

# Content

<b>1</b>	
<b>Plea for a process which has remained young</b> .....	8
A telephone call - The “tip of an iceberg” .....	8
The handicap of the “early birth” .....	10
Become curious? .....	11
Literature (a few examples, for going into the details - later on) .....	12

<b>2</b>	
<b>Changing lanes at 150,000 km/s – Generation and manipulation of an electron beam</b> .....	13
Where do the electrons come from? .....	13
Yes, where are they flying then? .....	16
Speed is no magic .....	18
Jumping procession and video transmission .....	19
Against the “horror vacui” .....	21
Absolutely no need to be frightened! .....	22
Literature .....	23

<b>3</b>	
<b>Through thick and thin: Electron beam welding – Processes and technologies</b> .....	26
The deep welding effect .....	26
Weld preparation and joint geometries .....	31
Joining of material combinations .....	33
Shielding gas – Why that then? .....	35
Kaleidoscope of EB-welded parts .....	35
Literature .....	37

<b>4</b>	
<b>Always the same but different every time</b> .....	38
Machines and installations for electron beam technologies .....	38
No EB machines “off the peg” .....	38

Fundamental types of EB machines .....	41
Bone of contention: Evacuation .....	43
Yes, and the costs? .....	45
“Stand alone” or interlinked .....	46
Quite particular executions - No “exotic items” .....	47
Conclusion .....	50
Literature .....	51

<b>5</b>	
<b>The electron beam as a jack of all trades – Local surface modification, generative fabrication and masses of boreholes</b> .....	52
SM – More than cosmetics .....	52
Surface hardening of steel components .....	53
“Refinement” of surfaces .....	57
Generation of structures .....	58
Holes without drilling – Above all, a lot of holes .....	60
Conclusion .....	63
Literature .....	63

<b>6</b>	
<b>Come out, beam! – Nonvac EBW: Electron beam welding in a free atmosphere</b> .....	64
Vacuum or nonvacuum, that is the question .....	64
Wide tolerances and high velocities .....	67
Who needs it then? .....	68
Diversity of installations also in the case of nonvac EB welding .....	71
Conclusion .....	74
Literature .....	75

<b>7</b>	
<b>Final appeal</b> .....	76