HOMEOWNER REPAIR GUIDE

SOLDERING COPPER PIPE

TOOLS
Tape measure
Pipe cutter or hacksaw
Steel wool or fine sandpaper
Propane torch
Lead-free solder
Soldering paste (“flux”) and brush

COPPER PIPE COMES IN THREE WEIGHTS	
“K”	Thickest wall
“L”	Medium wall
“M”	Thinnest wall

PROCEDURE

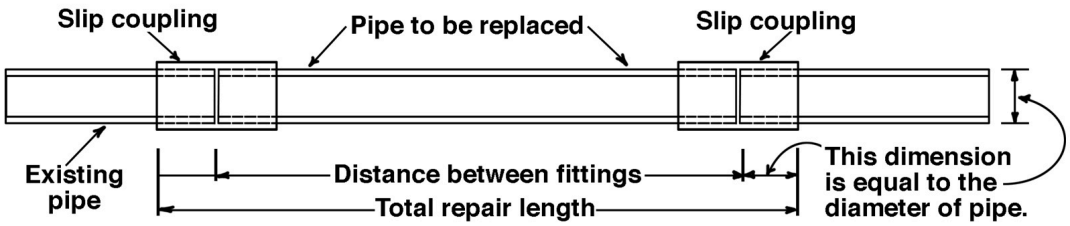
1. Cut pipe to length with pipe cutter.
2. Remove burrs on inside of pipe with scraper on pipe cutter.
3. Clean end of the pipe and inside surface of the fitting with steel wool or sandpaper.
4. Apply flux to both pieces to be joined (outside surface of the pipe and inside surface of the fitting).
5. Assemble the pieces and heat both pieces evenly with propane torch. Do not overheat; the most common mistake is overheating, not underheating.
6. Apply solder as soon as it will flow when touched to the pipe. (Solder melts at about 400°.) You’ll only need a piece of solder as long as twice the diameter of the pipe.
7. Don't move the joint for at least a minute.

IF THE JOINT LEAKS

If you have a leak after the water is on, drain the water from the line and reheat the joint to pull it apart; then, re-clean and start over. Don’t just reheat and add more solder – that's how you can “overcook” the fitting, when it may never solder properly. You’d then need to replace the fitting.

HOW TO MEASURE FOR CUTTING PIPE

1. Check diameter of pipe.
2. Measure the distance between ends of pipe fitting, and add twice the diameter of the pipe.



Total repair length = distance between fittings + twice the pipe diameter

Home Repair Resource Center empowers homeowners to maintain their homes for sustainable and diverse communities.

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