

ISO/TR 17671-7:2004-06 (E)

Welding - Recommendations for welding of metallic materials - Part 7: Electron beam welding

Contents	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Quality requirements	7
5 Storage and handling of parent metals and consumables	7
6 Welding facilities	7
7 Qualification of the welding personnel	8
8 Welding procedure specification	8
9 Welding procedure test	9
10 Joint preparation	9
10.1 Machining	9
10.2 Demagnetisation	9
10.3 Cleaning	10
10.4 Assembly	10
11 Joint design	10
11.1 Longitudinal seams	10
11.2 Circular seams	11
12 Evacuation holes	12
13 Tack welds, cosmetic passes	13
14 Thermal pre- and post heat treatment	13
15 Documentation	13
Annex A (informative) Information about weldability of metallic materials	14
Annex B (informative) Summary of electron beam weldability of metals with reference to Annex C (informative) Information about causes of weld imperfections and prevention	25
Annex D (informative) Examples of preparation of circular joints	27
Bibliography	34