

Table of contents

Preface

List of some abbreviations

1	Introduction	1
1.1	History	1
1.2	Special characteristics of the electron beam welding processes	3
1.3	Other beam welding processes	4
2	Generation of the electron beam	6
2.1	Free electrons	6
2.2	Cathode	7
2.3	Anode	8
2.4	Bias cup	9
2.5	Space charge effects	12
2.6	Focussing lens	13
3	Shaping and deflecting the electron beam	15
3.1	Static shaping and deflecting	15
3.1.1	Centring	15
3.1.2	Astigmatism correction	16
3.1.3	Deflecting	17
3.2	Dynamic deflecting	18
3.2.1	General	18
3.2.2	Oscillation	20
3.2.3	Vectorising	20
3.2.4	Focus oscillation	21
4	Electron beam characteristics	22
4.1	General	22
4.2	Aperture angle and caustic	22
4.3	Arata beam test	23
4.4	Power density distribution	24
4.5	Beam parameter product	27
5	Behaviour of the electron beam on penetrating metals	29
5.1	General	29
5.2	Processes at the metal surface	29
5.3	Deep penetration welding effect	30
5.4	Consequences for the welding process	33
6	Welding parameters and advice on welding practice	34
6.1	General	34
6.2	Accelerating voltage	35
6.3	Beam current	35
6.4	Lens current and focus position	37
6.5	Welding speed	38
6.6	Beam oscillation	39
6.7	Beam pulsing	41

6.8	Welding in forced positions	42
6.9	Working pressure	43
6.9.1	Welding in vacuum	43
6.9.2	Welding in atmosphere	44
6.10	Parameter optimisation	45
7	Beam and equipment control	49
7.1	General	49
7.2	Light and electron optical viewing systems	49
7.3	Automatic beam adjustment	50
7.3.1	Automatic centring	50
7.3.2	Automatic astigmatism correction	51
7.3.3	Automatic focussing	52
7.4	Seam tracking systems	53
7.4.1	General	53
7.4.2	Teach and play-back procedures	55
7.4.3	Lag distance compensation	55
7.4.4	Welding with online and offline seam tracking	56
7.5	Welding with a multiple spot beam	56
7.6	Heating current control	57
7.7	Beam current control	58
7.8	Slope control	59
7.9	Vacuum pump control	61
7.10	Complete control systems	61
7.10.1	General	61
7.10.2	PLC control	61
7.10.3	CNC control	63
8	The weldability of metallic materials	65
8.1	General	65
8.2	Process related effects	65
8.2.1	Melting and vapour phase	65
8.2.2	Solidification phase	65
8.2.3	Influence of the vacuum	67
8.2.4	Heat affected zones	68
8.2.5	Residual stresses due to welding	68
8.3	Material-related influences	70
8.3.1	Steel and iron	70
8.3.2	Aluminium and magnesium materials	77
8.3.3	Copper materials	79
8.3.4	Nickel and cobalt materials	79
8.3.5	Titanium materials	80
8.3.6	Special metals	81
8.3.7	Metal combinations	81
8.3.8	Material-related beam deflections	85
8.4	Strengths and corrosion properties	86
8.5	Weldability –classification and overview	87
8.5.1	Classification of weldability	87
8.5.2	Weldability of different metals	87

9	Workpiece preparation	89
9.1	General	89
9.2	Basic joint types	91
9.2.1	Butt joints	91
9.2.2	Fillet joints, T-joints and other joint configurations	93
9.2.3	Characteristics of circular welds	96
9.3	Different workpiece thicknesses	99
9.4	Fusion face preparation	100
9.5	Seam control lines	100
9.6	Seam beginning and end	101
9.7	Vent holes	102
9.8	Welding with difficult joint access	102
9.9	Workpiece and joint groove cleaning	103
9.10	Welding jigs and fixtures	104
9.11	Dimensions of working chambers, workpiece and beam gun motion	105
10	Welding equipment and facilities	108
10.1	Equipment basic design	108
10.2	High voltage supply	109
10.3	Beam gun	111
10.4	Working chamber	113
10.5	Motion devices	114
10.6	Vacuum equipment	117
10.6.1	General	117
10.6.2	Physical principles	117
10.6.3	Vacuum pumps	118
10.6.4	Measurement instruments	125
10.6.5	Construction and operation of vacuum facilities	125
10.6.6	Evacuation time	128
10.7	Examples of other welding equipment	128
10.7.1	Cycle equipment	128
10.7.2	Multi-chamber welding equipment	130
10.7.3	Continuous flow equipment	132
10.7.4	Atmosphere welding equipment	133
10.8	Welding equipment installation	135
10.8.1	General	135
10.8.2	Special measures to be taken for worker health and safety	135
11	Examples of welded components	136
11.1	Aerospace	136
11.2	Automotive and gear manufacturing	141
11.3	Railway technology	144
11.4	Equipment manufacture	145
11.5	Electrical engineering	149
12	Testing of weld seams	150
12.1	General	150
12.2	Non-destructive testing	150
12.2.1	Visual testing	150
12.2.2	X-ray testing	150
12.2.3	Ultrasonic testing	150

12.2.4	Penetration testing	150
12.2.5	Magnetic particle testing	151
12.2.6	Eddy current testing	151
12.3	Destructive testing	151
12.3.1	Tensile testing	151
12.3.2	Bend testing	152
12.3.3	Notch impact testing	152
12.3.4	Metallographic testing	152
12.3.5	Hardness testing	152
13	Evaluation of weld imperfections	154
13.1	General	154
13.2	Quality levels	154
13.3	Pores, shrinkage cavities and cracks	155
13.4	Lack of fusion and incomplete weld penetration	156
13.5	Undercuts and edge misalignments	157
13.6	Weld bead imperfections	157
13.7	Fillet welds	158
13.8	Weld spatter and metal vapour sublimate	158
14	Acceptance inspection of welding equipment	159
14.1	General	159
14.2	Testing of X-ray protection	161
14.3	Measurement of electrical and mechanical characteristics	162
14.3.1	Accelerating voltage	162
14.3.2	Beam current	164
14.3.3	Lens current	164
14.3.4	Welding speed	165
14.4	Measurement of mechanical engineering characteristics	166
14.4.1	Run-out accuracy	166
14.4.2	Stability of spot position	167
14.4.3	Working pressure rise rate	168
14.5	Wedge shaped test specimen	168
15	Qualification testing of operators and setters	170
15.1	General	170
15.2	Test procedures	170
15.3	Test certificate	171
16	Welding procedure specification	173
17	Welding procedure qualification	175
17.1	General	175
17.2	Qualification of welding procedure specification	176
17.3	Tests	176
17.4	Scope and period of validity	177
18	Quality assurance	179
18.1	General	179
18.2	Quality-determining factors	179
18.3	Regulation, control and monitoring systems	180
18.4	Documentation	181

19	Cost calculation and profitability	183
19.1	General	183
19.2	Cost savings before and after welding	183
19.3	Cost categories	184
19.3.1	Calculation of machine hour rate	184
19.3.2	Calculation of production cost rate	186
19.4	Automation	186
19.5	Job welding	187
20	Further thermal electron beam processes for metal machining	189
20.1	General	189
20.2	Material removal processes	189
20.2.1	Electron beam drilling	189
20.2.2	Electron beam engraving and profiling	192
20.3	Electron beam surface treatments	193
20.3.1	Solid phase processes	193
20.3.2	Liquid phase processes	196
20.4	Additive material processes	198
20.4.1	General	198
20.4.2	Base material: Powder	199
20.4.3	Base material: Wire	200
21	Standards and rules of electron beam welding	202
21.1	Standards	202
21.2	Technical Codes and Bulletins of DVS	203
21.3	Other rules	203
22	References	204
23	Keyword index	212
24	Figure credits	216