Keevitusprotseduuride spetsifitseerimine ja kvalifitseerimine metalsete materjalide korral. Osa 10: Keevitusprotseduuri spetsifitseerimine elektronkiirkeevituse korral

Specification and approval of welding procedures for metallic materials. Part 10: Welding procedure specification for electron beam welding

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 9956-10:1999 sisaldab Euroopa standardi EN ISO 9956-10:1996 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 9956-10:1999 consists of the English text of the European standard EN ISO 9956-10:1996.
Standard on kinnitatud Eesti Standardikeskuse 23.11.1999 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.	This standard is ratified with the order of Estonian Centre for Standardisation dated 23.11.1999 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.
Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on .	Date of Availability of the European standard text .
Standard on kättesaadav Eesti standardiorganisatsioonist.	The standard is available from Estonian standardisation organisation.

ICS 25.160.10

Võtmesõnad: elekterkeevitus, elektronkiirkeevitus, keevitus, metallid, protseduur, sulakeevitus, tehnilised andmed, vastavus tehnilistele tingimustele,

Inglisekeelsed võtmesõnad: acceptance, electric welding, electron beam welding, fusion welding, metals, procedure, specifications, welding,

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 9956-10

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Descriptors: see ISO document

English version

Specification and approval of welding procedures for metallic materials - Part 10: Welding procedure specification for electron beam welding (ISO 9956-10:1996)

Descriptif et qualification d'un mode opératoire de soudage pour les matériaux métalliques - Partie 10: Descriptif d'un mode opératoire de soudage par faisceau d'électrons (ISO 9956-10:1996)

Anforderung und Anerkennung von Schweißverfahren für metallische Werkstoffe - Teil 10: Schweißanweißung für das Elektronenstrahlschweißen (ISO 9956-10:1996)

This European Standard was approved by CEN on 1996-08-04. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart,36 B-1050 Brussels

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Foreword

The text of EN ISO 9956-10:1996 has been prepared by Technical Committee CEN/TC 121 ''Welding'', the secretariat of which is held by DS, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 1997, and conflicting national standards shall be withdrawn at the latest by April 1997.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This European Standard specifies requirements for the content of welding procedure specifications for electron beam welding.

Variables listed in this European Standard are those influencing the metallurgy, mechanical properties and the geometry of the welded assembly.

2 Normative references

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 288-1	Specification and approval of welding procedures for metallic materials - Part 1 : General rules for fusion welding
EN 24063	Welding, brazing, soldering and braze welding of metals - Nomenclature of processes and reference numbers for symbolic representation on drawings (ISO 4063:1992)
pr EN ISO 6947	Welds - Working positions - Definitions of angles of slope and rotation (ISO 6947:1990)

3 Definitions

For the purpose of this standard, the following definitions apply in addition of those given in EN 288-1 :

3.1 slope up

The controlled increase of the beam power at the beginning of welding.

3.2 slope down

The controlled decrease of the beam power at the end of welding. The slope down region is the region on the workpiece in which the effects of slope down occur. It can consist of one or two areas, depending on the selected welding mode :

a) in full penetration welding :

- a region where beam penetration is still complete ;

- a region where penetration is partial or decreasing.

b) in partial penetration welding :