

# Induction Brazing Carbide Tips

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering, induction melting and induction surface treatment applications  
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**Objective** Attaching carbide cutters to a steel meat cutter impeller

**Material** carbide blocks; steel shank fitting

**Temperature** 1400 °F (760 °C)

**Frequency** 219 kHz

**Equipment** Power of 30kW induction heating systems including:

Induction heating coil

**Workhead:** two-cap 1.0μF (Total 0.5 μF)

**Process** The entire part is placed in a five-turn helical coil, the power is applied until the part is heated to the required temperature and a uniform heat pattern is achieved. The coil allows for easy fixturing and uniformity of heating between the carbide and the steel shank for a premium braze joint.

**Results/Benefits** Precision: Due to the size of the induction coil, the process allows for precise placement of the carbides on the steel shanks

**Economy:** Power is consumed only during the heat cycle **Repeatability:** joint quality is maintained in this repeatable process



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