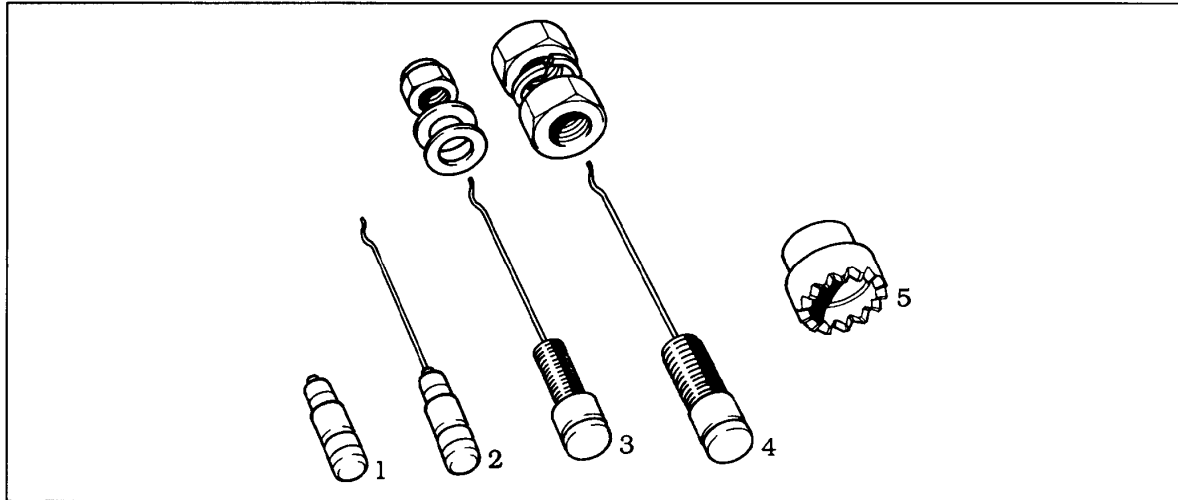




Brazing pins & ferrules

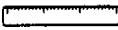



The working temperature of the brazing solder in the brazing pins is 630-660°C, unless the description is initialled 'CP', which indicates working temperature of 610-630°C. All are in line with the classification of the operation as hard soldering. A new ferrule must always be employed in pin brazing (the ferrule must be changed after each brazing operation). The purpose of the ferrule is to prevent spattering of the molten solder, to prevent oxidation of the molten solder, and to protect the operator against radiation from the arc. The ferrule must be stored dry.

Fig.	#	Description			Remarks
2	270 075 1210	Brazing pin, standard F	Ø 8 mm	100	With fuse wire
2	278 190 3250	Brazing pin, CP F	Æ 8 mm	100	With fuse wire
2	270 083 3520	Brazing pin, extra solder B	Ø 8 mm	100	With fuse wire
1	278 190 4320	Brazing pin, standard F	Ø 8 mm	100	Without fuse wire
1	278 190 3240	Brazing Pin, CP F	Æ 8 mm	100	Without fuse wire
1	278 190 4360	Brazing pin, extra solder B	Ø 8 mm	100	Without fuse wire
5	270 065 7230	Ferrule	Ø 8 mm	200	
2	270 075 1630	Brazing pin G	Ø 9,5 mm	100	With fuse wire
1	278 190 4350	Brazing pin G	Ø 9,5 mm	100	Without fuse wire
5	270 065 7240	Ferrule	Ø 9,5 mm	150	

We reserve the right to make technical changes

CORROSION CONTROL

Fig.	#	Description			Remarks
3	278 190 0430	Threaded brazing pin F	M8/12 x 30 mm	50	With fuse wire
	278 190 4920	Threaded brazing pin F	M8/12 x 30 mm	50	Without fuse wire
	278 190 3450	Threaded brazing pin F	M10 x 34 mm	40	With fuse wire
	278 190 4980	Threaded brazing pin F	M10 x 34 mm	50	Without fuse wire
4	278 190 1880	Threaded brazing pin F	M12 x 34 mm	25	With fuse wire
	278 190 4930	Threaded brazing pin F	M12 x 34 mm	25	Without fuse wire
5	270 077 3680	Ferrule	∅ 12 mm	100	

**F = 278 190 3250; 278 190 3240; 270 075 1210; 278 190 4320; 278 190 0430; 278 190 4920;
278 190 1880; 278 190 4930**

B = 270 083 3520 alt. 278 190 4360 alt 278 190 3240, 278 190 3250

G = 270 075 1630alt. 278 190 4350

We reserve the right to make technical changes.