

How To Sweat A Copper Pipe Instructions

Cut and dry fit the pieces – Plan ahead so ensure that you have all the parts and tools required for the job.

Safety: Please ensure that you have updated Material Safety and Data Sheets available for the chemicals used in this task. Ensure that you have a damp cloth to help handle material that may still be hot. Have a container of water placed under the soldering area to catch any falling solder. Have a fire extinguisher available if necessary.



Clean and prepare the parts:

- **Tubing Cutter:** This tool is a clamp like cutter that rotates around the pipe as you cut. Tighten the clamp on your cut line. Spin the cutter around the pipe a few times while tightening a little after each rotation. (Be careful not to tighten so much as to crush the pipe.) Repeat until the cut is complete. Use the reaming blade on the back of the tool to remove burrs on the inside of the cut pipe.

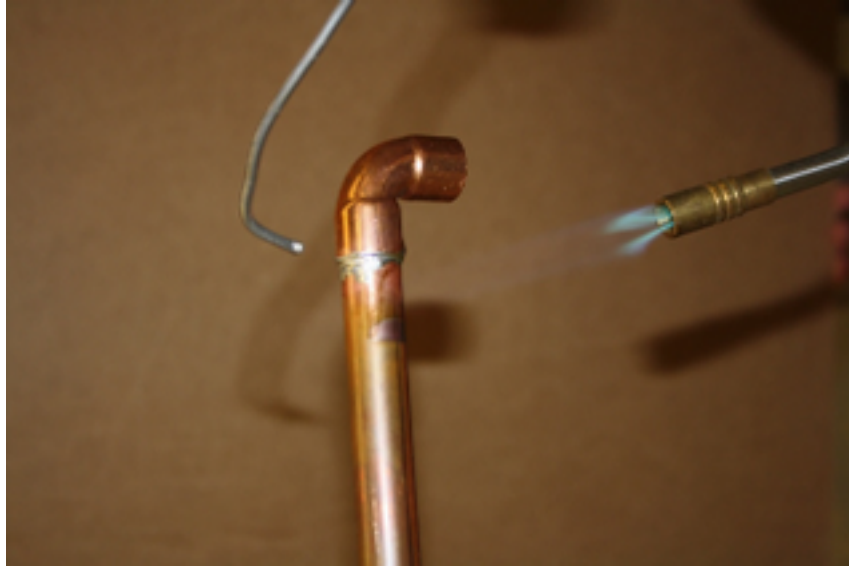


- Using plumbing sandpaper or wire cleaning tool, clean the ends of the copper pipe where it will be soldered until it is shiny and clean removing any grease, dirt and oxidation to provide a leak free joint.
- Using sandpaper or a wire brush, polish the inside of the fittings until it is shiny and clean removing any grease, dirt and oxidation.



- Dry fit all of the pieces together to ensure a proper fit.
- Using a brush, apply a coat of flux on all surfaces that will be soldered.





- Using the propane torch, heat the area where the straight pipe meets the fitting. Holding the point of the inner flame on the overlapping area for about 5-10 seconds. Pull a section of the solder out from the reel so that it has clearance from your hand. Touch the solder to the high point on the connecting joint between the fitting and the straight pipe. If the pipe is hot enough a capillary action will occur and pull the solder into the overlapping area and create a leak free joint.
- Allow the joint to cool for a couple of minutes. When you are sure the joint is cool enough to handle, use a damp cloth to clean off the pipe for a clean and finished look.