

# Induction Brazing carbide teeth to steel pipe

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** Brazing carbide teeth to a steel jaw in less than 5 minutes

**Material** Steel pipe jaw, 0.5" (12.7mm) dia, 1.25" (31.75mm) long, 0.25" (6.35mm) thick carbide teeth, black flux and silver copper braze shims

**Temperature** 1292°F (700°C)

**Frequency** 257kHz

**Equipment** • Power of 6 kW induction heating system, equipped with a remote workhead containing one 0.66µF capacitor

- An induction heating coil designed and developed specifically for this application.

Process A two turn rectangular helical coil is used to heat the carbide and steel to 1292°F (700°C) for 4 to 5 minutes. Three braze shims control the amount of braze and the even heat allows for a good flow of braze creating an aesthetically pleasing bond.

**Results/Benefits** Induction heating provides:

- Hands-free heating that involves no operator skill for manufacturing
- Consistent, repeatable aesthetically pleasing brazes
- Even distribution of heating

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