



Pin Brazing Equipment Data Sheet



Pin brazing for cathodic protection

When a cathodic protection system is applied to a pipe-line, cables need to be attached for continuity, connection of anodes, test leads etc. To attach the cable connection pin brazing can be used. Threaded brazing pins, with nuts, are used for pipes of ductile or cast-iron to which a lugged cable is fastened. For steel pipes, either threaded brazing pins, with nuts, are used or the cable is brazed directly onto the pipe by means of a special lug. The pinbrazing unit contains all the equipment and tools required to make safe cable connections.

Pinbrazing equipment is primarily designed for the occasional user who needs a simple, rugged and low cost machine. The unit is portable and easy to transport. The brazing process is controlled in by means of the fuse wire on the brazing pin. The battery capacity is sufficient for approximately 20 brazes with the smallest type of brazing pin and is normally recharged from a mains supply.

Unit Comprises

Description
EASYBOND Battery Unit
EASYBOND Brazing Gun
3 x Batteries
Battery Charger (240/110v supply)
Magnetic Earth Device

Optional Accessories

Description
Pin Holder M8
Ferrule Holder M8
Attaché Case
Grinder
Battery Charger (12V supply)

Fast and easy connection - Pin brazing of cables gives a safe and durable connection to a pipeline. The automated brazing takes only 1.5-2 seconds.

Speed of Installation - One minute per connection from start to finish with only 1.5 - 2 seconds for the braze itself.

Low Temperature - The low melting point of the braze material (650°) and short heating time keep thermal effects on the steel to a minimum thus ensuring no critical damage to the pipeline steel, particularly high strength steels.

All Weather - Wind, rain, and cold do not prevent the operator from working safely and effectively. Damp pipes pose no problem.

Safety - No special equipment or precautions are needed for pin brazing operators

Pipeline Maintenance Limited

Cathodic Protection Engineering and Materials Supply
 11 & 12 Merlin Park, Mildenhall,
 Suffolk, IP28 7RD, UK
 Tel: +44 (0) 1638 711955
 Fax: +44 (0) 1638 711953

Data Sheet WELD02 Rev 01
 Page No 1 of 2

email: sales@pipelinemaintenance.co.uk
 website: www.pipelinemaintenance.co.uk



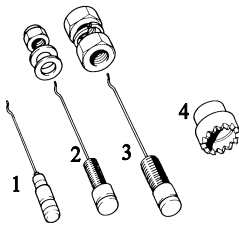
Easy to Use - The automated process means operators can be trained in less than one hour.

Versatile - The portable nature of the equipment means that connections can be made in almost any location above or below ground and even overhead.

Pinbrazing Consumables

A range of pinbrazing consumables is available to cover almost any application. The most common types which can be used with this system are shown below. A ceramic ferrule is required for each brazing pin.

Brazing Pins



Cable Lugs



Item	Description	Pack size
1	8mm Direct Brazing Pin	10 or 100
2	M8 Threaded Brazing Pin c/w S/Steel nylock nut and washer	10 or 100
3	M10 Threaded Brazing Pin c/w 2 brass nuts and lock washer	10 or 100
4	Ceramic Ferrule to suit 8mm direct brazing pin	200
5	Ceramic Ferrule to suit all threaded pins	100

Cable lugs for direct connection to pipe

Pin brazing cable lugs are specially designed to be pinbrazed directly to the base metal after the cable has been connected by crimping. Most common cable sizes are catered for in our range, other sizes are available on request.

Item	Description	Pack size
1	Cable lug for 4mm sq. cable	50
2	Cable lug for 10mm sq. cable	50
3	Cable lug for 16mm sq. cable	0

All the above cable lugs use 8mm Direct Brazing Pin and appropriate ceramic ferrule.

Pipeline Maintenance Limited

Cathodic Protection Engineering and Materials Supply
11 & 12 Merlin Park, Mildenhall,
Suffolk, IP28 7RD, UK

Tel: +44 (0) 1638 711955
Fax: +44 (0) 1638 711953

Data Sheet WELD02 Rev 01
Page No 2 of 2

email: sales@pipelinemaintenance.co.uk
website: www.pipelinemaintenance.co.uk

