

Copper Brazing Skill Check Sheet

Name: _____

Points: 0

SAFETY & OTHERS			
ITEMS	OK	NG	Scores
1.1 Quality - No Leaks 30			-
1.2 Quality - Proper Sequence Torch Operation 20			-
2.1 Appearance (Inside) 90			
2.2 Appearance (Outside) 90			
3. Knowledge & Operation 144			0
4. Time 30			0
5.1 Safety - PPE & Torch 15			-
5.2 Clean Up 5			-

◆ **Pre-heating Check Point**

- 1) Heat adjustment
- 2) Flame length adjustment (40 ~ 50 mm)
- 3) Keep proper distance between white flame and pipe (2 ~ 3 mm)
- 4) Heating both pipes evenly
(Heating inner pipe and outer pipe evenly at the same time)

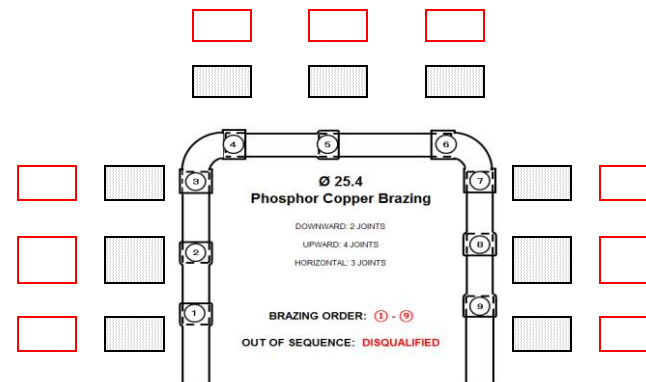
◆ **Alloy Application Check Point**

- 5) Heating up pipes to proper temperature for operation
- 6) Running small amount of alloy consistently
- 7) Keep proper distance between white flame and pipe (2 ~ 3 mm)
- 8) Running alloy by keeping proper temperature

Decision: PASS FAIL

No More Than 2 Marks Per Joint Allowed By Judges

	Downward		Upward	Horizontal			Upward			
	1	2	3	4	5	6	7	8	9	
	Decision	Decision	Decision	Decision	Decision	Decision	Decision	Decision	Decision	
Pre-heating Check Point										
Heat adjustment - Excessively high or low	1	1	1	1	1	1	1	1	1	1
Flame adjustment (5 cm) - Excessively long or short	2	2	2	2	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	3	3	3	3
Uniform pre-heating - Judge only on front side	4	4	4	4	4	4	4	4	4	4
Alloy Application Check Point										
Working temperature - can display some color variation - judge by whether the alloy melts or not - if not (points are deducted)	5	5	5	5	5	5	5	5	5	5
Small amount of alloy application with each pass - visual observation alone - not judged by length of alloy swipe	6	6	6	6	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	7	7	7	7
Working temperature control - excessive loss of color - judges discretion by visual check	8	8	8	8	8	8	8	8	8	8
	# of Pass	# of Pass	# of Pass	# of Pass	# of Pass	# of Pass	# of Pass	# of Pass	# of Pass	# of Pass
Brazing Operation Evaluation Point	Pass x 2	1	2	3	4	5	6	7	8	9
		0	0	0	0	0	0	0	0	0
										Total Score
										0



OUTSIDE INSIDE
0 + 0 = 0