

NOTICE OF  
ADOPTION

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16 March 1992  
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ADOPTION NOTICE

ELECTRON-BEAM WELDING

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400 Commonwealth Drive, Warrendale, PA 15096-0001

# AEROSPACE MATERIAL SPECIFICATION

**SAE**

AMS 2681A

Issued 1 OCT 1982  
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Superseding AMS 2681

Submitted for recognition as an American National Standard

## ELECTRON-BEAM WELDING

### 1. SCOPE:

#### 1.1 Purpose:

This specification defines the procedures and requirements for joining metals and alloys using the electron-beam (EB) welding process.

#### 1.2 Application:

These procedures are used typically for electron-beam welding of aerospace components in hard and soft vacuum atmospheres. Although intended primarily for procedures not covered by AMS 2680, usage is not limited to such applications.

### 2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

#### 2.1 SAE Publications:

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

AMS 2630 Ultrasonic Inspection, Product over 0.5 inch (12.5 mm) Thick  
AMS 2631 Ultrasonic Inspection, Titanium and Titanium Alloy Bar and Billet  
AMS 2632 Ultrasonic Inspection of Thin Materials; 0.5 inch (13 mm) and Thinner  
AMS 2635 Radiographic Inspection  
AMS 2640 Magnetic Particle Inspection  
AMS 2645 Fluorescent Penetrant Inspection  
AMS 2680 Electron Beam Welding, For Fatigue Critical Applications  
ARP1317 Electron Beam Welding  
ARP1333 Nondestructive Testing of Electron Beam Welded Joints in Titanium-Base Alloys

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AMS 2681A

SAE

AMS 2681A

**2.2 U.S. Government Publications:**

Available from Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-STD-453	Inspection, Radiographic
MIL-STD-1595	Qualification of Aircraft, Missile, and Aerospace Fusion Welders
MIL-STD-1949	Inspection, Magnetic Particle
MIL-STD-6866	Inspection, Liquid Penetrant
MIL-STD-2073-1	DOD Materiel, Procedures for Development and Application of Packaging Requirements

**2.3 AIA Publications:**

Available from National Standards Association, Inc., 4827 Rugby Avenue, Washington, D.C. 20014.

NAS 976 Electron Beam Welding Machine

**3. TECHNICAL REQUIREMENTS:****3.1 Materials:**

3.1.1 Parent Materials: Shall be as specified on the applicable part drawing.  
(R) (See ARP1317 for guidelines.)

3.1.2 Filler Materials: When required, filler metal shall be as specified on  
(R) the part drawing.

3.1.3 Cleaning Materials: Cleaning materials, chemical solvents, and etching solutions shall be as specified on the part drawing or in the certified welding schedule.

**3.2 Equipment:**

3.2.1 Electron-Beam Welding Equipment: Shall be capable of producing welds  
(R) meeting the requirements of 3.6 and 3.7. Equipment conforming to NAS 976 shall be acceptable.

3.2.2 Jigs and Fixtures: All holding fixtures shall be capable of maintaining the desired configuration and tolerances during welding, providing back-up as required, and allowing required work space between the work piece and the electron gun. Back-up material used to deflect or absorb residual electron-beam energy shall be of the same alloy as the part being welded except that alternate back-up materials may be used when approved by procedure certification as in 3.4.2. Tooling within 6 inches (152 mm) of the weld joint shall be made from nonmagnetic materials or be degaussed to acceptable limits (See 3.2.3).

3.2.3 Degaussing: Ferromagnetic materials and tooling shall, prior to welding, be demagnetized to a level established by procedure certification (3.4.2) which prevents electron-beam deflections while welding the joint.

AMS 2681A

SAE

AMS 2681A

**3.3 Preparation:**

Joint and surface preparation, prior to welding, shall be as follows and shall be included as part of the approved procedure certification:

- 3.3.1 **Joint Preparation:** Joints shall be prepared to conform to requirements specified on the part drawing.
- 3.3.2 **Edge Preparation:** Edges shall be machined square and parallel to ensure proper fit-up. Joints shall have no rounded-off edges, but shall be deburred after machining. (See ARP1333 for guidelines.)
- 3.3.3 **Joint Edges:** Immediately prior to assembly for welding, joint edges may (R) be additionally prepared, depending on the alloy being welded, by either hot alkaline cleaning, acid pickling, solvent cleaning (non-halogenated for titanium alloys), wire brushing with a stainless steel brush and solvent (non-halogenated for titanium alloys) cleaning, or, for aluminum alloys, scraping of joint faying surfaces.
- 3.3.4 **Pre-Weld Fit-Up:** Gap shall not exceed the limits shown in Table 1, unless (R) otherwise specified on the certified weld schedule:

TABLE 1 - GAP LIMITS

Thickness	Gap, max
Up to 0.009 inch (0.23 mm), incl	5% of joint thickness
Over 0.009 to 0.061 inch (0.23 to 1.55 mm), incl	10% of joint thickness
Over 0.061 to 1.49 inch (1.55 to 37.8 mm), incl	Not to exceed 0.010 inch (0.25 mm)
Over 1.49 inch (37.8 mm)	Not to exceed 0.005 inch (0.13 mm)

- 3.3.5 **Weld Start and Run-Off Tabs:** Tabs, when used, shall be of the same alloy as the detail parts being welded and shall be cleaned in the same manner as the parts. Tabs shall be integral with the part, either being machined in, or welded to, the part pieces prior to assembly.
- 3.3.6 **Surface Preparation:** Surfaces of parts to be welded shall be prepared (R) using alkaline or acid cleaners, solvents (non-halogenated for titanium alloys), pickling, or combinations thereof as applicable to the alloy being welded. Welding should commence within 40 hours after surface preparation, unless otherwise permitted or restricted by purchaser.

AMS 2681A

SAE

AMS 2681A

- 3.3.6.1 After surface preparation, parts shall be handled in the joint area with clean, lint-free gloves and shall be covered or otherwise protected to prevent contamination.
- 3.3.7 Accessory Equipment Preparation: Jigs, fixtures, and measuring devices shall be free of scale, grease, protective coatings, oxides, dust, oil, and other foreign materials detrimental to the welding process.
- 3.3.7.1 Handle cleaned surfaces with clean, lint-free gloves.
- 3.4 Procedure:
- 3.4.1 Electron beam weld operators shall be certified. Unless other methods are (R) specified by purchaser, operators certified in accordance with MIL-STD-1595 shall be acceptable.
- 3.4.1.1 Personnel performing welding in accordance with this specification shall be qualified under the cognizance and supervision of the designated welding activity and approved by the cognizant quality control activity. Qualified personnel shall be assigned a stamp with a number or symbol that shall be used to identify all weldments made by such personnel.
- 3.4.1.2 An operator undergoing qualification testing may weld a certification (R) plate in accordance with 3.4.2 according to a pre-established schedule as part of the test.
- 3.4.2 Procedure Certification: Prior to production, a separate weld schedule shall be established for each joint and alloy or alloy combination to be welded. The schedule shall be prepared for each alloy, penetration, weld joint configuration, and for each cosmetic pass configuration, if required, according to Table 3 as a minimum requirement.
- 3.4.2.1 Tacking/Locking Passes: A tack weld or locking pass may be used to restrict relative motion in the weld assembly prior to the first full penetration pass. Weld schedule certification of a tack weld or locking pass is not required provided all evidence of the tack welding is obliterated by the actual weld through fusion.
- 3.4.2.1.1 A tacking pass, other than a full-penetration pass and made with a power density setting substantially reduced from the certified settings, may be used over any portion of the weld joint up to and including the full length of the weld.
- 3.4.2.1.2 A full-penetration tacking pass using certified parameters may be utilized but shall not exceed 10% of the weld joint length. This locking pass shall terminate in the starting or stopping tabs, when applicable.
- 3.4.2.2 Cosmetic Pass: Cosmetic passes for bead appearance improvement may be applied at any time after completion of the initial full-penetration pass. Cosmetic passes, if used, shall be certified in accordance with 3.4.2.

AMS 2681A

SAE

AMS 2681A

- 3.4.3 Procedure Recertification: Recertification of weld schedules shall be required for failed test welds and when any change is made to the following parameters:
- 3.4.3.1 When a change is made in parent metal composition or a change in thickness in excess of  $\pm 10\%$  (not applicable to cosmetic-pass-weld configuration).
  - 3.4.3.2 When a change is made in joint design (not applicable to cosmetic-pass-weld configuration), but not necessarily after changes in length of joint.
  - 3.4.3.3 When the welding position (relationship between the gun angle and the work angle) is changed.
  - 3.4.3.4 When a change is made in any one of the machine settings (items 14 and 16 through 20 of Table 3).
    - 3.4.3.4.1 The use of the beam-deflection switch, item 19 of Table 3, need not be (R) considered when used for the purpose of scanning or beam alignment.
  - 3.4.3.5 When a machine other than the machine used for weld procedure certification tests is used.
- 3.4.4 Production Welding: Production parts shall be welded in accordance with the parameters established in the certified weld schedule of 3.4.2.
- 3.4.4.1 Welding Environment: Electron-beam welding shall be performed in a vacuum at a partial pressure not exceeding  $1 \times 10^{-3}$  Torr (0.133 Pa). Venting the chamber after welding shall not occur less than 2 minutes after completion of welding, unless otherwise established in the procedure certification.
- 3.4.5 Marking and Identification: Each weld shall be traceable to the date of welding and identifiable to the welding operator, and shall be recorded, unless waived by purchaser.
- 3.4.6 Rework: A rework shall be a full or partial electron-beam penetration weld accomplished subsequent to the full-penetration weld. Rework of imperfections, such as cosmetic passes for correction of underfill, as well as full-penetration passes for correction of a missed joint, and other defects may be accomplished by electron-beam welding in accordance with a certified welding schedule. Restarting of the electron beam after an arc-out shall not be classified as a rework but the reason, location, and method shall be recorded.
- 3.5 Post Treatment:
- 3.5.1 Machining: Machining of face or root surfaces, or both, shall be as (R) specified by the applicable part drawing and/or the certified weld schedule. Postweld machining or blending shall not decrease material thickness by more than 5% of weld depth of penetration.

AMS 2681A

SAE

AMS 2681A

3.5.2 Heat Treatment: Weldments requiring heat treatment shall be processed in accordance with part drawing requirements.

### 3.6 Properties:

Specimens taken from test plates, actual parts, or simulated parts produced for procedure certification as in 3.4.2 shall conform to the following requirements:

#### 3.6.1 Metallurgical Examination for Soundness, Bead Shape, and Weld Width:

3.6.1.1 Macro-sections of the weld shall conform to the minimum requirements of the part drawing for weld size, location, length, and configuration. Sections shall be taken transverse and parallel to the weld direction and shall be examined at 10X magnification. In full penetration welds, minimum weld bead width shall be established and recorded.

3.6.1.2 Certification test welds shall meet all requirements of the part drawing (R) and 3.7.

### 3.7 Quality:

(R)

All electron-beam welds shall be subjected to visual inspection at 10X magnification and, when specified, to radiographic inspection in accordance with AMS 2635 or MIL-STD-453, to ultrasonic inspection in accordance with AMS 2630 or AMS 2632 or, for titanium and titanium alloys, AMS 2631, to fluorescent penetrant inspection in accordance with AMS 2645 or MIL-STD-6866, to magnetic particle inspection in accordance with AMS 2640 or MIL-STD-1949, or to any combination thereof, and shall conform to the following requirements:

3.7.1 Color: The weld bead and adjacent parent metal shall have a color similar to that of the unwelded parent metal. Discoloration due to vapor deposition occurring during welding is acceptable. Areas that exhibit loose spatter shall be mechanically cleaned to remove loose particles. Cosmetic passes shall not be used to change color.

3.7.1.1 In the case of titanium alloys, this color shall be a bright silver or light straw-colored in appearance; blue-gray or gray discoloration or the presence of loose scale is not acceptable.

3.7.2 Penetration: Joints shall show evidence of complete penetration on fillet welds, tee welds, and butt welds. Penetration for tube welds shall be as specified on the part drawing. In all other cases, weld root reinforcement shall not exceed 1T or 0.070 inch (1.78 mm), whichever is less, except as otherwise specified by the certified weld procedure. Weld reinforcement shall blend evenly into the adjacent base metal with no sharp notches.

3.7.3 Incomplete Fusion: Incomplete fusion or missed seams are not acceptable. (R) Not less than 0.010 inch (0.25 mm) of parent metal from each side of the joint shall be included in the welded area. Fillet welds shall show complete fusion at the root of the joint.

AMS 2681A

SAE

AMS 2681A

- 3.7.4 Cracks: Cracks are not acceptable.
- 3.7.5 Voids and Pores: Voids and pores open to the surface are not acceptable unless they are subsequently to be removed by machining or blending.
- 3.7.6 Underfill and Concave Root Surfaces: The cumulative depths of underfill of face and root surfaces shall not exceed the post-weld machining allowances specified on the part drawing. The allowable underfill for each surface not machined after welding shall be 10% of the joint thickness or as specified on the drawing.
- 3.7.7 Undercut and Root Notches: Where permissible, shall not exceed engineering drawing tolerances. When not specifically noted, undercut or root notches shall not exceed 10% of material thickness total and shall be blended to have not less than 0.06 inch (1.5 mm) root radius.
- 3.7.8 Overlaps: Protrusion of weld metal beyond the toe, face, or root of the weld is not acceptable.
- 3.7.9 Mismatch: Shall not exceed the limits shown in Table 2.  
(R)

TABLE 2 - MISMATCH

Thickness	Maximum Mismatch
Up to 0.250 inch (6.35 mm), incl	10% of joint thickness or 0.010 inch (0.25 mm), whichever is less
Over 0.250 inch (6.35 mm)	10% of joint thickness or 0.030 inch (0.76 mm), whichever is less

## 3.7.10 Internal Discontinuity Limits:

- 3.7.10.1 Maximum Pore Diameter: The following limits apply to aluminum, titanium, iron, nickel, and cobalt alloys for various applications:
- 3.7.10.1.1 0.25 Inch (6.4 mm) and Under in Nominal Thickness: Shall not exceed 0.33T or 0.060 inch (1.52 mm), whichever is less.
- 3.7.10.1.2 Over 0.25 Inch (6.4 mm) in Nominal Thickness: Shall not exceed 0.33T or 0.125 inch (3.18 mm), whichever is less.
- 3.7.10.2 Other Discontinuities: Maximum number of pores, total defect area, and defect spacing shall be as specified by purchaser. (See ARP1317 and AMS 2680 for guidelines.)

AMS 2681A

SAE

AMS 2681A

#### 4. QUALITY ASSURANCE PROVISIONS:

##### 4.1 Responsibility for Inspection:

(R)

The welding vendor shall be responsible for performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that welded parts conform to the requirements of this specification.

##### 4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests for quality (3.7) are acceptance tests and shall be performed on each weld.

4.2.2 Preproduction Tests: Tests for all technical requirements including procedure certification tests are preproduction tests and shall be performed prior to or on the initial shipment of a welded part to a purchaser and when purchaser deems confirmatory testing to be required.

4.2.2.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.

##### 4.3 Sampling and Testing:

(R)

Shall be in accordance with the following; a lot shall be all parts of the same alloy(s) of one configuration processed at one time in sequence and presented for vendor's inspection at one time:

4.3.1 For Acceptance Tests: All production weldments.

4.3.2 For Procedure Certification: Not less than three welds for procedure certification (3.4.2) representative of each joint in the part or assembly. When test welds are made on actual hardware, one part may be welded for procedure certification (3.4.2).

##### 4.4 Approval:

4.4.1 The purchaser shall approve the vendor's facilities, inspection methods, (R) and process controls before production parts are supplied.

4.4.2 When required by purchaser, sample welded parts and the welding procedure (R) shall be approved by purchaser before parts for production use are supplied. If necessary to make any change in procedures or methods of inspection, the welding processor shall submit for reapproval details of the proposed changes and, when requested sample welded joints or assemblies.

AMS 2681A

SAE

AMS 2681A

#### 4.5 Reports:

The vendor of welded parts shall furnish with each shipment a report showing the results of tests on each lot to determine conformance to the acceptance test requirements and stating that the parts have been processed in accordance with the certified welding procedure by certified welding operators. This report shall include the purchase order number, AMS 2681A, part or assembly number, and quantity.

#### 5. PREPARATION FOR DELIVERY:

##### 5.1 Identification:

Welded parts shall be identified as specified on the part drawing or as agreed upon by purchaser and vendor.

##### 5.2 Protective Treatment:

When required, welded parts shall be given a suitable protective treatment as specified in the process schedule or on the part drawing.

##### 5.3 Packaging:

5.3.1 Welded parts shall be handled and packaged in a manner to ensure that the required physical characteristics of the parts are preserved.

5.3.2 Packages of parts shall be prepared for shipment in accordance with (R) commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the parts to ensure carrier acceptance and safe delivery.

5.3.3 For direct U.S. Military procurement, packaging shall be in accordance with (R) MIL-STD-2073-1, Commercial Level, unless Level A is specified in the request for procurement.

#### 6. ACKNOWLEDGMENT:

A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

#### 7. REJECTIONS:

Parts not welded in accordance with this specification, or to modifications authorized by purchaser, will be subject to rejection.

#### 8. NOTES:

##### 8.1 Marginal Indicia:

The (R) symbol is used to indicate technical changes from the previous issue of this specification.