

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

José María Ceriani Cernadas



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