

Apprentice & Journeymen Training Trust Fund of the Southern California Plumbing & Piping Industry

A&J Braze Testing Prerequisites & Procedures

I. Small Bore Brazing

Members qualifying for 3/4" & 1-1/2" brazing certifications can walk into any A&J facility during posted walk-in brazing & welding hours only with the exception of training centers with appointment requirements listed in their hours.

Appointments can be made by phone only at (310) 604-0892.

II. Practice

Walk-in brazing practice is available to all members for 3/4" through 1-1/2" only. Practice on 2" will be approved for members with a current BTS15 or UA 51 certification.

III. Big Bore Brazing

Members qualifying for 2" through 8" big bore brazing certifications must make an appointment by phone only at (310) 604-0892.

Members without a Local Union or DC16 contractor referral must follow the listed progression of prerequisites per braze certification.

A tandem braze is required for 4" – 8" big bore testing. Brazers providing back-up heat must also have required prerequisites. An A&J CWI can provide back-up heat if needed when availability permits.

Tests will take place at a designated training center on specific testing days only.

IV. Big Bore Emergency Referrals

Members in need of brazing certification without holding required prerequisites must have a DC16 contractor or Local Union referral. Local Unions and contractors referring a member can do so by contacting an A&J Training Coordinator.

Referred members who fail on their first attempt will be required to go through the full progression of prerequisite certifications before making another attempt at a big bore certification.

V. Testing Procedures and Prerequisites

**3/4" - BTS34 (Medical Gas Braze) / UA-50 (Non-Medical Gas Braze)
or R78 (7/8" OD Refrigerant Braze)**

Prerequisite: NONE

Testing:

The horizontal progression test coupon will be completed first followed by the vertical test coupon.

Both horizontal and vertical test coupons must be sent to the certifying agency together. No exceptions.

BTS34 Certifying Range: Type L Copper Tube: 1/4"– 1" / Type K Copper Tube: 1/4"– 1"

1-1/2" - BTS15 (Medical Gas Braze) / UA-51 (Non-Medical Gas Braze)

Prerequisite: NONE

Testing:

The horizontal progression test coupon will be completed first followed by the vertical test coupon.

Both horizontal and vertical test coupons must be sent to the certifying agency together. No exceptions.

BTS15 Certifying Range: Type L Copper Tube: 5/8" – 2" / Type K Copper Tube: 5/8" – 2"

2" - BTS2 (Large Bore Medical Gas Braze)

Prerequisite: Current BTS15 medical gas brazing certification listed on file.

Testing:

The horizontal progression test coupon will be completed first followed by the vertical test coupon.

Both horizontal and vertical test coupons must be sent to the certifying agency together. No exceptions.

BTS2 Certifying Range: Type L Copper Tube: 1" – 3" / Type K Copper Tube: 1" – 3"

4" – BTS4 (Large Bore Medical Gas Braze)

Prerequisite: Current BTS2 brazing certification listed on file.

Testing:

The testing appointment should consist of 2 brazers per session, to perform 2 separate tests. The second brazer will be required to provide backup heat for the other member brazing coupons in tandem.

The horizontal progression test coupon will be completed first followed by the vertical test coupon.

Both horizontal and vertical test coupons must be sent to the certifying agency together. No exceptions.

BTS4 Certifying Range: Type L Copper Tube: 2" – 5" / Type K Copper Tube: 2" – 5"

6" – BTS6 (Large Bore Medical Gas Braze)

Prerequisite: Current BTS4 brazing certification listed on file.

Testing:

The testing appointment should consist of 2 brazers per session, to perform 2 separate tests. The second brazer will be required to provide backup heat for the other member brazing coupons in tandem.

The horizontal progression test coupon will be completed first followed by the vertical test coupon.

Both horizontal and vertical test coupons must be sent to the certifying agency together. No exceptions.

BTS6 Certifying Range: Type L Copper Tube: 2-1/2" – 6" / Type K Copper Tube: 2-1/2" – 6"

8" – BTS8 (Large Bore Medical Gas Braze)

Prerequisite: Current BTS6 brazing certification listed on file.

Testing:

The testing appointment should consist of 2 brazers per session, to perform 2 separate tests. The second brazer will be required to provide backup heat for the other member brazing coupons in tandem.

The horizontal progression test coupon will be completed first followed by the vertical test coupon.

Both horizontal and vertical test coupons must be sent to the certifying agency together. No exceptions.

BTS8 Certifying Range: Type L Copper Tube: 2-1/2" – 8" / Type K Copper Tube: 2-1/2" – 8"