



**WORK INSTRUCTION**

**BRAZING PROCESS**

REVISION: 00

PROCEDURE NO.: WI-8.2.4.18

DATE EFFECTIVE: 04/15/09

SEQUENCE*	OPERATION DESCRIPTION
1	Verify material/heater part number with visual or dimensional inspection on the first piece followed by a random sample basis.
2	Visually inspect material/brazing area for damage.
3	Clean and prepare materials as needed.
4	Prepare flux as needed.
5	Adjust valves on oxygen and acetylene tanks.
6	Attach appropriate torch nozzle.
7	Ignite torch and adjust gas flow to achieve appropriate flame.
8	Setup brazing workbench as required.
9	Apply flux to the materials as needed.
10	Heat materials using torch.
11	Apply solder to required areas.
12	Remove excess flux.
13	Clean heater/materials after brazing as needed.

\*Sequence may vary based on requirements for individual jobs.



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REVISION HISTORY

REVISION	DATE OF	SECTIONS	DESCRIPTION OF CHANGE
00	04/15/09	All	Initial release

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Design Engineer	Ryan Lott	<i>Ryan M Lott</i>
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