

Annex B (Informative)

Sample WPS

This annex is not part of AWS C7.3:2016, *Process Specification for Electron Beam Welding*, but is included for information purposes only.

Weld Procedure Specification

(Asterisks (*) indicate essential variables for electron beam welding.)

Part No.:		*Machine No.:		WPS No.:			
Part Name:		CNC Program:		Operator:			
MACHINE SETUP		FILLER MATERIAL		PART SPECIFICATIONS			
*Gun Type		*Method of Addition		Weld Spec.			
*Filament Type		Wire Diameter		*Material Spec.			
*Filament Size		Wire Speed		*Thickness			
Filament Current		Shim Thickness		Weld Width			
*Gun-to-Work Distance		*Material Spec.		*Required Pen.			
Focus Target Position				Actual Pen.			
NOTES		*PREWELD HEAT TREAT		*WELD GEOMETRY / SYMBOL			
*Table Tilt Angle		Temperature					
*Chamber Vacuum		Notes					
Time Prior to Vent		*POSTWELD HEAT TREAT					
Pulse Width		Temperature					
Pulse Frequency		Notes					
*Cleaning & Assembly							
*Fixture							
WELD PASS PARAMETERS		Type	1 st Pass	2 nd Pass	3 rd Pass	4 th Pass	Weld Developer
*Beam Voltage (kV)							
*Beam Current (mA)							
*Beam Focus							
*Beam Deflection		Type					Engineer Approval
	Freq.						
	X Amplitude						
	Y Amplitude						
Slope Time	Rise						Stamp
	Fall						
*Weld Speed	IPM						
	RPM						
Comments:							