

Title (en)

METHOD FOR BRAZING A HEAT EXCHANGER FOLDED TUBE WHILE APPLYING A FLUX NEAR A CONTACT ZONE OF THE WALLS, RESULTING TUBE

Title (de)

VERFAHREN ZUM HARTLÖTEN EINES GEFALZTEN WÄRMETAUSCHERROHRS UNTER ZUFÜHRUNG EINES FLUSSMITTELS IN DER NÄHE EINER KONTAKTZONE DER WÄNDE, SICH ERGEBENDES ROHR

Title (fr)

PROCEDE DE BRASAGE D'UN TUBE PLIE D'ECHANGEUR DE CHALEUR AVEC APPLICATION DE FLUX PROCHE D UNE ZONE DE CONTACT DES PAROIS ; TUBE AINSI OBTENU

Publication

EP 1896213 A1 20080312 (FR)

Application

EP 06755529 A 20060529

Priority

- FR 2006001210 W 20060529
- FR 0505422 A 20050530

Abstract (en)

[origin: FR2886185A1] The brazing of a folded tube for a heat exchanger consists of placing a first tube part (20) in contact with a contact surface of a second tube part (22) and brazing the two tube parts at the level of the contact zone using a brazing deposit and a brazing flux to form the brazed liaison. The brazing flux (32) is applied on the contact surface of the second tube part, prior to the brazing operation, in controlled conditions at a distance close to the contact zone. An independent claim is also included for a heat exchanger tube assembled by this method.

IPC 8 full level

B23K 1/00 (2006.01); **B23K 1/20** (2006.01); **B23K 35/02** (2006.01); **B23K 35/36** (2006.01); **F28D 1/03** (2006.01)

CPC (source: EP US)

B23K 1/0012 (2013.01 - EP US); **B23K 1/203** (2013.01 - EP US); **B23K 35/025** (2013.01 - EP US); **B23K 35/3611** (2013.01 - EP US); **F28D 1/0391** (2013.01 - EP US); **B23K 2101/10** (2018.07 - EP US); **B23K 2101/14** (2018.07 - EP US); **Y10T 29/49391** (2015.01 - EP US)

Citation (search report)

See references of WO 2007010099A1

Designated contracting state (EPC)

AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HU IE IS IT LI LT LU LV MC NL PL PT RO SE SI SK TR

DOCDB simple family (publication)

FR 2886185 A1 20061201; **FR 2886185 B1 20090102**; CN 101227997 A 20080723; EP 1896213 A1 20080312; JP 2008545944 A 20081218; US 2009126921 A1 20090521; WO 2007010099 A1 20070125

DOCDB simple family (application)

FR 0505422 A 20050530; CN 200680027255 A 20060529; EP 06755529 A 20060529; FR 2006001210 W 20060529; JP 2008514143 A 20060529; US 91583506 A 20060529