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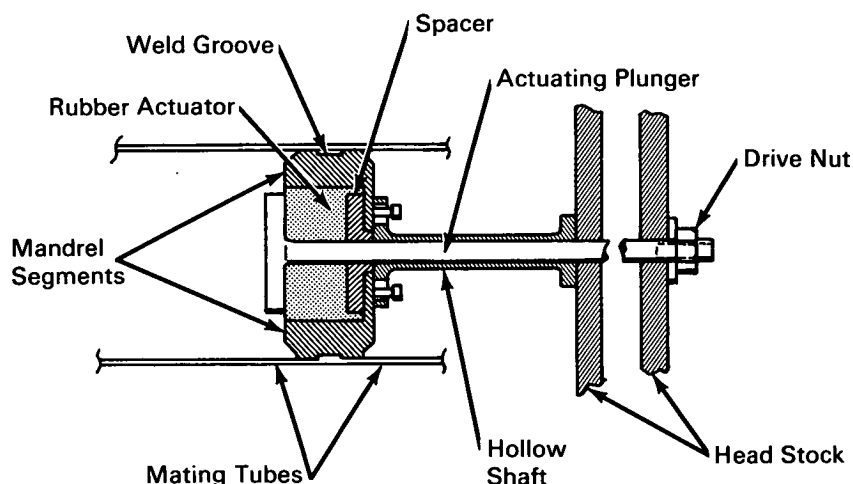
Brief 66-10323

# NASA TECH BRIEF



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## Special Mandrel Permits Uniform Welding of Out-of-Round Tubing



### The problem:

To provide uniform weld bead chilling in the machine welding of circumferential seams on tubing or cylinders that are out of round.

### The solution:

A segmented, expandable mandrel that achieves close contact with the inner walls of the out-of-round tubes by the independent expansion of each segment.

### How it's done:

The assembly is installed on the headstock and secured by slight tightening of the drive nut. Two mating tubes are positioned on the mandrel with their point of juncture aligned with the center of the weld groove on the mandrel segments. Further tightening of the drive nut pulls the actuating plunger through

the hollow shaft, thus compressing the heat resistant rubber actuator between the actuating plunger and the spacer. This causes radial expansion of the rubber actuator and forces the individual mandrel segments into intimate contact with the inner walls of the mating tubes.

### Notes:

1. Various sizes of tubing may be welded with this method by substituting different mandrels and rubber actuators.
2. Inquiries concerning this innovation may be directed to:

Technology Utilization Officer  
Marshall Space Flight Center  
Huntsville, Alabama 35812  
Reference: B66-10323

(continued overleaf)

**Patent status:**

No patent action is contemplated by NASA.

Source: Edwin L. Whiffen, Martin E. D'Or,  
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Marshall Space Flight Center  
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