

AEROSPACE STANDARD

SAE AS7110/3

REV.
C

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Superseding AS7110/3B

Nadcap Requirements for Electron Beam Welding

1. SCOPE:

This Aerospace Standard (AS) is to be used to supplement AS7110. In addition to the requirements contained in AS7110, the requirements contained herein shall apply to suppliers seeking Nadcap accreditation for electron beam welding.

2. REFERENCES:

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AS7110 Nadcap - Requirements for Welding/Brazing

3. REFERENCE REQUIREMENTS:

3.1 Applicable customer specifications shall be available at the facility.

4. MATERIALS/MATERIAL CONTROL:

4.1 Base materials shall be as specified in applicable part drawings.

4.2 When required, filler metals shall be as specified on part drawings or customer specifications.

4.2.1 There shall be procedures for the control and identification of filler metals, when used.

4.2.2 Procedures shall address the disposal of filler metals that have lost their identification or traceability to certifications.

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- 4.3 Cleaning materials, chemical solvents, or etching solutions shall be as specified on part drawings or certified/qualified welding procedures/schedules.
- 4.4 Unless otherwise approved by procedure certification or specification, all back-up materials used to absorb residual electron beam energy shall be the same alloy type as the part being welded.
- 5. EQUIPMENT CONTROL:
 - 5.1 The electron beam (EB) equipment shall be capable of meeting customer specifications.
 - 5.2 Equipment shall be qualified in accordance with applicable customer specifications if required.
 - 5.3 All holding fixtures shall be capable of maintaining the desired configuration and tolerances during welding, providing back-up as required, and allowing the required work space between the workpiece and the gun.
 - 5.4 Magnetic materials and tooling, prior to welding, shall be degaussed to a level established by procedure certification.
 - 5.5 When required, equipment shall be calibrated and controlled.
- 6. QUALIFICATION OF PROCEDURE/SCHEDULE:
 - 6.1 Weld procedures/schedules shall:
 - a. Identify those parameters specified by appropriate customer specifications
 - b. Be qualified in accordance with applicable customer specifications prior to production welding
 - c. Be requalified after failed test welds
 - d. Be requalified when a change is made in essential parameters
- 7. PROCESS CONTROL:
 - 7.1 Preparation:
 - 7.1.1 Joints shall be prepared in accordance with applicable specifications, drawings, or work instructions.
 - 7.1.2 Edges shall be machined and parallel to each other to assure proper fit-up.

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- 7.1.3 Joints shall be deburred after machining without rounding off the edges.
- 7.1.4 When specified, witness lines or features shall be applied in accordance with part drawings.
- 7.1.5 When run-on/run-off tabs are used, they shall be the same alloy as the part being welded.
- 7.1.6 When run-on/run-off tabs are used, they shall be removed after welding in such a manner as to prevent damage.
- 7.1.7 Surfaces of parts to be welded shall be prepared using chemical and/or mechanical cleaning or combinations thereof as applicable in accordance with customer requirements to the alloy being welded.
 - a. Welding shall commence within customer specified time limits.
 - b. After surface preparation, parts shall be handled in the joint area with clean, lint-free gloves and covered or otherwise protected to prevent contamination.
- 7.1.8 Jigs, fixtures, and measuring devices shall be free of scale, grease, protective coatings, oxides, dust, oil, and other foreign matter detrimental to the welding process.
- 7.1.9 Gaps for production welds shall be equal to or less than those used for procedure/schedule certification.
- 7.1.10 When required, process control tests shall be performed per customer requirements (coupons/part cut-up).
- 7.1.11 A means to verify joint to beam tracking prior to and during welding shall be established, when required.
- 7.2 Production Welding:
 - 7.2.1 EB welding shall be performed in a vacuum level that meets customer requirements.
 - 7.2.2 For each arc-out, the location and reason (if known) shall be recorded, when required by customer.
 - 7.2.3 Tack welding of details shall be accomplished by EB welding, unless alternate process is permitted by the customer.
 - 7.2.4 When tack welding is permitted and performed using a process other than electron beam, the tack personnel shall be qualified in accordance with customer requirements.

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7.2.5 Tack welds shall be totally consumed by the finished weld.

7.2.6 Production parts shall be welded using an approved weld procedure/schedule.

7.3 Post-Weld Treatment:

7.3.1 Machining of face surface, root surface, or both shall be performed in accordance with customer requirements.

7.3.2 Parts requiring heat treatment shall be processed in accordance with part drawings and specifications.

8. INSPECTION AND ACCEPTANCE CRITERIA:

8.1 Welds shall be visually examined at the required magnification and shall meet the requirements of applicable customer specification.

8.1.1 The results of visual inspection shall be documented.

8.2 When NDT is specified, the inspection processes shall be documented and flowed down.

8.2.1 When NDT is specified, acceptance criteria shall be flowed down.

8.3 In-process control tests shall be performed in accordance with applicable customer specifications, if required.

8.4 Inspection tools to measure dimensional features shall be available to the inspector.

9. REWORK/REPAIR:

9.1 Rework/repair shall be performed in accordance with customer requirements.

10. PERIODIC MAINTENANCE:

10.1 Written procedures shall require preventive maintenance of equipment and tooling at a specified frequency.

10.2 Records shall indicate that maintenance is performed on equipment and tooling in accordance with the procedures and appropriate standards.