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