

Aluminum Brazing Skill Check Sheet

Name: _____

Points: 0

Max Points: 300

SAFETY & OTHERS			
ITEMS	OK	NG	Scores
1.1 Quality - No Leaks 30			
1.2 Quality - Proper Sequence Torch Operation 20			
2.1 Appearance (Inside) 60			
2.2 Appearance (Outside) 60			
3. Knowledge & Operation 84			
4. Time 26			
5.1 Safety - PPE & Torch 15			
5.2 Clean Up 5			

◆ **Pre-heating Check Point**

- 1) Heat adjustment
- 2) Flame length adjustment - 5 cm
- 3) Proper Distance - Flame not touching
- 4) Preheating occurred - light orange flame
(Heating inner pipe and outer pipe evenly at the same time)

◆ **Alloy Application Check Point**

- 5) Preheating occurred - light orange flame
- 6) Small amounts of alloy each pass
- 7) Proper Distance - Flame not touching

Decision: PASS

No More Than 2 Marks Per Joint Allowed By Judges

	Downward			Downward				
	1	2	3	4	5	6		
	Decision	Decision	Decision	Decision	Decision	Decision		
Pre-heating Check Point								
Heat adjustment - Excessively high or low	1	1	1	1	1	1		
Flame adjustment (5 cm) - Excessively long or short	2	2	2	2	2	2		
Flame distance - Only judge by sound - More than 2-times, starts over with each joint	3	3	3	3	3	3		
Did preheating occur - Judged by light orange flame color	4	4	4	4	4	4		
Alloy Application Check Point								
Did preheating occur - Judged by light orange flame color	5	5	5	5	5	5		
Small amount of alloy application at a time - alloy was not placed flat on the base material - 4047 - if alloy sticks - does brazer try to add more before melting current alloy into the joint	6	6	6	6	6	6		
Flame distance - Only judge by sound - More than 2-times, starts over with each joint	7	7	7	7	7	7		
	# of Pass	0	# of Pass	0	# of Pass	0	# of Pass	0
	Pass x 2	0	Pass x 2	0	Pass x 2	0	Pass x 2	0
Brazing Operation Evaluation Point		1	2	3	4	5	6	Total Score
		0	0	0	0	0	0	

