to the full depth of socket and make joint by applying heat evenly until solder appears between copper tube and fitting. |
| 9. | Remove excess solder if necessary. |

