Brazing Carbide Tips to a Meat Cutter

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 Ambrell 20 kW 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