

INSTALLATION METHODS IN ORDER OF PREFERENCE:

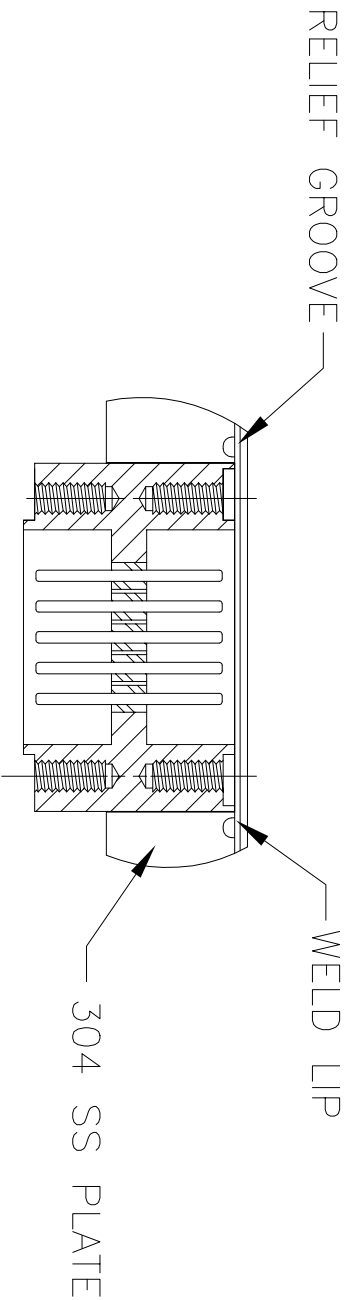
1. E.B. WELDING AND OR LASER WELDING
2. PULSED TIG WELDING
3. PLASMA WELDING
4. STRAIGHT TIG WELDING (NOT RECOMMENDED)

FLANGE CONFIGURATION / DIMENSIONS:

- REFER TO SUBDWELD DWG. FOR DIMENSIONAL REQUIREMENTS
- FLANGE MATERIAL SHOULD BE 304 SS
- BEST ORIENTATION IS WITH WELD LOCATION ON THE VACUUM SIDE

PULSED TIG WELD PROCEDURE:

- TYPICAL WELD SETTINGS:
CURRENT SETTING – 25–30 AMPS
BACKGROUND CURRENT – FIXED AT 1/5 OF PEAK CURRENT (e.g. 4A @20A)
PULSE FREQUENCY – 400 hz.
PULSE WIDTH FIXED AT 50%.
- WELD TRAVEL SPEED SHOULD BE MAXIMIZED (IE .25 INCH/SEC.) TO REDUCE HEAT INPUT.
- UNDERSIDE OF HEADER SHOULD BE FLOODED WITH INERT GAS FOR EXTRA COOLING AND OXIDATION REDUCTION



A

A

B

B

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|----------------|--|---------|-------------|----------------|----------------------|--|
| MATERIAL: | TITLE: CERAMASEAL TYPE "D" HEADER INSTALLATION METHOD | | SUPERSEDES: | | SIMILAR TO: INSTYPED | |
| FINISH: | DO NOT SCALE DRAWING WORK TO DIMENSIONS ALL DIMENSIONS IN INCHES EXCEPT AS NOTED TOLERANCES APPLY UNLESS OTHERWISE SPECIFIED | | DRAWN: RAC | | DRAWING No. | |
| PLATING: | | | CHECK: RAC | | REV. | |
| SPECIFICATION: | 1 PLACE | 2 PLACE | 3 PLACE | DATE: 06/21/96 | INSTYPED2 | |
| USED ON: | | | | REF: | | |

CeramTec
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Ceramasal Division