

Applications of Electron Beam Welding:

- ❖ Electron beam welding is mainly used in electronic industries, automotive & aircraft industries where the quality of weld required.
- ❖ It is also used in rocket and atomic energy field.

Plasma Arc Welding:

The term plasma refers to mass of extremely hot, ionized gas. To obtain this plasma state gases like argon are passed through a constricted electric arc. This causes ionization of the gas and a jet of plasma ejects out from the nozzle of the welding torch. The temperature of the plasma jet emerging from the torch is as high as 15000°C. This temperature can be controlled by controlling the ionization process, in turn by controlling the supply of gas. This high temperature plasma jet is suitable for welding, cutting, drilling and spraying of very refractory materials. The plasma arc welding can be done using two methods.

➤ Transferred Arc Plasma:

An arc is struck between a non consumable tungsten electrode and the work. Since in this process, most of the heat is liberated at the work, this is most suitable for welding and cutting of very refractory materials. The transferred arc plasma can be used for welding with filler metal with manual or semi automatic means. If required, an auxiliary gas shield can be used to protect the weld bead from oxidation.

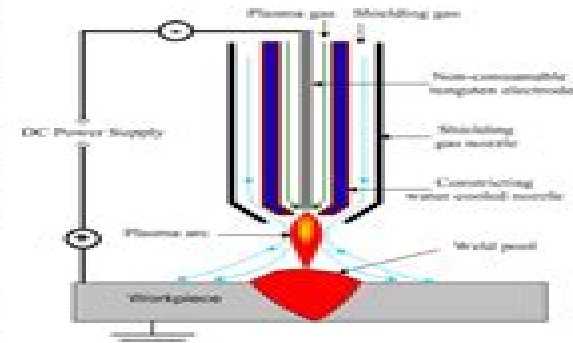


Fig: Transferred Arc Plasma

In this process for welding stainless steel & other hard materials, with tungsten electrode is used so as to produce more heat in the base metal. For welding aluminum & its alloys, DCRP is used with a water cooled copper electrode. This process is used for welding of various parts in aerospace engineering, welding of reactive materials & thin metals. This process is suitable for welding of stainless steel, titanium, high carbon & seam welded stainless steel tubes.

➤ Plasma Jet Projector:

An arc is struck between the tungsten electrode and an insulated water cooled nozzle which forms the positive electrode. This is also called as non transferred arc process. Here, most of the heat is concentrated in the flame which is emerging out from the nozzle as plasma jet. The material in welding may be fed into the plasma flame in the form of fine powder.

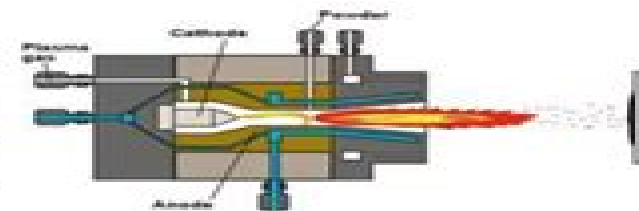


Fig: Plasma Jet Projector

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D. KOSHAL



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Table of Contents Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2

1. Understanding the eBook Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - The Rise of Digital Reading Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Advantages of eBooks Over Traditional Books
2. Identifying Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - User-Friendly Interface
4. Exploring eBook Recommendations from Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Personalized Recommendations
 - Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 User Reviews and Ratings
 - Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 and Bestseller Lists
5. Accessing Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 Free and Paid eBooks
 - Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 Public Domain eBooks
 - Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 eBook Subscription Services

- Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 Budget-Friendly Options
- 6. Navigating Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 eBook Formats
 - ePub, PDF, MOBI, and More
 - Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 Compatibility with Devices
 - Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Highlighting and Note-Taking Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Interactive Elements Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
- 8. Staying Engaged with Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
- 9. Balancing eBooks and Physical Books Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Setting Reading Goals Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2
 - Fact-Checking eBook Content of Manufacturing Processes Techniques Plating Brazing Soldering Welding Volume 2

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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