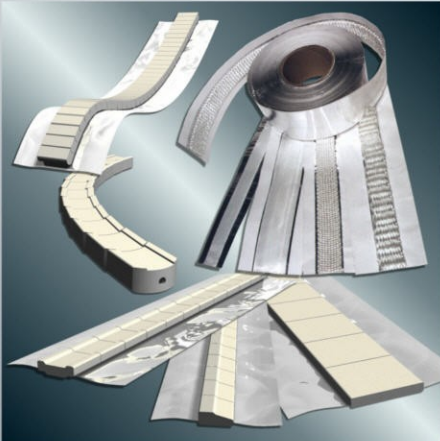
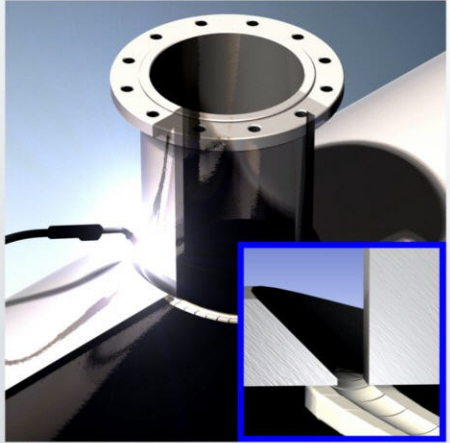


CERBACO LTD.

***STANDARD NON METALLIC WELD BACKINGS
FOR FULL PENETRATION WELDING***


















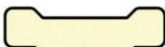
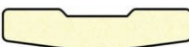
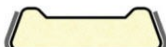
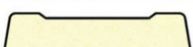



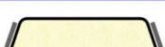

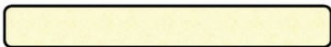



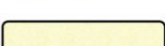






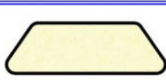

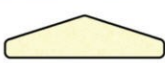






WELD MORE EFFICIENTLY !



WWW.CERBACO.COM

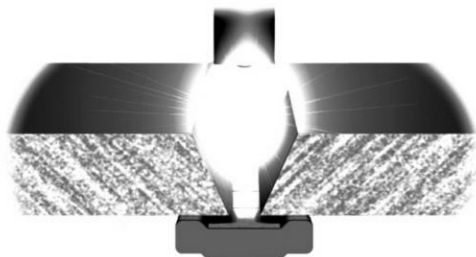


MADE IN U.S.A.

 1C32-CE	 1C41-CE	 1C42-CE	 1C42-D
 1C42-DT	 1C43-CE	 1C43-DT	 1C44-CE
 1C44-W	 1C46-A	 1C52-CE	 1C72
 1C72-A	 1C75	 1C83	 1C85
 1B92-A	 1B93-A	 1B93-A-40mm	 1B93-A-DT
 1B93-CDT	 1B93-20	 1B93-W	 1C42-FL
 1C42-FL-DT	 1C42-FL-1/4"	 2 X 2 X 3/8"	
 1C42-EZ	 1C42-EZ-1/4"	 2 X 2 X EZ	
 1C90	 1C33-45	 1C33-60	 1C33-90
 1C45	 1C54	 1C55	 1S14
 105 DEG.	 145 DEG.	 1N34	 1N35
 1S60	 D13-8mm	 D13-12mm	 D13-20mm RD/2

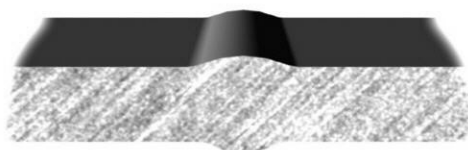
JUST A FEW OF OUR 500+ PROFILES

CERBACO LTD.



FROM THIS

TO THIS



*WITHOUT GOUGING, GRINDING,
REWELDING, OR REWORK*

ACHIEVE:

*X-RAY QUALITY WELDS
FULL PENETRATION WELDING FROM ONE SIDE
UNIFORM BACK BEAD OF FINISHED QUALITY*

ELIMINATE:

*DEFECTS AND COSTLY REWORK
GOUGING AND BACKGRINDING
TURNING OVER HEAVY SECTIONS*

WELD:

*CARBON AND ALLOY STEEL
STAINLESS STEEL
NON FERROUS METALS
ALUMINUM*

*-STICK ELECTRODE
-MIG
-TIG
-SUB ARC
-FLUX CORE*

*-SHIPBUILDING
-STRUCTURAL STEEL
-PIPELINES
-PRESSURE VESSELS
-TANKS*

PRODUCT DESCRIPTION

In the past, full penetration welding involved costly backgouging, grinding, and rewelding. With CERBACO LTD. non metallic weld backings you can achieve X-ray quality, full-penetration welds from one side and in a single pass. The result is a finished high quality weld and a savings of labor, materials, and time. CERBACO weld backings are manufactured in many different configurations and in formulas for the diverse conditions encountered when welding anything from light gauge sheet metal to heavy metal fabrication. CERBACO weld backings can be used to compensate for poor fit-ups, and is a valuable tool when welding conditions are not ideal or where the back side of a weld joint is inaccessible.

CERBACO weld backings are non metallic, non hygroscopic, neutral, and unlike metal backing bars, do not become part of the finished weld. When properly positioned and attached to the back side of a weld joint, your welds can be free of defects eliminating rework and cleanup associated with poor root welds.

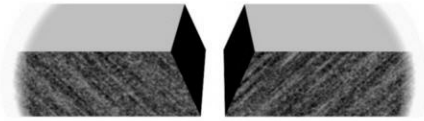
One-sided one-pass and one-sided multi-pass welds are possible with CERBACO weld backings. Our backings support molten weld metal over a wide range of welding heats resulting in uniform back beads of finished quality.

SERVICES

At CERBACO, we will provide complete technical assistance and will direct proper use of our products. If your application requires something special we will design custom shapes and sizes. In addition we will, if necessary, develop new backing formulations for you. In our 25 years of experience we have designed over 500 profiles. Typically, we stock many of these items in order to be ready for immediate shipment. All manufacturing is done by CERBACO. When an item is not readily available, it can generally be shipped within days from the time of order.

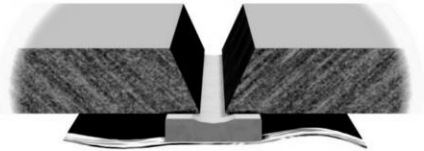
PROCEDURE

STEP 1. start with an open root:



Backing will vary depending upon root opening, joint design and welding process

STEP 2. apply backing:



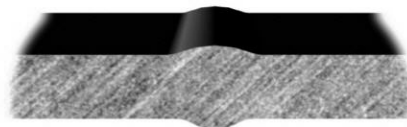
In most applications backing is applied using our adhesive foil on which the backing is assembled. The area to which the backing will be attached should be free of loose rust, dirt, and oil.

STEP 3. weld:

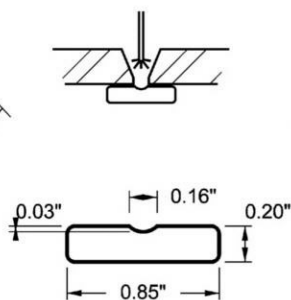
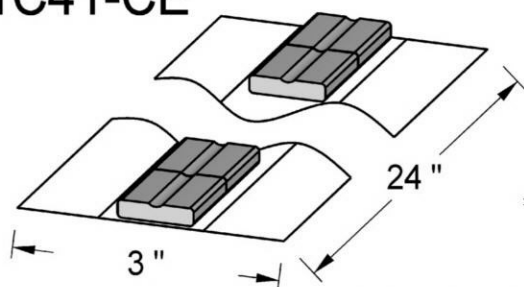


Establish your arc and weld a root pass.

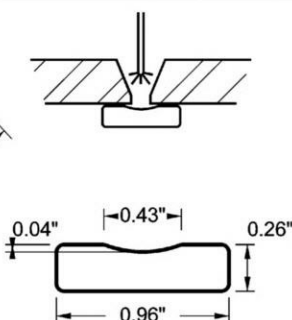
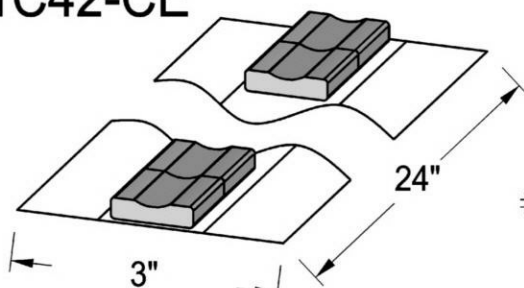
STEP 4. remove backing to reveal finished backbead:



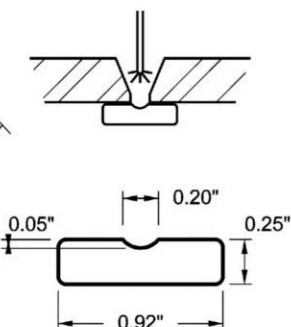
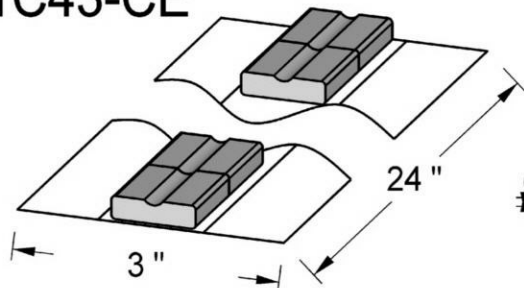
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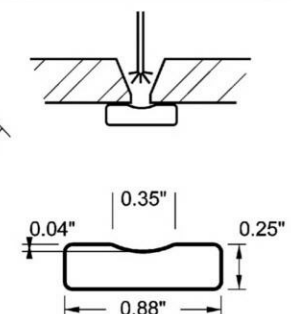
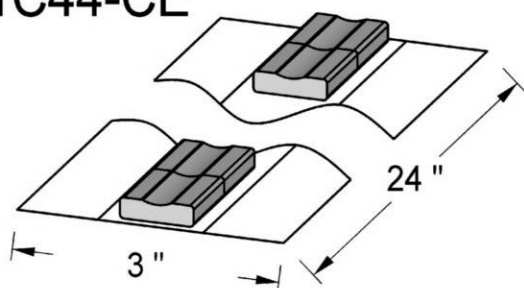
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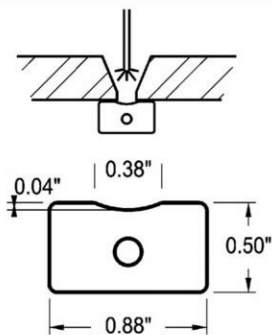
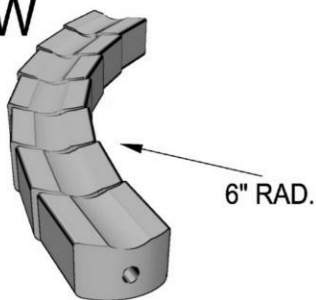
1C43-CE



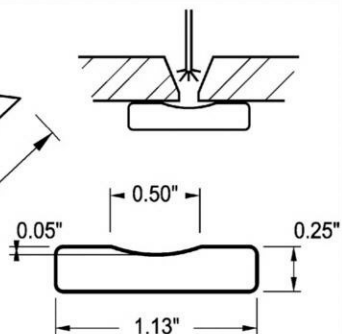
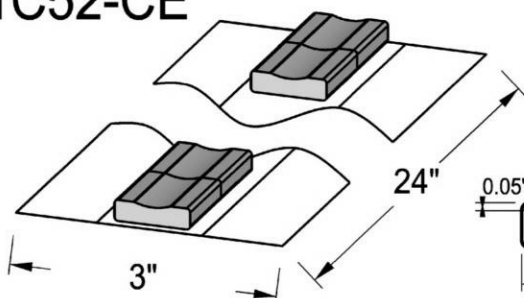
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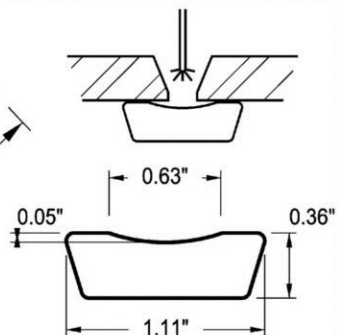
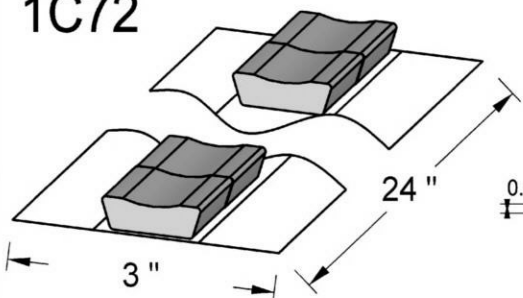
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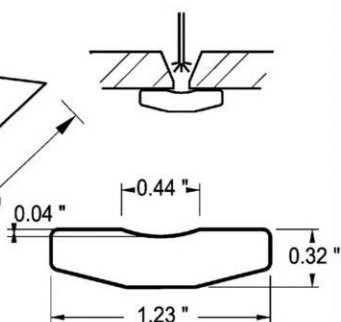
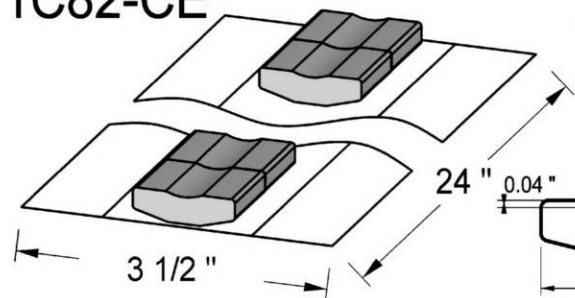
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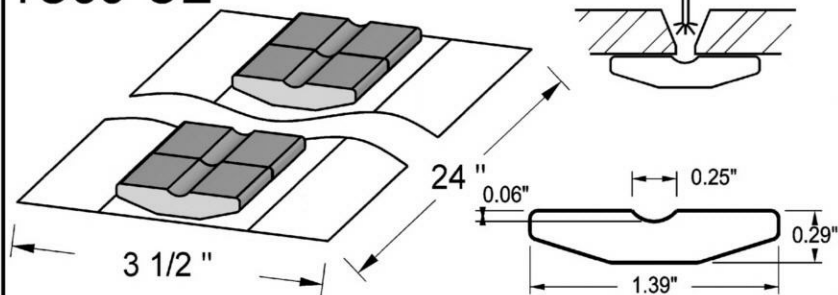
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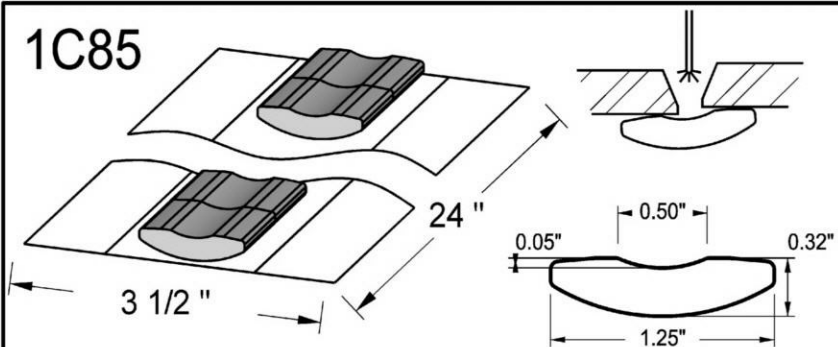
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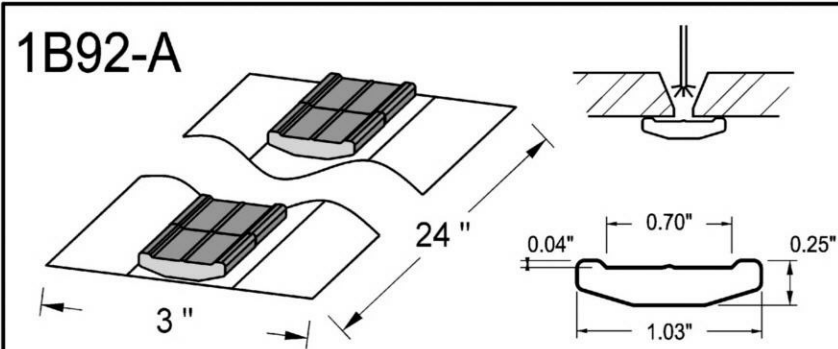
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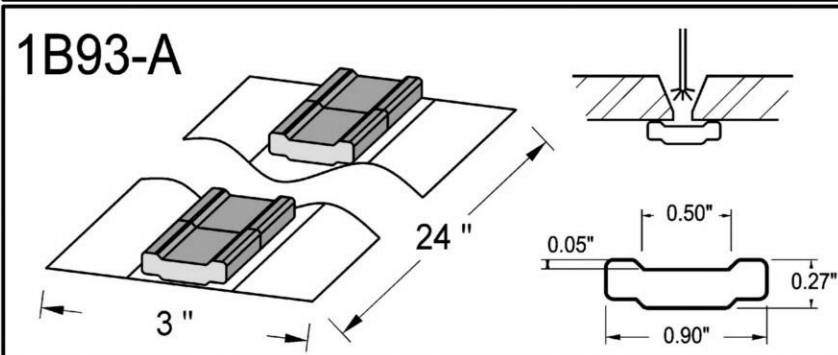
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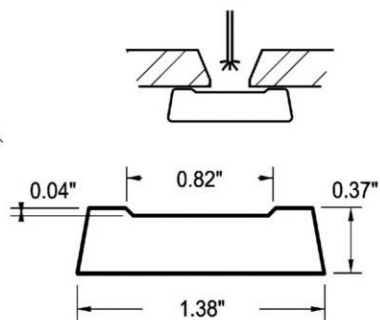
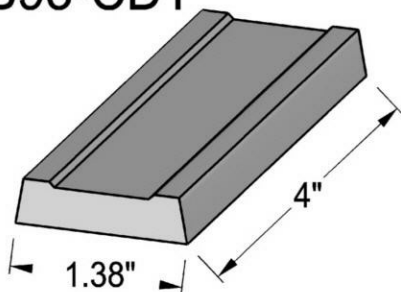
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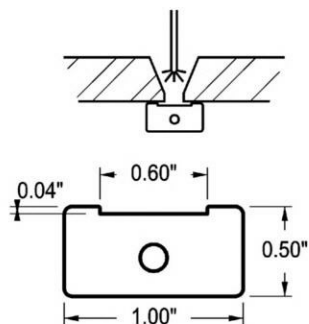
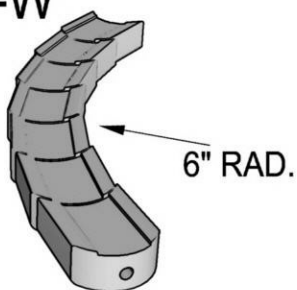
1B93-A



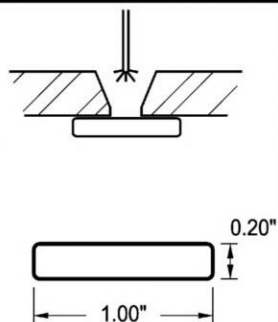
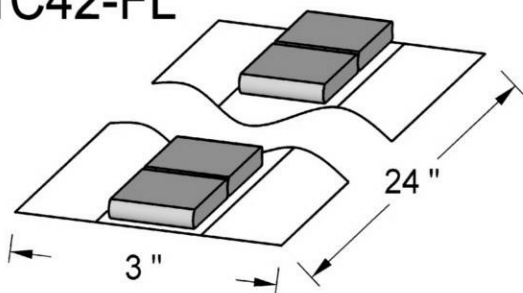
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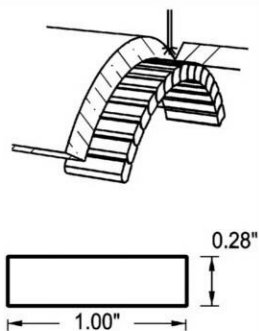
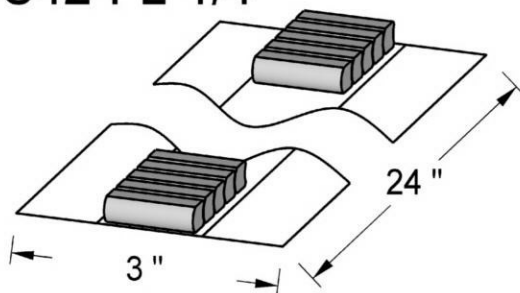
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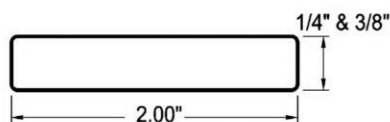
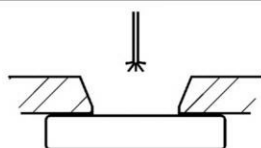
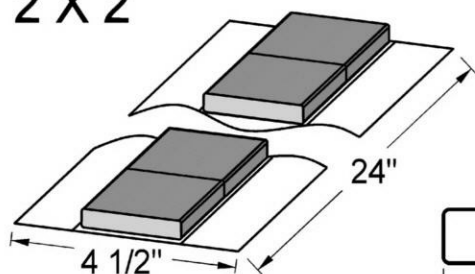
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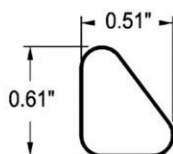
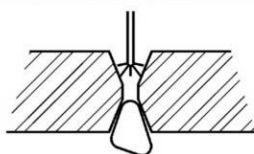
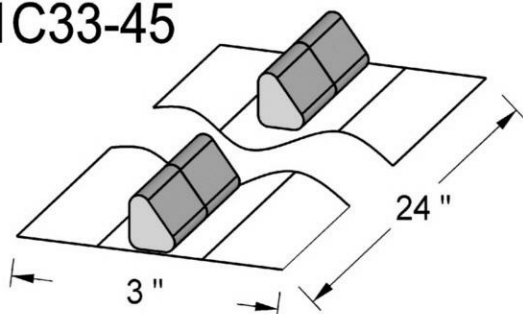
1C42-FL-1/4"



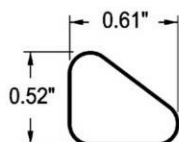
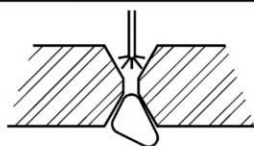
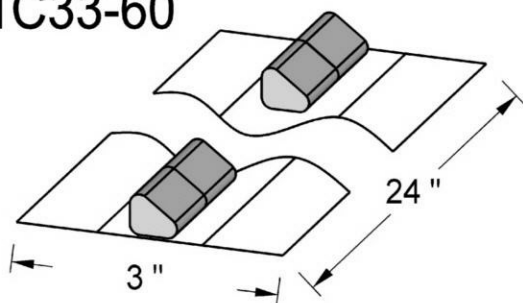
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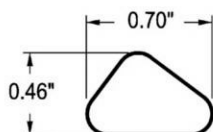
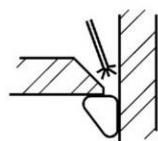
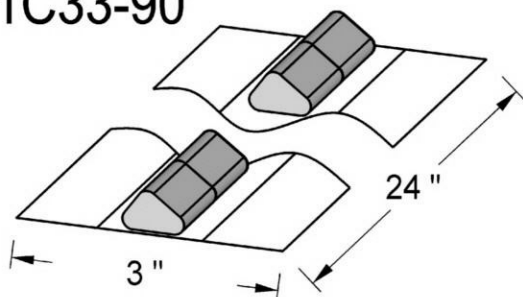
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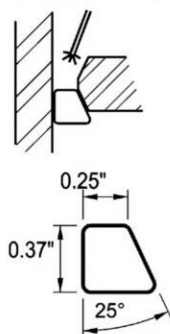
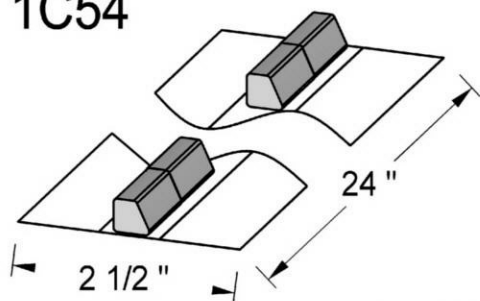
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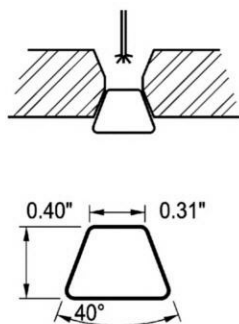
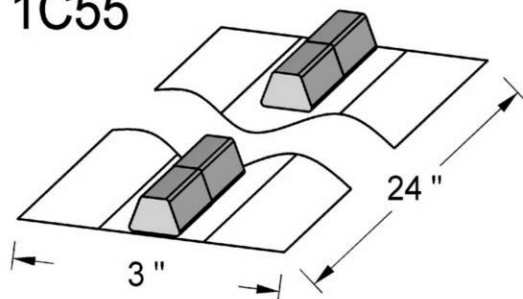
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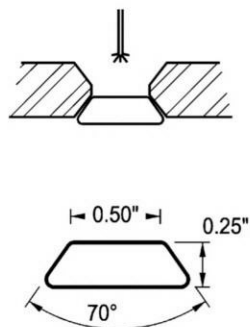
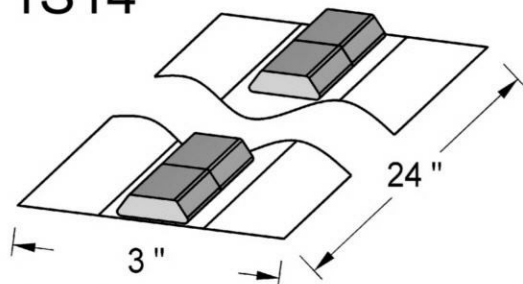
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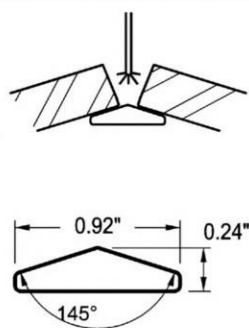
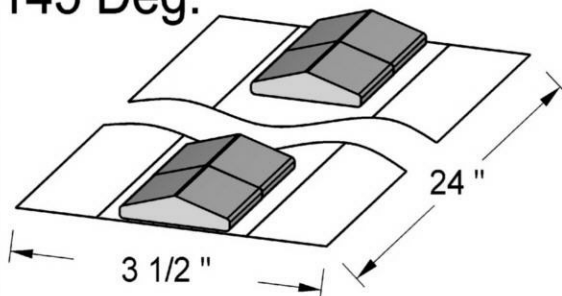
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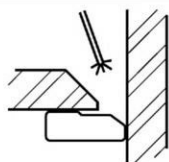
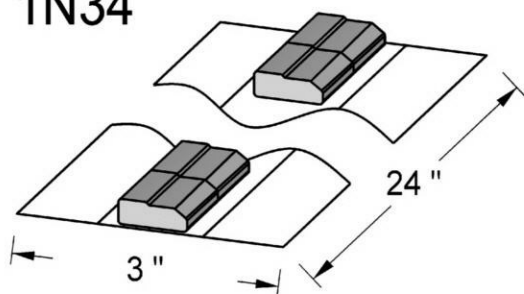
1S14



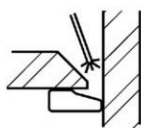
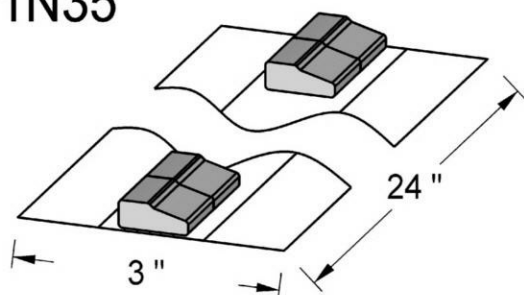
145 Deg.



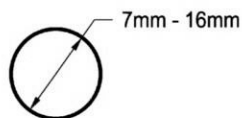
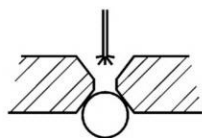
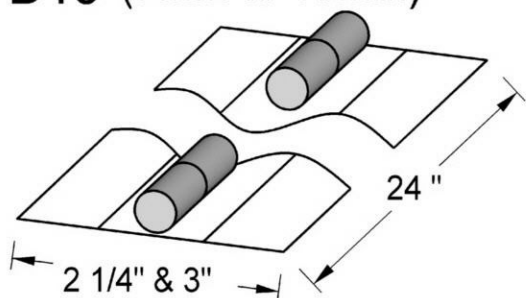
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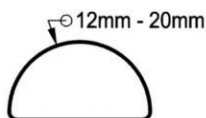
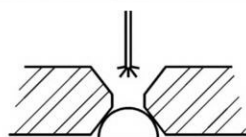
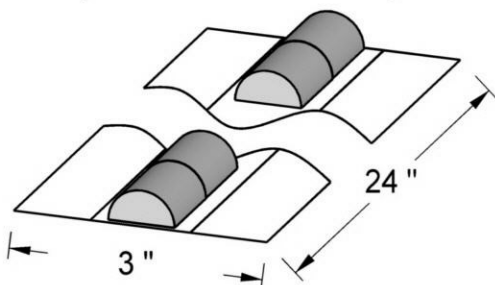
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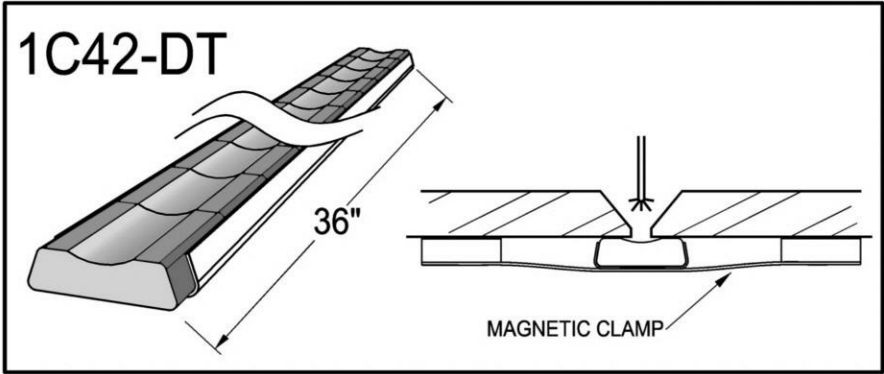
D13-(7mm to 16mm)



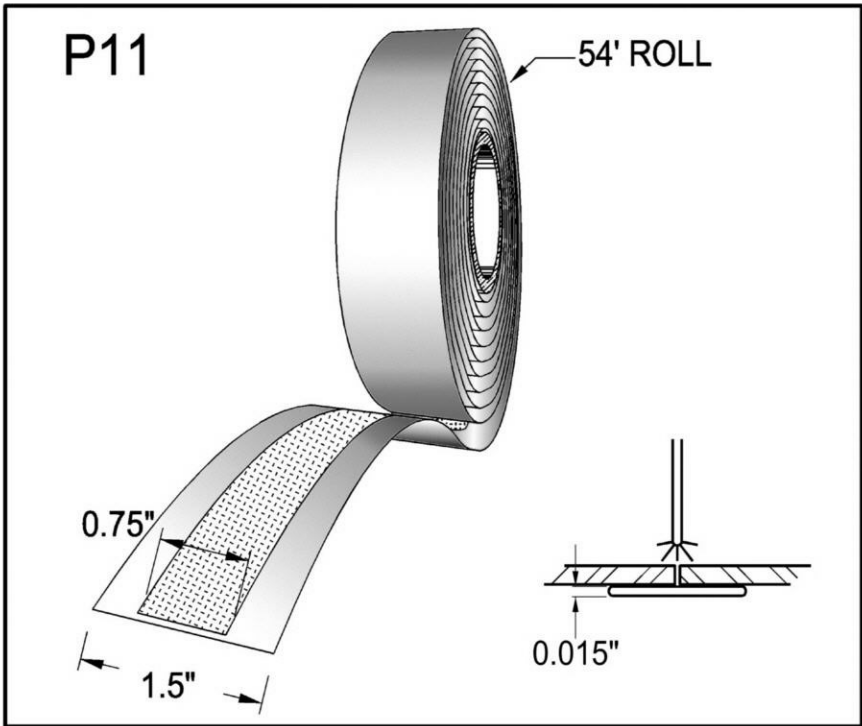
D13-(12mm to 20mm) RD/2



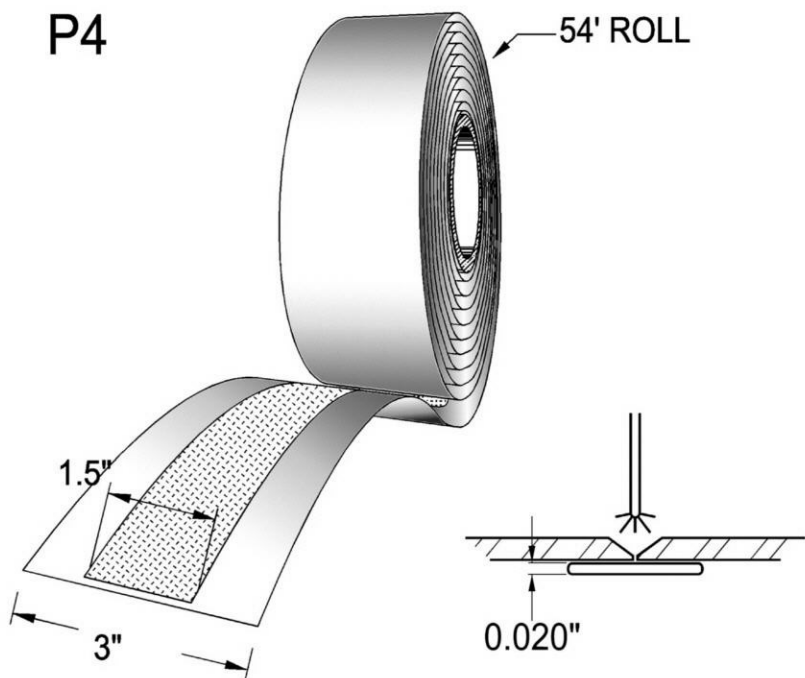
A range of CERBACO weld backings are available in varied metal track mounting systems supported by our magnetic clamps such as our 1C42-DT shown below.



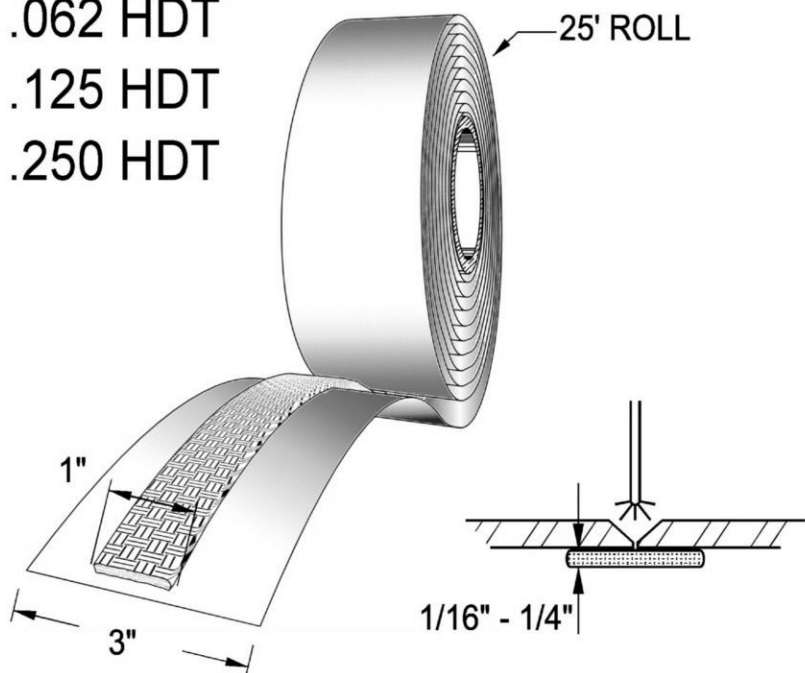
CERBACO also manufactures a line of flexible fiber backings for TIG welding of carbon and stainless sheet metal.



P4



.062 HDT
.125 HDT
.250 HDT



At CERBACO, we will provide you with the proper backing for your applications.

Our engineers will be happy to assist you in implementing the proper weld backing.

CERBACO can also develop new backings and formulations for your specific needs.



With a full range of shapes, formulations and mounting systems combined with our 25 years of expertise and customization, CERBACO LTD. is the one source for weld backings.

**CERBACO LTD.
809 HARRISON STREET
FRENCHTOWN, N.J. 08825
PHONE: 908-996-1333
FAX: 908-996-0023**

WWW.CERBACO.COM

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**For assistance in determining the proper
weld backing for your application, fill out the
"WELD BACKING PERFORMANCE REQUIREMENT SHEET"
in the center of this brochure and:**

FAX TO: 908-996-0023

or

MAIL TO:

**CERBACO LTD.
809 HARRISON STREET
FRENCHTOWN, NJ 08825
ATTN. TECHNICAL DEPARTMENT**

or

**VISIT OUR WEBSITE AND
SUBMIT IT ONLINE AT
WWW.CERBACO.COM**

or

**CALL CERBACO AT:
908-996-1333**

CERBACO LTD.
809 HARRISON STREET
FRENCHTOWN, NJ 08825

TEL: 908-996-1333
FAX: 908-996-0023

WELD BACKING REQUIREMENTS

SUBMITTED BY: _____ TITLE: _____
COMPANY: _____
ADDRESS: _____
CITY, STATE, ZIP: _____
TEL: _____ FAX: _____ E-MAIL: _____

PLEASE PROVIDE US WITH THE FOLLOWING INFORMATION

BASE MATERIAL _____ THICKNESS _____
JOINT DESIGN _____ ROOT OPENING _____
BEVEL ANGLE _____ WELDING PROCESS _____
LAND SIZE _____
ELECTRODE/WIRE TYPE & DIAMETER _____
VOLTS _____ AMPS _____ TRAVEL SPEED _____
WELD POSITION ☐ FLAT ☐ HORIZONTAL ☐ VERTICAL
CIRCUMFERENTIAL ☐ YES ☐ NO IF YES DIAMETER _____

SPECIAL REQUIREMENTS (PROVIDE SKETCH IF NECESSARY)

BEFORE USING, USER SHALL DETERMINE ULTIMATE SUITABILITY OF THE PRODUCT FOR ITS INTENDED USE AND ASSUME ALL RISK AND LIABILITY
SELLER AND MANUFACTURERS' OBLIGATION SHALL BE LIMITED TO REPLACE THE QUANTITY OF THE PRODUCT PROVED TO BE DEFECTIVE.
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