INSTALLATION WELDING OPTIONS

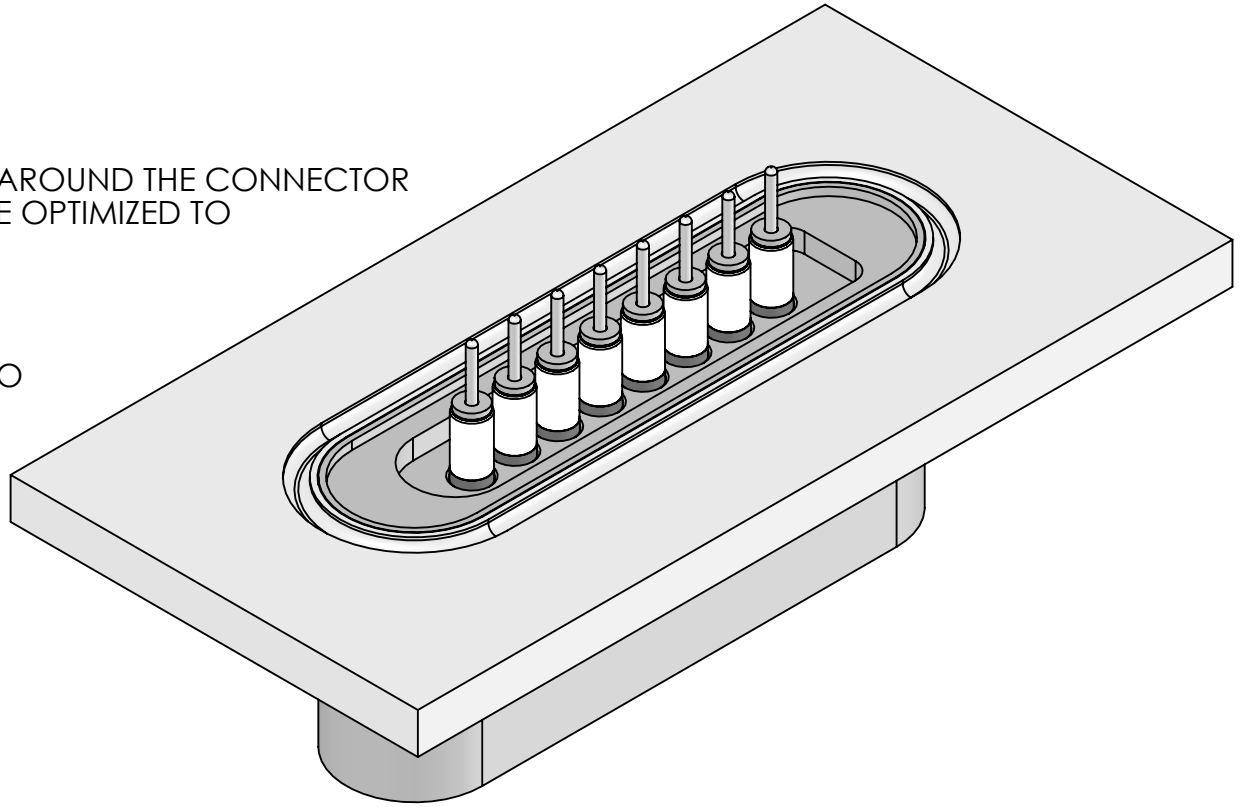
1- E.B. OR LASER WELDING
2- PULSED TIG WELDING

MATING HARDWARE DIMENSIONS/ CONFIGURATION

SEE SHEET 2 OF THIS INSTRUCTION SHEET.
MATING HARDWARE SHOULD BE 304/304L OR 316/316L STAINLESS STEEL
(304/340L ONLY FOR LASER).
PREFERRED ORIENTATION IS WITH THE WELD ON THE VACUUM SIDE.

PULSED TIG WELD RECOMMENDATIONS

1- TYPICAL WELDER SETTINGS
BACKGROUND CURRENT: 9 AMPS
PEAK CURRENT SETTING: 22 AMPS
FREQUENCY: 21Hz
PULSE WIDTH FIXED AT 42-50%
2- TACK WELD 5-6 PLACES EQUALLY SPACED AROUND THE CONNECTOR
3- WELD TRAVEL SPEED: 0.2"/ sec. (SHOULD BE OPTIMIZED TO REDUCE HEAT INPUT).
4- OPPOSITE SIDE OF HEADER SHOULD BE FLOODED WITH INERT GAS FOR EXTRA COOLING AND TO MINIMIZE OXIDATION
5- USE COPPER SHEET AROUND INSULATORS TO SHIELD FROM WELD HEAT.
6- BETWEEN SEGMENTS, FLOOD THE WELD WITH INERT GAS OR NITROGEN GAS FOR 10 SEC MIN, FOR EXTRA COOLING.



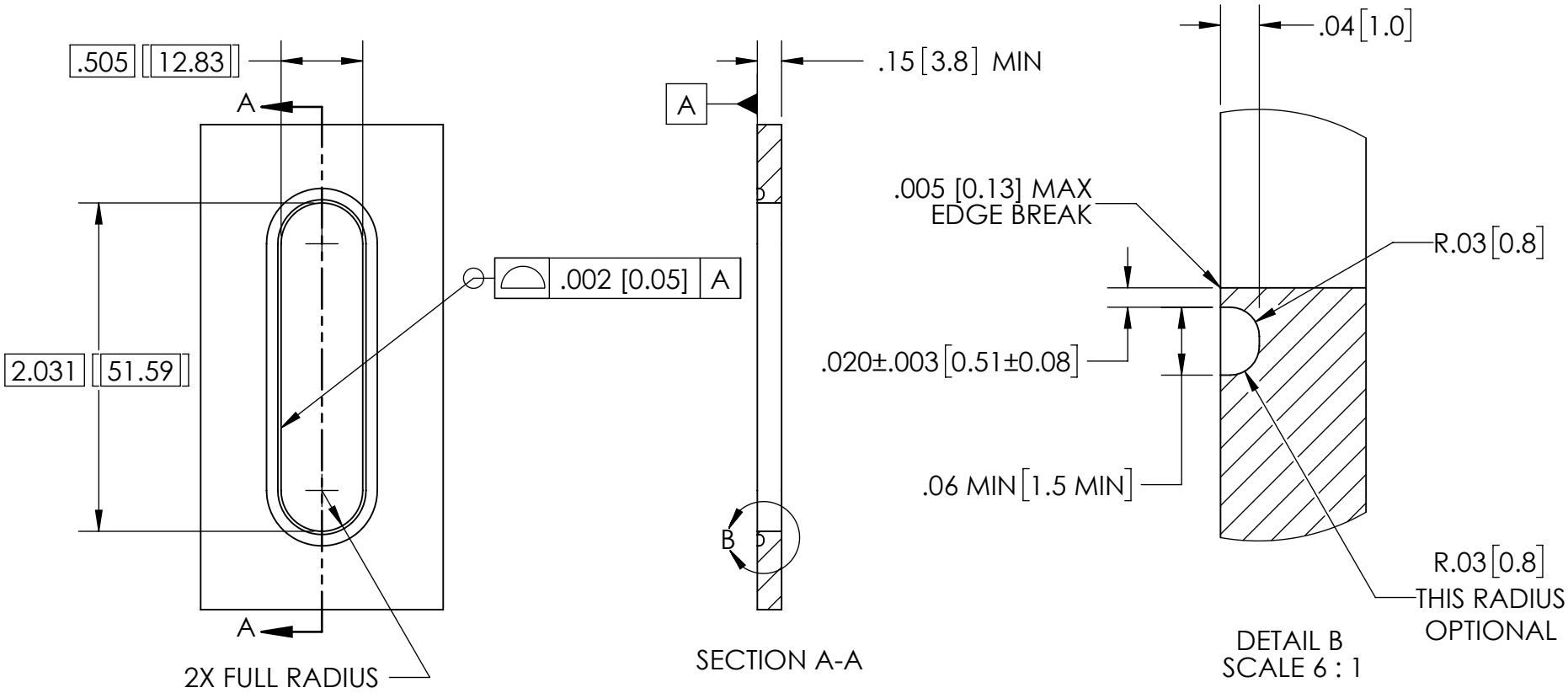
- SEE SHEET 2 FOR HOLE DIMENSIONS -

THIRD ANGLE PROJECTION

TITLE: INSTRUCTION SHEET
FA35741 WELDING/ASM

SOLID SEALING TECHNOLOGY

REV.	APP'D	DATE	SCALE 2:1	DIMENSIONS IN INCHES [mm]	DRAWN	HJ	09/27/2019	NUMBER: NS35741	REV: B	SHEET 1 OF 2
B	CW	7/22/2021	NS35741-01		ENG APPR.	HJ	10/02/2019			



RECOMMENDED HOLE & WELD PREP DIMENSIONS

DIMENSIONS & TOLERANCES REQUIRED MAY DEPEND ON THE PROCESS AND EQUIPMENT USED

- SEE SHEET 1 FOR TIG WELDING INSTRUCTIONS -

THIRD ANGLE PROJECTION

TITLE: INSTRUCTION SHEET FA35741 WELDING/ASM

SOLID SEALING TECHNOLOGY

REV.	APP'D	DATE	SCALE 1:1	DIMENSIONS IN INCHES [mm]	DRAWN	HJ	09/27/2019	NUMBER: NS35741	REV: B	SHEET 2 OF 2
B	CW	7/22/2021	NSPRT001-02		ENG APPR.	HJ	10/02/2019			