

Joining Techniques (8 - 54mm Soft Solder)

The reliability of soft soldered joints is influenced by the type of flux used. Special care should be taken when choosing the correct flux.

1.

Select equipment:
Blow Lamp
Wire Brush
Steel Wool
Solder
Flux



2.

Ensure the tube conforms to the specification. Flowflex End Feed Fittings are to be installed with copper tubes that conform to BS EN 1057.



3.

Select the correct fitting for the size of the tube to be connected.

4.

Ends of the tube for jointing 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 fine steel wool.

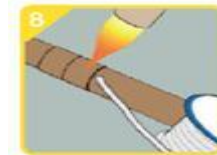
7.

Apply flux to the socket and the outside diameter of the tube.



8.

Push fittings onto copper tube to 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.