

CÓMO SOLDAR COBRE

PASO	VISUALIZACIÓN	PROCEDIMIENTO Y OBSERVACIONES
1. Medición		- Medir exactamente la longitud del tubo, ya que éste debe llegar hasta el fondo del casquillo de la conexión. - Medidas demasiado cortas o largas deterioran la calidad de la junta.
2. Corte		- Cortar el tubo en ángulo recto y a la longitud medida. - Puede emplearse un cortador de tubos de tipo disco, una sierra para metales, una rueda abrasiva o una sierra de banda portátil o estacionaria. - Evitar que el tubo se deforme al cortarlo.
3. Escariado y limpieza		- Escariar todos los diámetros interiores de los extremos del tubo cortado para eliminar las rebabas creadas durante el corte. Así se logra una superficie lisa para un mejor flujo. - Lijar suavemente los extremos del tubo y los casquillos de unión con papel abrasivo. - El lijado excesivo producirá un encastre defectuoso de las piezas y una junta de mala calidad, por lo que debe evitarse.
4. Aplicación del fundente y ensamble		- El fundente elimina los residuos de óxido, facilita el flujo y evita que las superficies a soldar se oxiden durante el calentamiento. - Aplicar con pincel una capa delgada y uniforme del fundente al tubo y al casquillo. - No aplicar con los dedos ni utilizar grandes cantidades, ya que el fundente es corrosivo. - Ensamblar las piezas a soldar.
5. Calentamiento		- Comenzar a calentar con el soplete, desplazando la llama en dirección perpendicular al tubo, luego el casquillo y finalmente entre el tubo y el casquillo. - No sobrecalentar, ya que se puede quemar el fundente quitándole su eficacia. - Mantener el soplete en la base del casquillo y tocar la junta con la varilla de aporte. Si esta derrite, se ha logrado la temperatura adecuada; si no, se debe seguir calentando.
6. Aplicación de la varilla de aporte		- Una vez lograda la temperatura adecuada, comenzar a soldar. - No utilizar exceso de metal: la cantidad correcta equivale a la circunferencia del tubo. - El metal fundido fluye hacia la junta por acción capilar sin importar si el flujo es hacia arriba, hacia abajo u horizontal. - La acción capilar es más eficaz cuando el espacio entre las superficies a soldar oscila entre 0,002 y 0,005 pulgadas.
7. Enfriamiento y limpieza		- Dejar enfriar. - Limpiar el excedente del fundente con un paño limpio y terminar de enfriar con un paño húmedo.
8. Comprobación		- Comprobar la eficacia de la junta mediante métodos normalizados para el servicio propuesto.

Manual En De Cobra

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Table of Contents Manual En De Cobra

1. Understanding the eBook Manual En De Cobra
 - The Rise of Digital Reading Manual En De Cobra
 - Advantages of eBooks Over Traditional Books
2. Identifying Manual En De Cobra
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Manual En De Cobra
 - User-Friendly Interface
4. Exploring eBook Recommendations from Manual En De Cobra
 - Personalized Recommendations
 - Manual En De Cobra User Reviews and Ratings
 - Manual En De Cobra and Bestseller Lists
5. Accessing Manual En De Cobra Free and Paid eBooks

- Manual En De Cobra Public Domain eBooks
- Manual En De Cobra eBook Subscription Services
- Manual En De Cobra Budget-Friendly Options
- 6. Navigating Manual En De Cobra eBook Formats
 - ePub, PDF, MOBI, and More
 - Manual En De Cobra Compatibility with Devices
 - Manual En De Cobra Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Manual En De Cobra
 - Highlighting and Note-Taking Manual En De Cobra
 - Interactive Elements Manual En De Cobra
- 8. Staying Engaged with Manual En De Cobra
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Manual En De Cobra
- 9. Balancing eBooks and Physical Books Manual En De Cobra
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Manual En De Cobra
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Manual En De Cobra
 - Setting Reading Goals Manual En De Cobra
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Manual En De Cobra
 - Fact-Checking eBook Content of Manual En De Cobra
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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