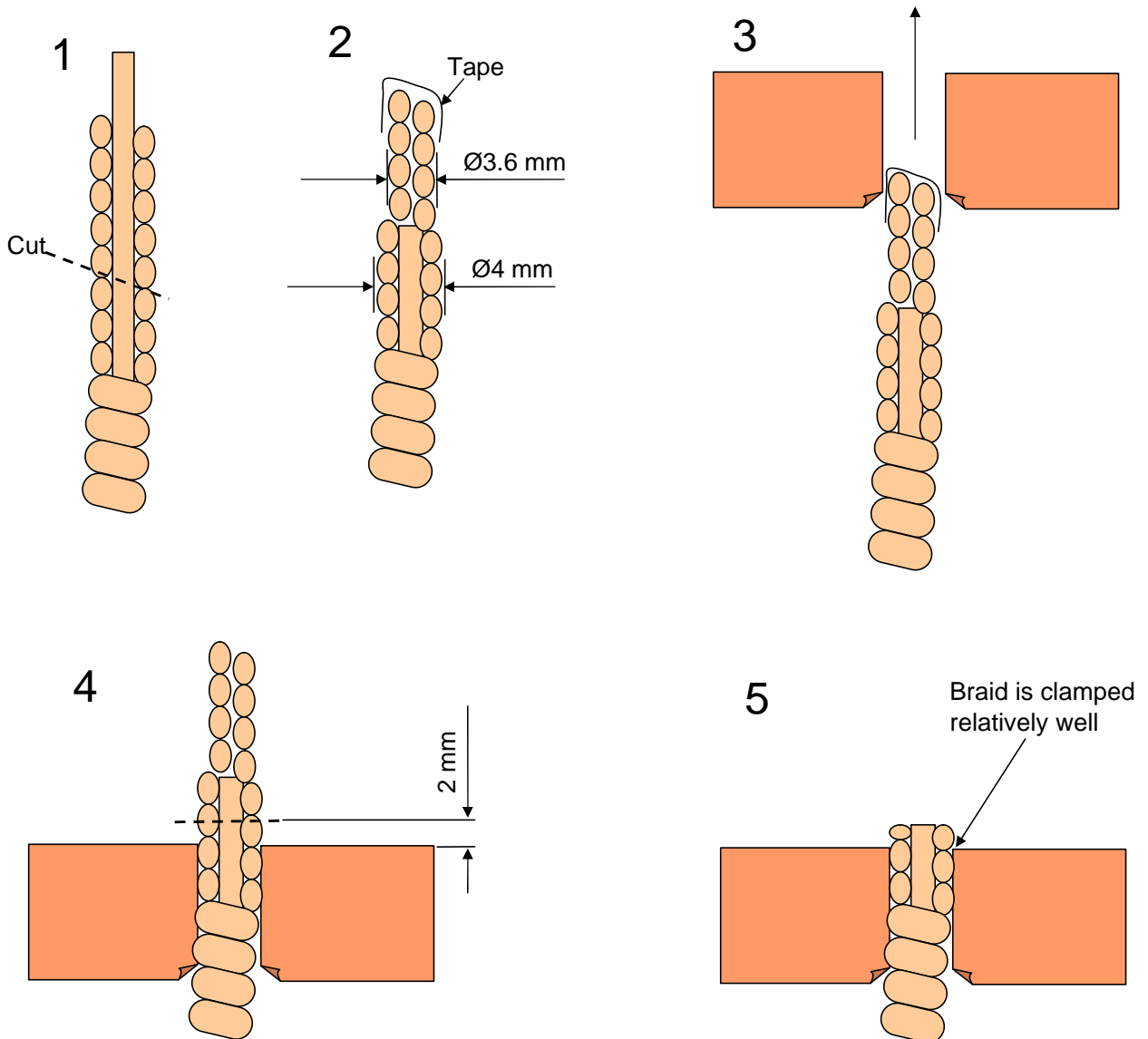
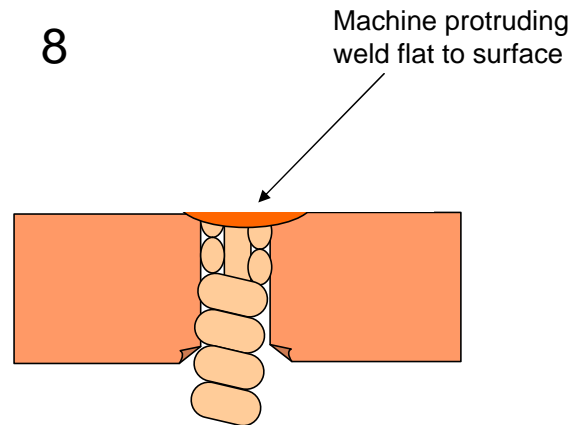
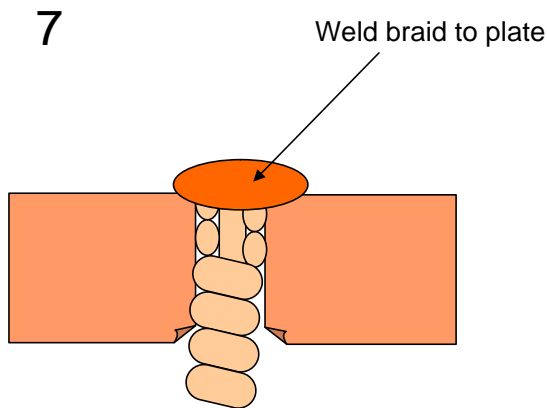
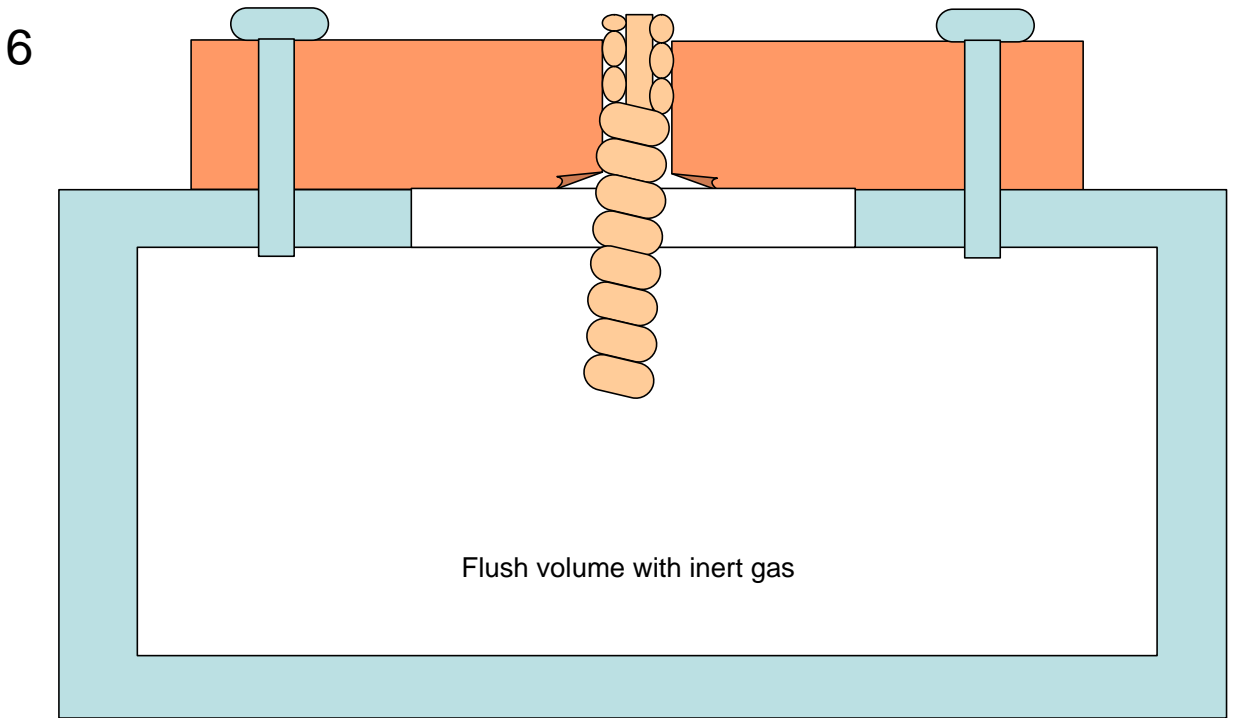


# Copper braid welding procedure ASR-0S-002



1. The braid is made with one central wire and six wires wind around it. Decoil the braid slightly and cut the central wire.
2. Recoil the wires to its original shape, so the braid obtains a smaller diameter at the tip. Stick a piece of tape tight around the tip
3. Pull the braid through the conical hole. Make sure that the hole edge is not cutting the braid. If so debur the sharp edges a bit more. Pull until the central wire is also completely through. This last pull with the central braid can go very difficult. This is normal.
4. Cut the braid circa 2 mm above the surface. The central wire is also cut in this procedure.
5. The braid to plate pre assembly is ready for welding. The braid maintains it position and can be forced a bit. If the braid falls out, modify the conical hole to a smaller diameter.

# Copper braid welding procedure ASR-0S-002



6. The plate with clamped braid(s) is screwed on top of a closed box. The copper plate can be larger than the final plate to make a gas tight connection to the box much easier. After the welding the plate is cut to the final dimensions. Flush the box with an inert welding gas (Argon, CO<sub>2</sub>, H<sub>2</sub>, etc)
7. Weld the braid to the plate using GTAW welding, under inert gas protection, Do not add material, if the material is not sufficient, cut the braid to a longer protrusion.
8. Machine the protruding weld flat to the surface. In the occasion that this surface is soldered to the pipes, no holes may be present. If so there is a risk of capillary filling of the braid with solder, or contamination of the braids with soldering flux.