

ABSTRACT

A pipe (40) having a specific length is filled with nitrogen gas (4a). From opening ends of connecting portions (42, 42) located at both ends of the pipe (40), cross-sectionally hat-shaped block plugs (50) made of brazing filler metal are press-fitted into respective connecting portions (42, 42) and are mounted thereon for the purpose of sealing the pipe (40). Next, one end of a connecting piece (60) is inserted into the connecting portion (42) of one pipe (40) so as to break the block plug (50) mounted thereon. The other end of the connecting piece (60) is also inserted into the connecting portion (42) of another pipe (40) so as to break the block plug (50) mounted thereon. Thereafter, the block plugs (50) are melt so that the connecting portions (42) of both the pipes (40) are brazed with the connecting piece (60).