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VACUUM BRAZING TECHNOLOGY

ADVANTAGES OVER CAB BRAZING

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COMPARISON OF BRAZING PROCESSES

PLATE BAR COOLER

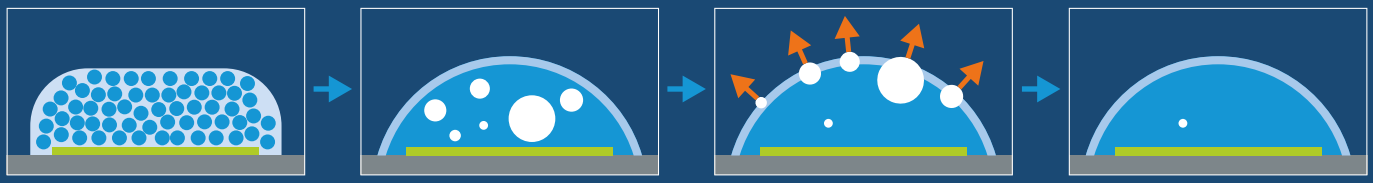
VACUUM BRAZING TECHNOLOGY	CAB BRAZING PROCESS
Atmosphere in the brazing furnace	
• Vacuum 10^{-5}mbar – 10^{-6}mbar • No oxygen → no oxide layer	• No vacuum • Protective gas / oxygen mix → oxide layer
Solder connections	
• No corroded soldered seams • Outgassed soldered seams	• Corrosion of the soldered seams • Flux residues and cavities
Reliability	
• Long service life • High pressure stability	• Shorter service life • Strength of the soldered seams reduced

VACUUM BRAZING TECHNOLOGY	CAB BRAZING PROCESS
Weldability	
• TIG / WIG weldable • Easy to weld with no preparatory work	• TIG / WIG weldable after mechanical processing
Appearance	
• No flux residue • Glossy aluminium colour	• Matt surface from the oxide layer
Flux residues	
• None, as the process is flux-free	• Fluorine and crystalline residues in the cooling circuit cause clogging of the cooling channels or failure of the coolant pump

Contamination / residues during the CAB brazing process

BRAZING PROCESS WITH AND WITHOUT VACUUM

VACUUM BRAZING TECHNOLOGY



CAB BRAZING PROCESS