Title (en)

METHOD OF SOLDERING RIBS TO A HALF-SECTION PIPE AND A DEVICE FOR CARRYING OUT SAID METHOD

Title (de)

VERFAHREN ZUM LÖTEN VON RIPPEN MIT EINER ROHRSCHALE UND ANORDNUNG ZUR DURCHFÜHRUNG DES VERFAHRENS

Title (fr)

PROCEDE PERMETTANT DE BRASER DES AILETTES SUR DES DEMI-TUBES ET SYSTEME DE MISE EN UVRE DUDIT PROCEDE

Publication

EP 0690762 A1 19960110 (DE)

Application

EP 95906884 A 19950124

Priority

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Abstract (en)

[origin: WO9520455A1] Two steel U-shaped half-section pipes (4, 5) are joined by a steel ribbed web (2) with rectangular folds. Soldering foil (23) is placed between the ridge regions (21, 22) of the ribbed web (2) and the outer surfaces (3) of the half section pipes (4, 5). Chamber-like jointing devices (11, 12) press the half section pipes, soldering foil (23) and ribbed web (2) together. Electrically operated heating units (16, 17) are accommodated inside, and can move in relation to, the jointing devices (11, 12). The ribbed web (2) and the outer surfaces (3) of the half-section pipes (4, 5) are bonded together as the solder liquefies, re-solidifies and hardens. The half-section pipes (4, 5) can be joined to the ribbed web (2) at the same time or one after the other. In the latter case, the entire assembly (1) must be rotated by 180 DEG . After the soldering, cool air can be directed onto the soldered areas. Once two half-section pipes (4, 5) have been joined to form a heat exchanger pipe, the front faces are coated with zinc or aluminium or capped.

IPC 1-7

B23K 1/00

IPC 8 full level

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