

## **CoreMax Seat Brazing**

### **Description: Recommended seat brazing technique**

#### **1. Recommended brazing practices:**

Braze the CoreMax seat into the system using good brazing practices. It is important to keep material out of the inside of the seat so the seal ability and flow rates are not affected. **Braze using a nitrogen purge to minimize oxidation.**

This is especially important on POE oil systems. A vapor (liquid) flux can be used to introduce the flux directly into the acetylene, allowing the braze technician the ability to work more expediently and cleanly. Visually inspect the seat for contaminants before moving to next station.

A 5%-15% silver content braze alloy has been found to work best, although some customers do use a 2% silver alloy with no issues.

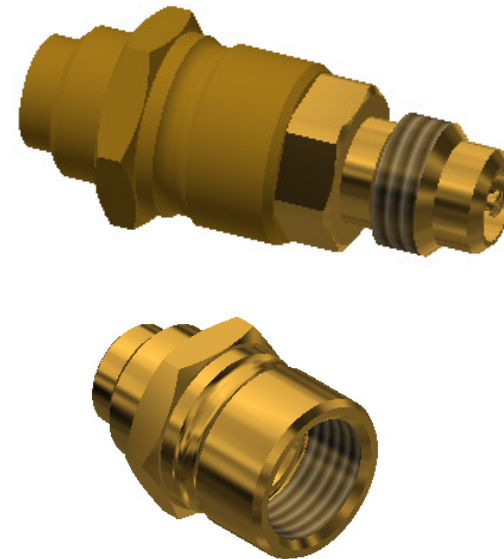
Another flux method that has been shown to work well are brazing rods that contain flux. Flux rods work well to evenly distribute flux to create a uniform braze. On POE oil systems, flush system with dry nitrogen vapor once sealed from atmosphere.

#### **2. Page 2 image description:**

On the following page there is images of CoreMax-seats that have been brazed.

The top row shows images of CoreMax seats that are acceptable post brazing.

The bottom row shows examples of seats that have been poorly brazed with large amounts of scale and porosity in the internal sealing areas. These are not acceptable, and will most likely cause leakage after the CoreMax valve is installed.



These images are recommendations only:



**BEST**



**BETTER**



**GOOD**



**OK/MARGINAL**

**This Group Is Not Acceptable**

