

# *CERAMIC BACKING*

## **E-brochure**



# *Ceramic backing weld metal supports*

Úvod

Vyhledávání



# *Ceramic backing weld metal supports*

- Uplatnění při stavbě lodí, mostů, tlakových nádob a ocelových konstrukcích.
- Typy použitelné pro MMA, MIG/MAG, FCAW and SAW.



# *Ceramic backing weld metal supports*

## **Hlavní výhody:**

- Jednostranné svařování
- Možnost použití vyšších svařovacích parametrů = zvýšení produktivity.
- Vysoká kvalita kořenových svarů se zárukou průvaru a hladkého povrchu.
- Použitelné v polohách PA (1G), PC (2G), a PF (3G nahoru).
- Odstraňuje nutnost broušení a čištění kořene.
- Jednoduchá aplikace, rychlé zaučení i pro méně zkušené svařeče.



# *Ceramic backing weld metal supports*

## **Hlavní výhody:**

- Nemá vliv na chemické složení nebo mechanické vlastnosti svarového kovu.
- Nenavlhavé, možné použít i s materiály garantující nízký obsah difúzního vodíku.



# *Ceramic backing weld metal supports*

## **Středové trhliny při používání keramických podložek:**

- Středové trhliny se mohou objevit při použití s plněnou elektrodou rutilových typů především při vyšším vneseném teple.
- Konkávní typy nepříznivě ovlivňují vznik tuhoucích struktur způsobující náchylnost svarového kovu k trhlinám za tepla především v případě vysokých tepelných deformací.



# *Ceramic backing weld metal supports*

## **Zásady pro omezení vzniku trhlin:**

- Úhel rozevření svaru 45-60° s mezerou v kořeni 5mm.
- Použití rektangulárního typu pro struskotvorné svařovací materiály.
- Použití podložky se šířkou kanálku min 15mm.
- Svařovací proud max. 180A (Ø1,2mm).
- Minimalizovat rozkyv pro dosažení co nejnižšího svaru a držet obluk před svarovou lázní pro dostatečný průvar.



# *Ceramic backing weld metal supports*

Rozsah podložek v této prezentaci pokrývá většinu aplikací.  
V sortimentu jsou obsaženy **šedé** a **hnědé** typy.

- **Šedé** typy jsou vyrobeny z tvrdšího materiálu s vyšším bodem tání a nízkou tvorbou vlastní strusky. Jsou křehké za tepla a proto musí být upevněny na hliníkové pásce nebo kovové kolejniče.
- **Hnědé** mají nižší bod tání, ale mohou být děleny na menší díly a nemusí být nutně upevněny protože se nerozpadají.





# *Ceramic backing weld metal supports*

Vyhledávání podle:

**Typu / Tvaru**

**Způsobu upevnění**

**Seznam všech položek**

**Aplikace**



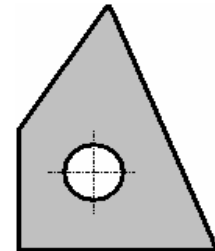
# Ceramic backing weld metal supports

**Type / Shape:**

**RECTANGULAR**

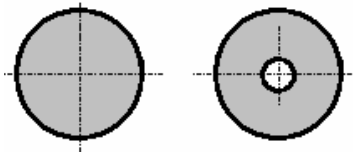


**CONCAVE**

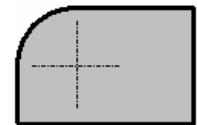


**SPECIAL**

**ROUND**



**SPECIAL - FLAT**



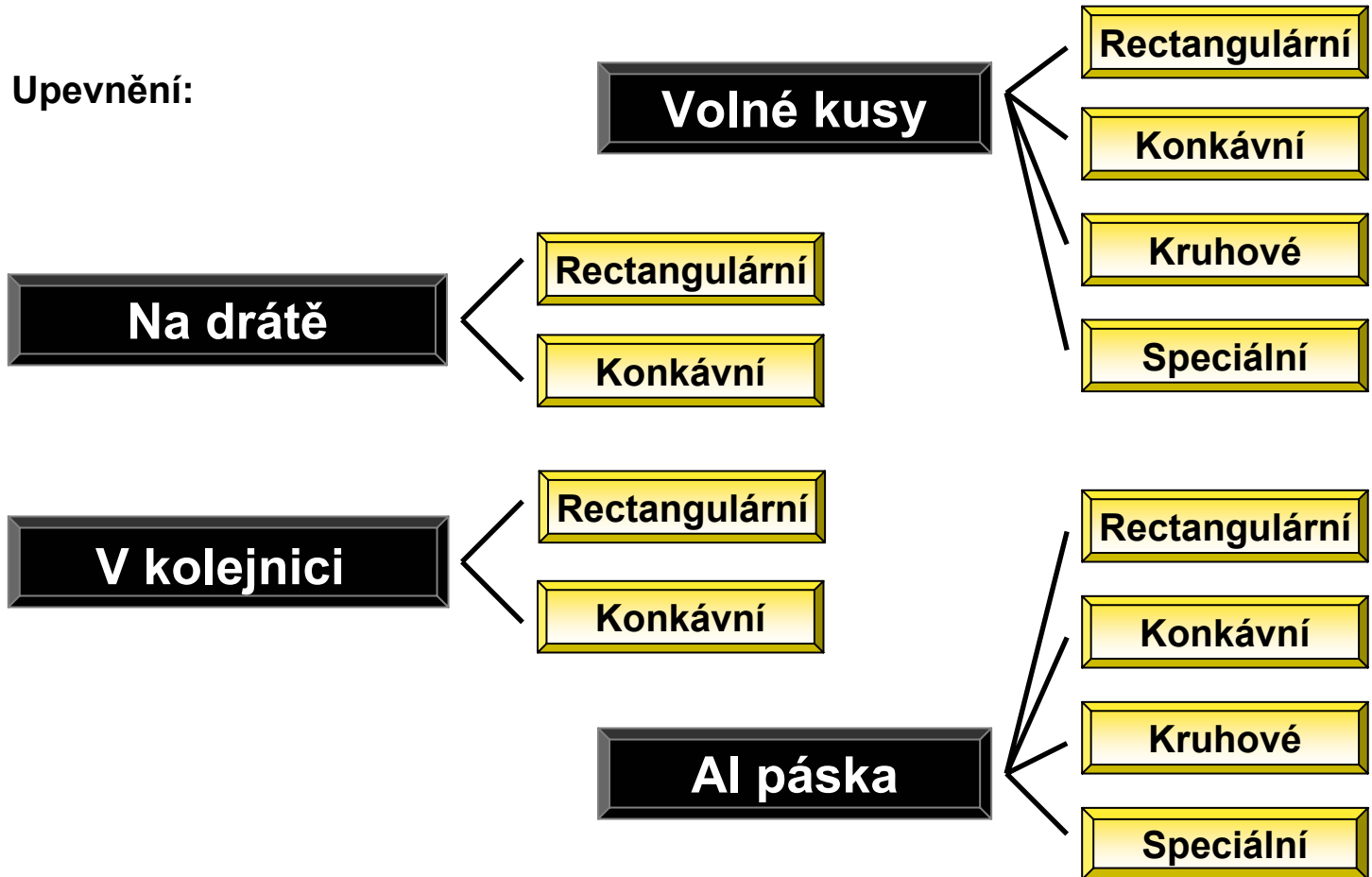
**SPECIAL**

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# Ceramic backing weld metal supports

Upevnění:



PŘÍSLUŠENSTVÍ



# Ceramic backing weld metal supports

PZ1500/01	PZ1500/24	PZ1500/44	PZ1500/57	PZ1500/87
PZ1500/02	PZ1500/25	PZ1500/48	PZ1500/70	OK Backing Rectangular 13
PZ1500/03	PZ1500/29	PZ1500/50	PZ1500/71	OK Backing Concave 13
PZ1500/07	PZ1500/30	PZ1500/51	PZ1500/72	OK Backing Pipe 9
PZ1500/08	PZ1500/32	PZ1500/52	PZ1500/73	OK Backing Pipe 12
PZ1500/17	PZ1500/33	PZ1500/54	PZ1500/80	
PZ1500/22	PZ1500/42	PZ1500/56	PZ1500/81	
	PZ1501/01	PZ1501/02	PZ1504/01	



# *Ceramic backing weld metal supports*

## **Rektangulární typy**

**Rektangulární typy** jsou konstruovány pro struskotvorné přídavné materiály.

Jsou dodávány jako:

- volné kusy.
- bloky upevněné v kovové kolejnici pro svary na rovných konstrukcích.
- bloky nalepené na hliníkové pásce nebo navlečené na drátě.



# *Ceramic backing weld metal supports*

## **Konkávni typy**

**Konkávni typy** jsou konstruovány pro materiály tvořící malé nebo žádné množství strusky jako jsou plné dráty nebo basické či kovové plněné elektrody

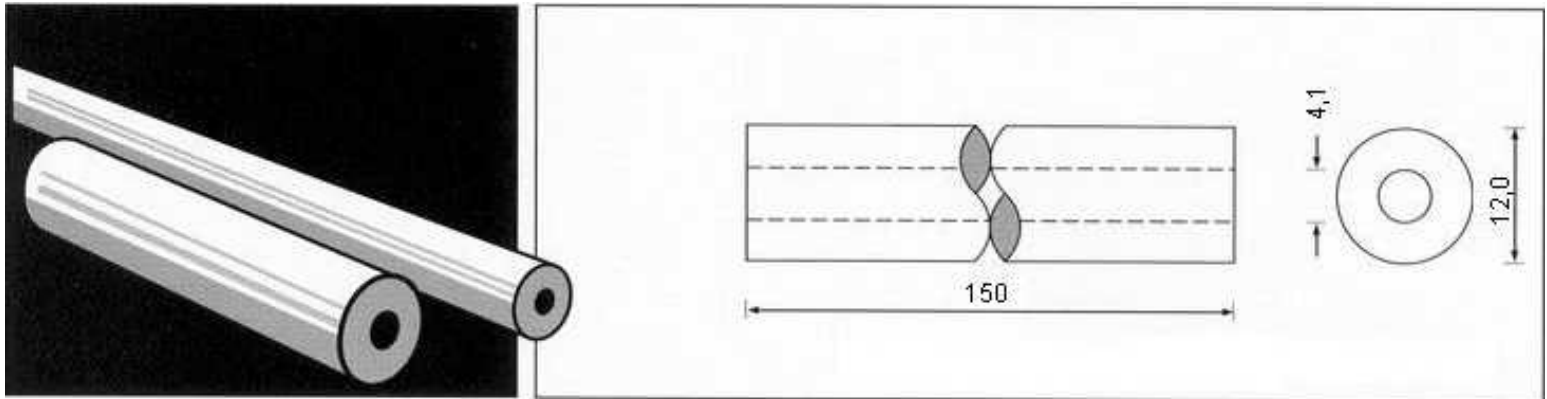
Jsou dodávány jako:

- volné kusy.
- bloky upevněné v kovové kolejnici pro svary na rovných konstrukcích.
- bloky nalepené na hliníkové pásce nebo navlečené na drátě.



# Ceramic backing weld metal supports

## PZ1500/01



Gin. no.	Colour	Shape	Assembly	Length mm
2150001000	Brown	Round	Loose blocks	150

per box		per pallet		
pcs	kg	box's	pcs	kg
200	7	48	9 600	336

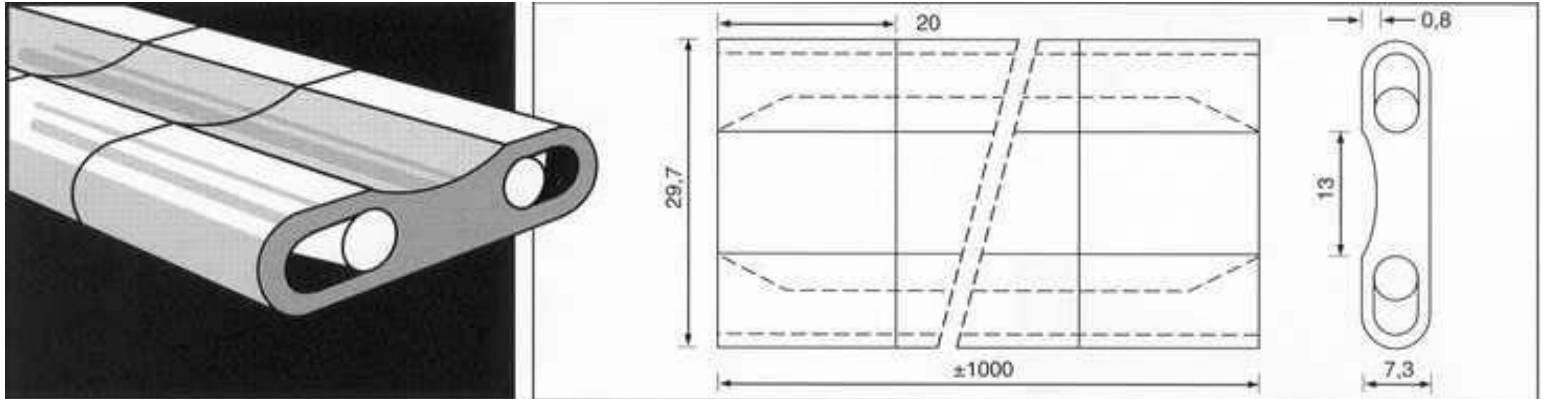
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# Ceramic backing weld metal supports

## PZ1500/02



Gin. no.	Colour	Shape	Assembly	Length mm
2150002000	Brown	Concave	On wire	1000 (50x20)

per box		box's	per pallet	
pcs	kg		pcs	kg
24	11	36	864	396

APPLICATION



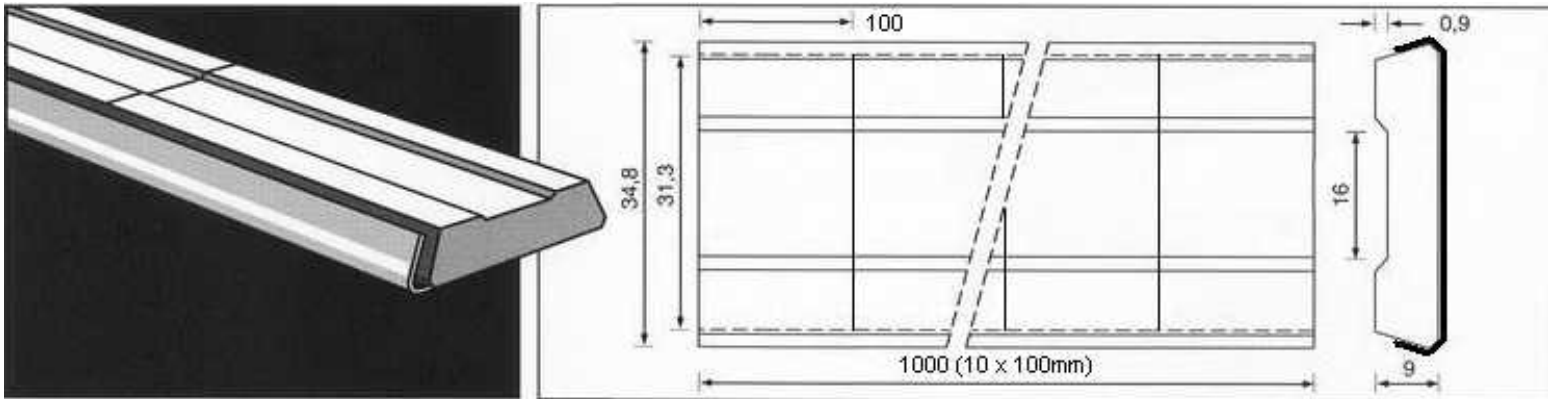
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# Ceramic backing weld metal supports

## PZ1500/03



Gin. no.	Colour	Shape	Assembly	Length mm
2150003000	Brown	Rectangular	In metal rail	1000 (10x100)

per box		box's	per pallet	
pcs	kg		pcs	kg
21	15	30	630	450

APPLICATION

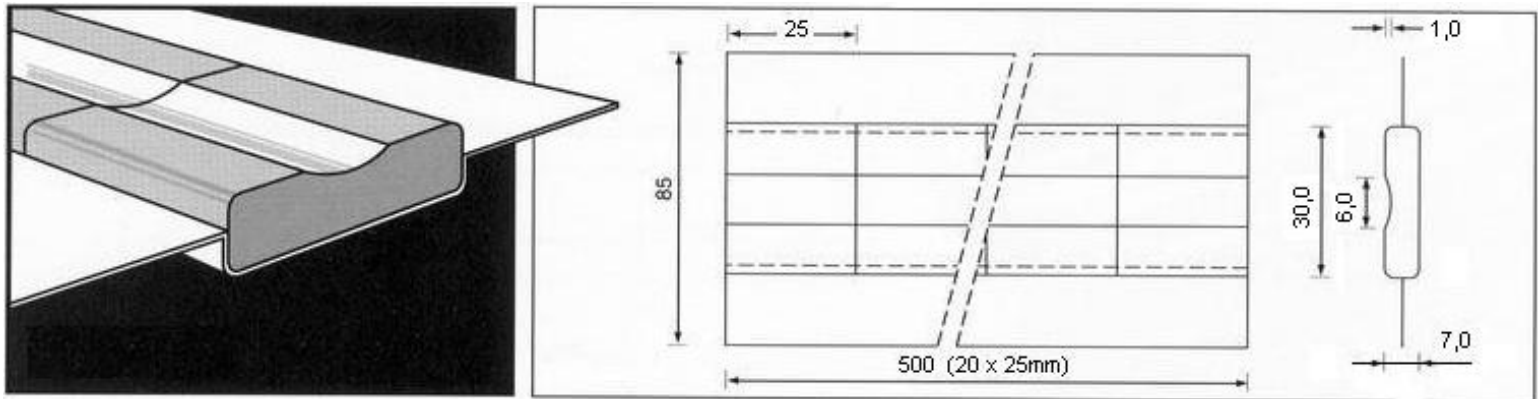


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# Ceramic backing weld metal supports

## PZ1500/07



Gin. no.	Colour	Shape	Assembly	Length
				mm
2150007000	Brown	Concave	On adhesive tape	500 (20X25)

per box		per pallet		
pcs	kg	box's	pcs	kg
48	10	42	2 016	420

APPLICATION

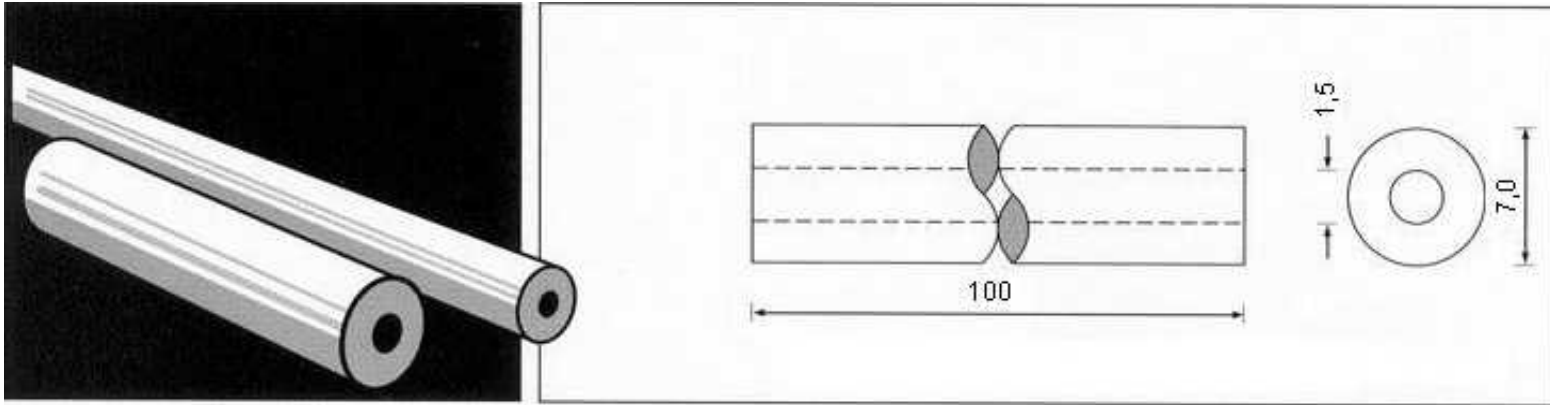


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# Ceramic backing weld metal supports

## PZ1500/08



Gin. no.	Colour	Shape	Assembly	Length mm
2150008000	Brown	Round	Loose blocks	100

per box		per pallet		
pcs	kg	box's	pcs	kg
900	8	48	43 200	360

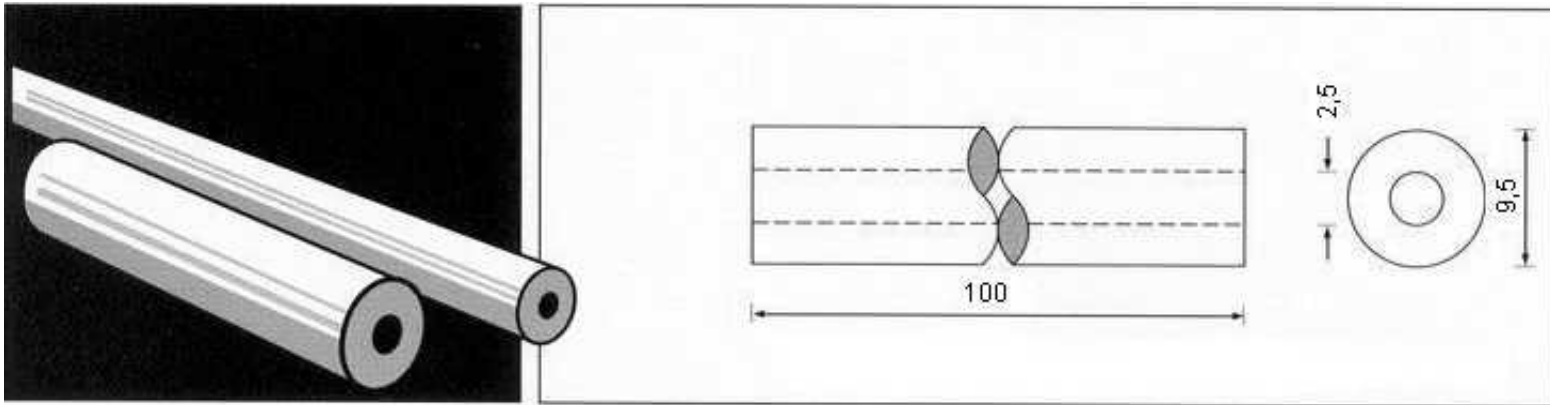
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# Ceramic backing weld metal supports

## PZ1500/17



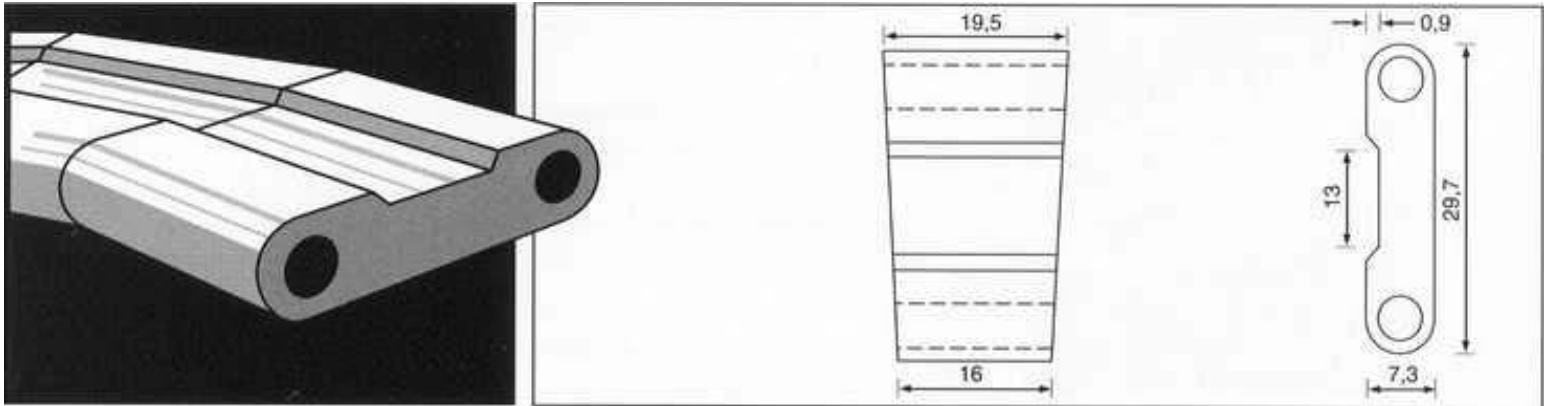
Gin. no.	Colour	Shape	Assembly	Length mm
2150017000	Brown	Round	Loose blocks	100

per box		per pallet		
pcs	kg	box's	pcs	kg
520	8	48	24 960	360

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/22



Gin. no.	Colour	Shape	Assembly	Length mm
2150022000	Brown	curved ceramics	Loose blocks	R=150

per box		box's	per pallet	
pcs	kg		pcs	kg
1 000	8	48	48 000	360

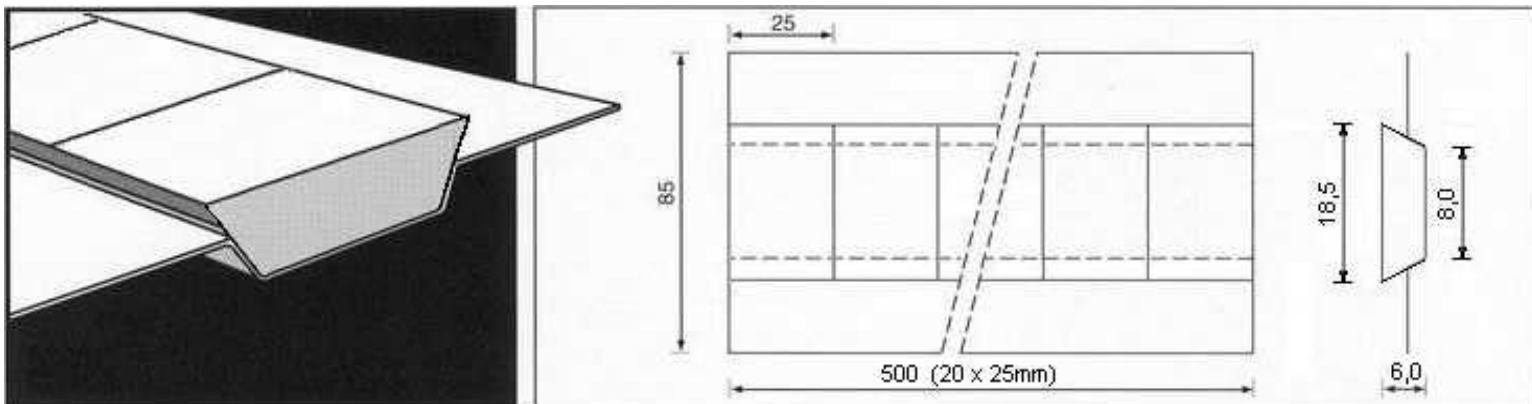
APPLICATION

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# Ceramic backing weld metal supports

## PZ1500/24



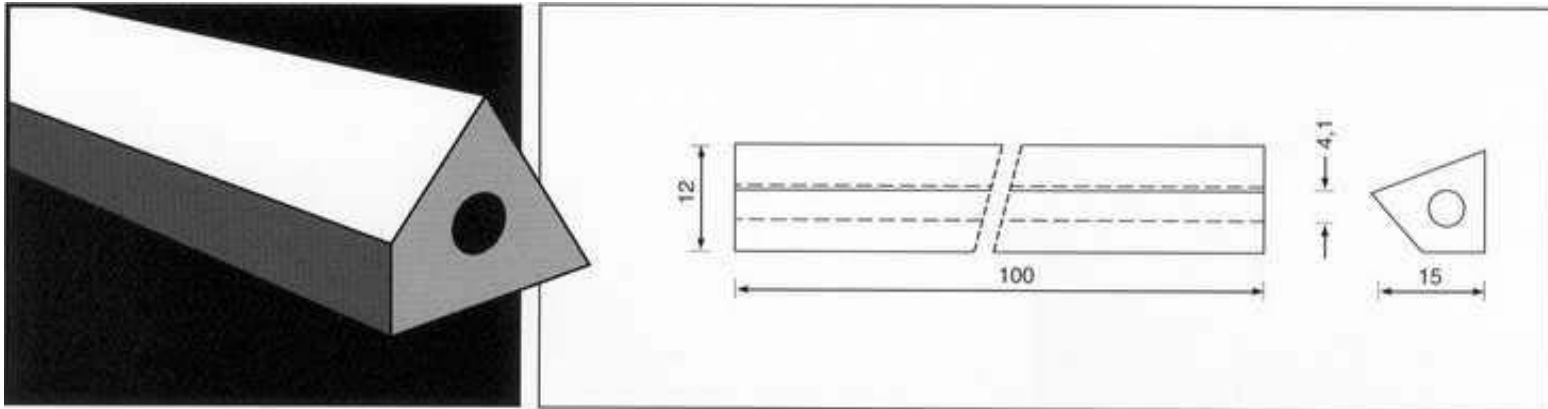
Gin. no.	Colour	Shape	Assembly	Length mm
2150024000	Grey	Special	On adhesive tape	500 (20x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
70	9	42	3 780	462

A P P L I C A T I O N

# Ceramic backing weld metal supports

## PZ1500/25



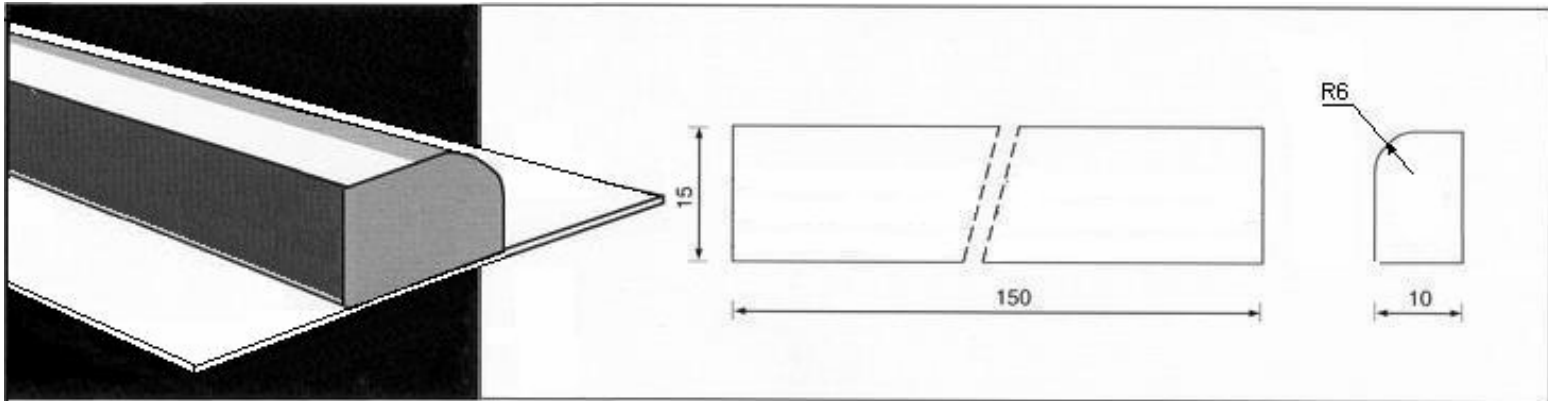
Gin. no.	Colour	Shape	Assembly	Length mm
2150025000	Brown	Special	Loose blocks	100

per box		per pallet		
pcs	kg	box's	pcs	kg
450	10	48	21 600	480

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# Ceramic backing weld metal supports

## PZ1500/29



Gin. no.	Colour	Shape	Assembly	Length mm
2150029000	Grey	Special	On adhesive tape	500 (20x25)

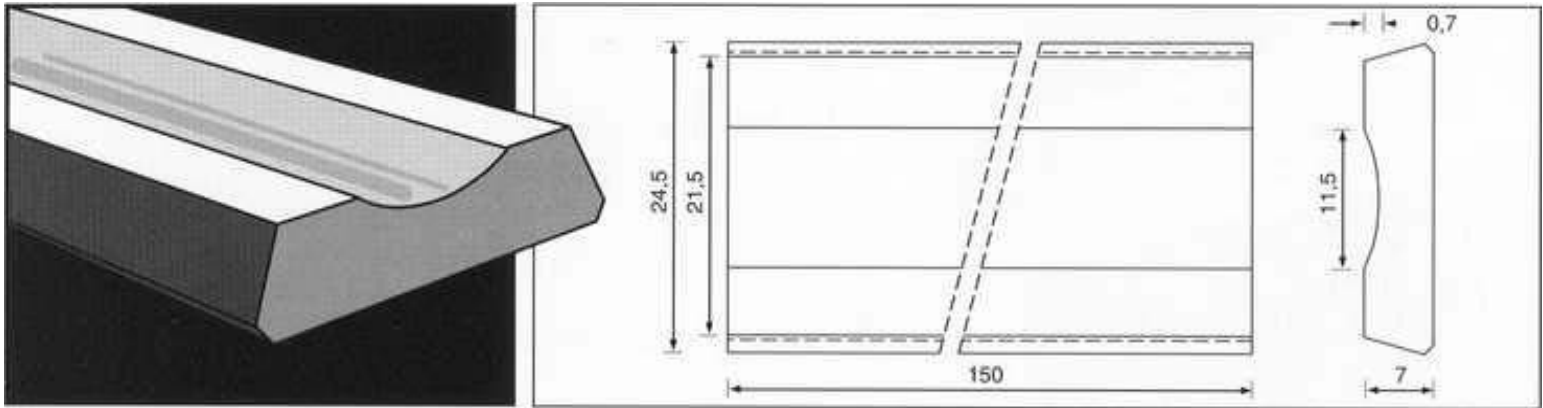
per box		per pallet		
pcs	kg	box's	pcs	kg
48	9	42	2 016	378

APPLICATION



# Ceramic backing weld metal supports

## PZ1500/30



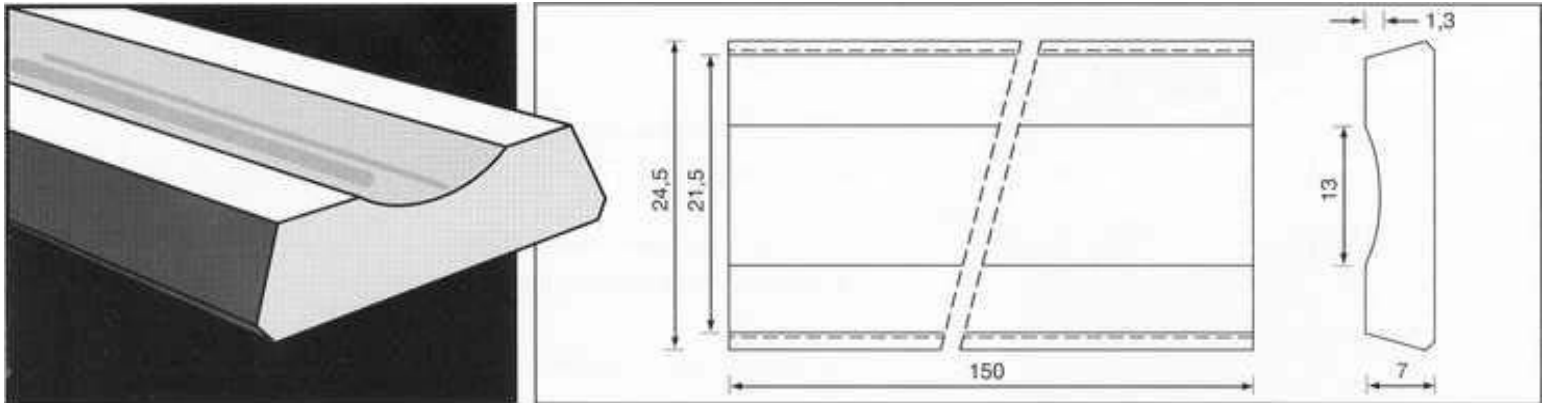
Gin. no.	Colour	Shape	Assembly	Length mm
2150030000	Brown	Concave	Loose blocks	150

per box		per pallet		
pcs	kg	box's	pcs	kg
175	9	48	8 400	432

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# Ceramic backing weld metal supports

## PZ1500/32



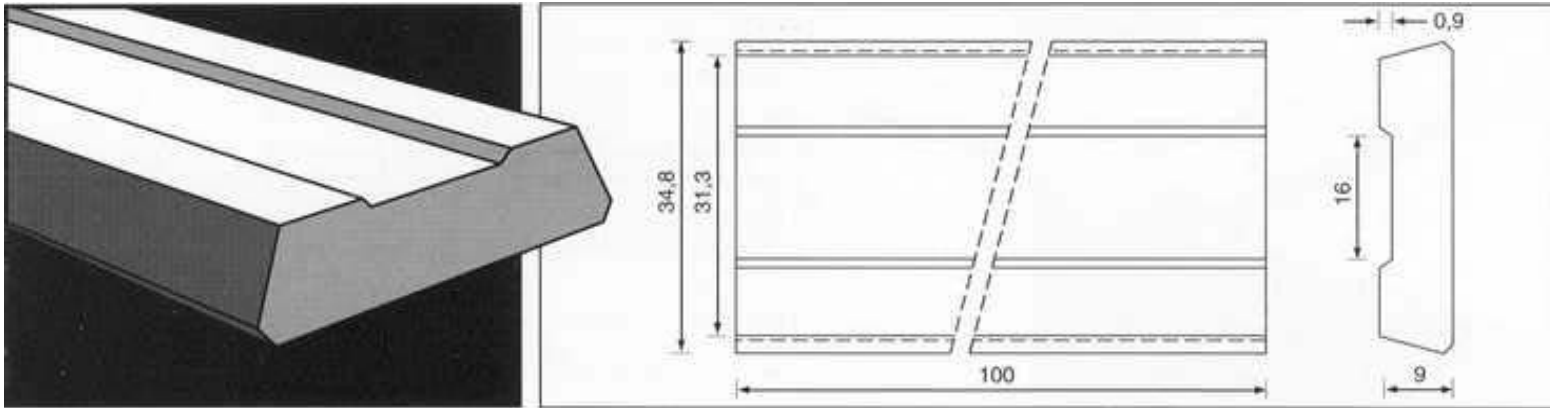
Gin. no.	Colour	Shape	Assembly	Length mm
2150032000	Grey	Concave	Loose blocks	150

per box		per pallet		
pcs	kg	box's	pcs	kg
175	10	48	8 400	480

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# Ceramic backing weld metal supports

## PZ1500/33



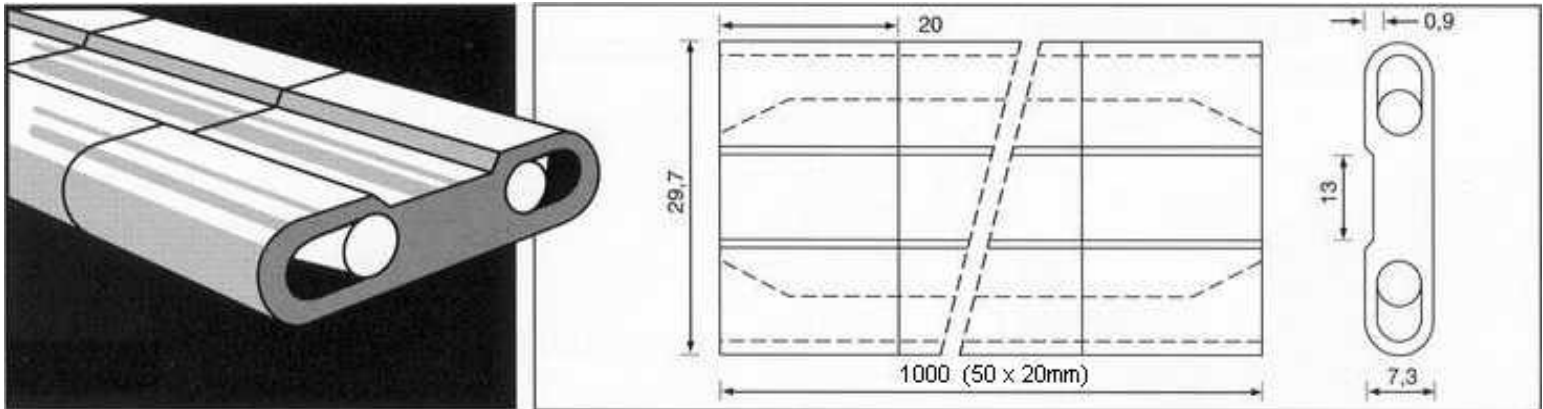
Gin. no.	Colour	Shape	Assembly	Length mm
2150033000	Grey	Rectangular	Loose blocks	100

per box		per pallet		
pcs	kg	box's	pcs	kg
160	12	48	7 680	576

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# Ceramic backing weld metal supports

## PZ1500/42



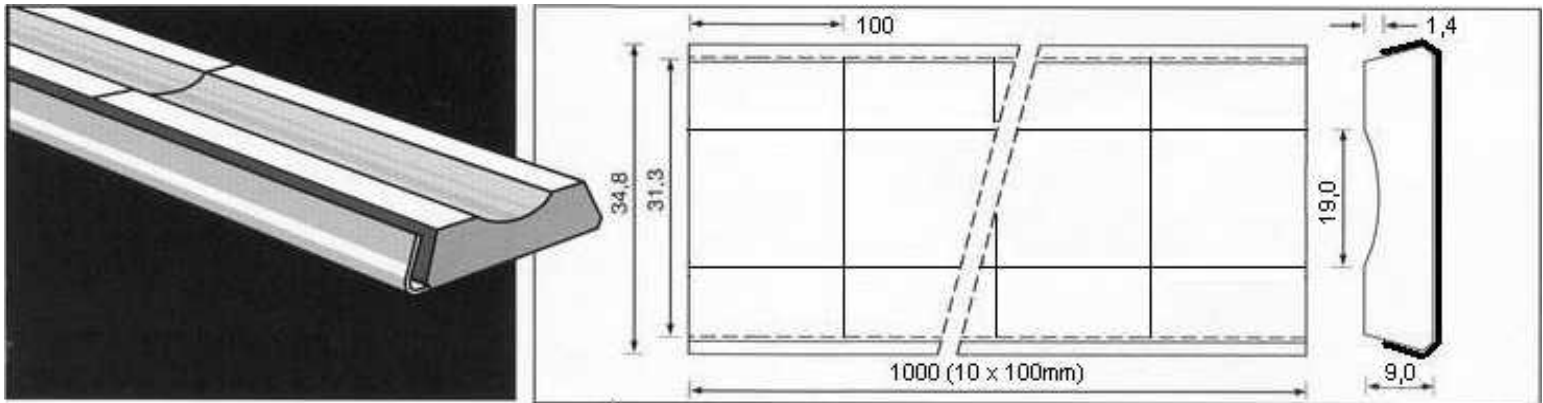
Gin. no.	Colour	Shape	Assembly	Length mm
2150042000	Brown	Rectangular	On wire	1000 (50x20)

per box		box's	per pallet	
pcs	kg		pcs	kg
24	11	36	864	396

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/44



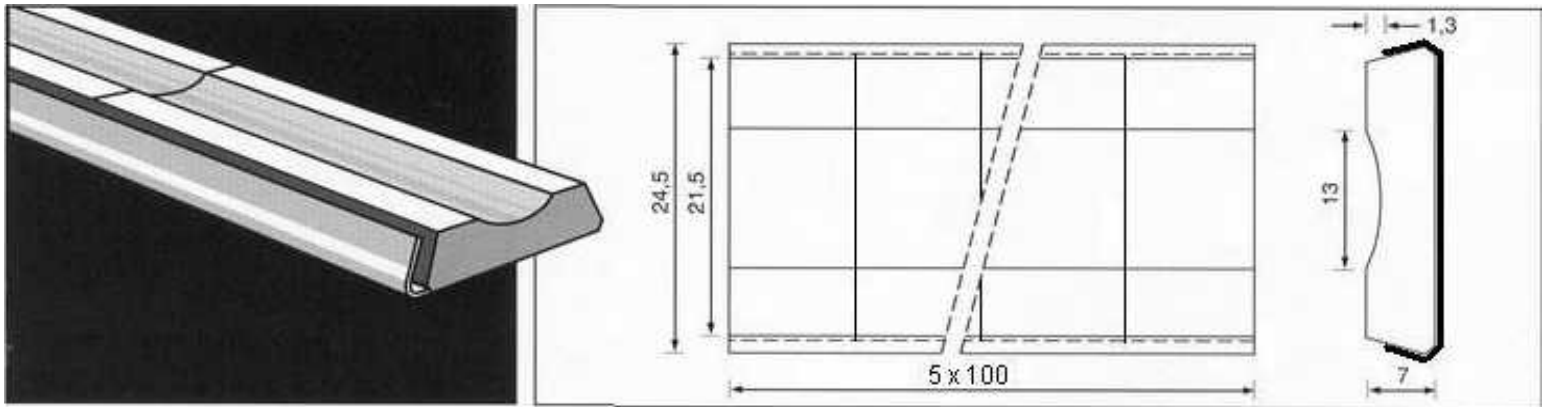
Gin. no.	Colour	Shape	Assembly	Length mm
2150044000	Brown	Concave	In metal rail	500 (5x100)

per box		per pallet		
pcs	kg	box's	pcs	kg
35	14	42	1 470	567

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/48



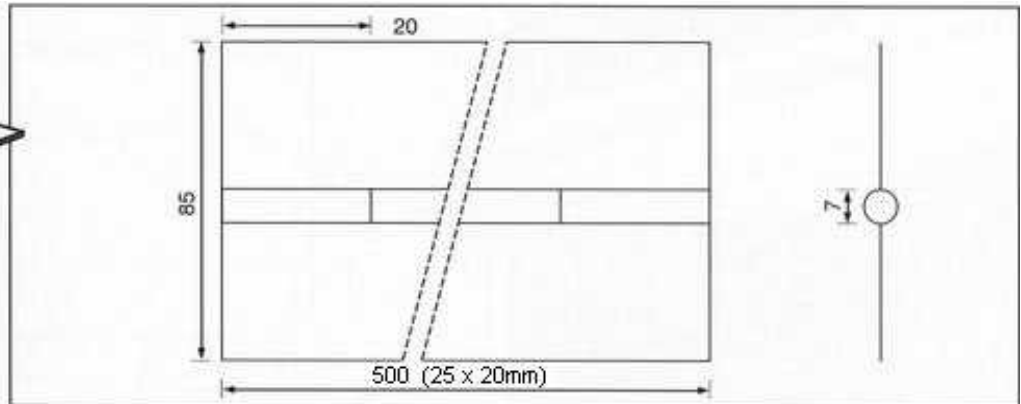
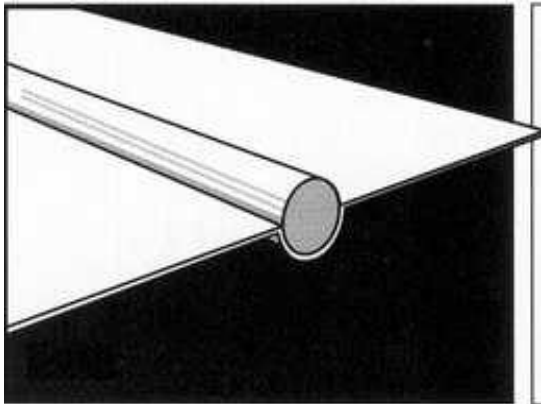
Gin. no.	Colour	Shape	Assembly	Length mm
2150048000	Grey	Concave	In metal rail	500 (5x100)

per box		per pallet		
pcs	kg	box's	pcs	kg
63	17	42	2 646	714

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/50



Gin. no.	Colour	Shape	Assembly	Length mm
2150050000	Brown	Round	On adhesive tape	500 (25x20)

per box		per pallet		
pcs	kg	box's	pcs	kg
100	5	42	4 200	210

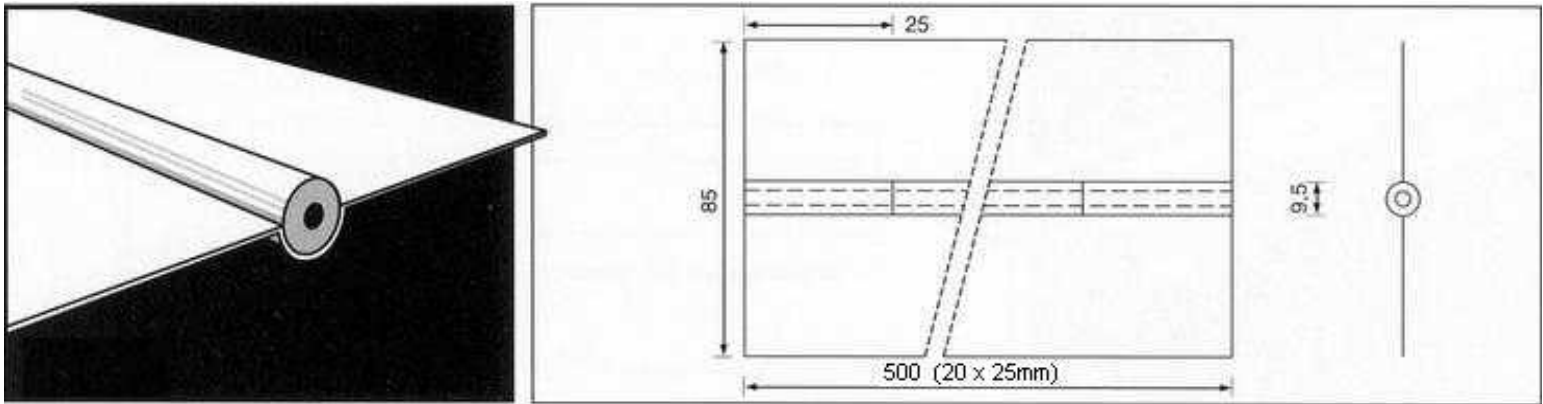
APPLICATION

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# Ceramic backing weld metal supports

## PZ1500/51



Gin. no.	Colour	Shape	Assembly	Length mm
2150051000	Brown	Round	On adhesive tape	500 (20x25)

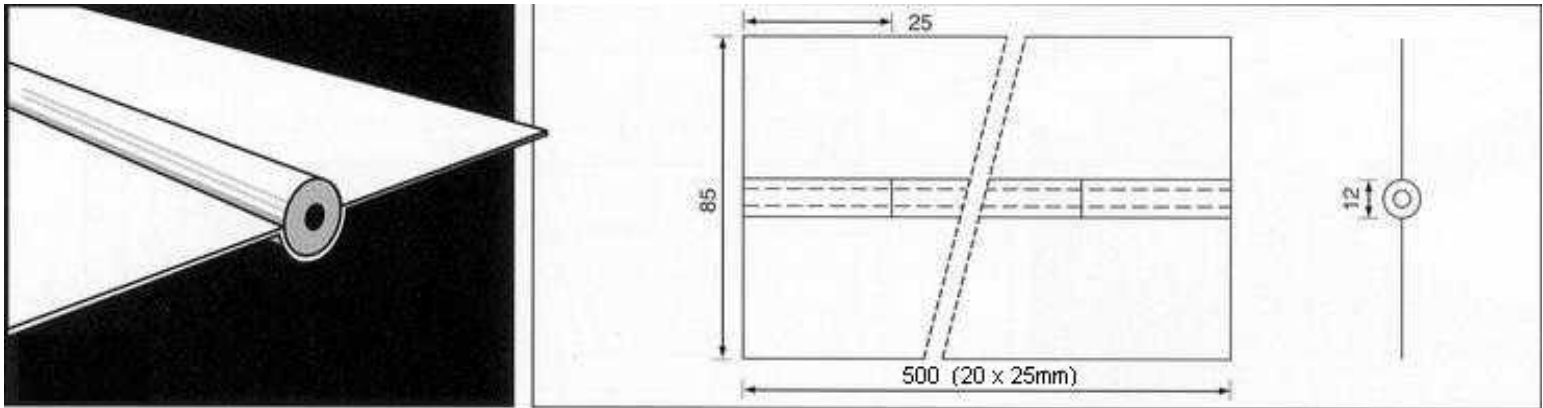
per box		per pallet		
pcs	kg	box's	pcs	kg
72	7	42	3 024	273

APPLICATION



# Ceramic backing weld metal supports

## PZ1500/52



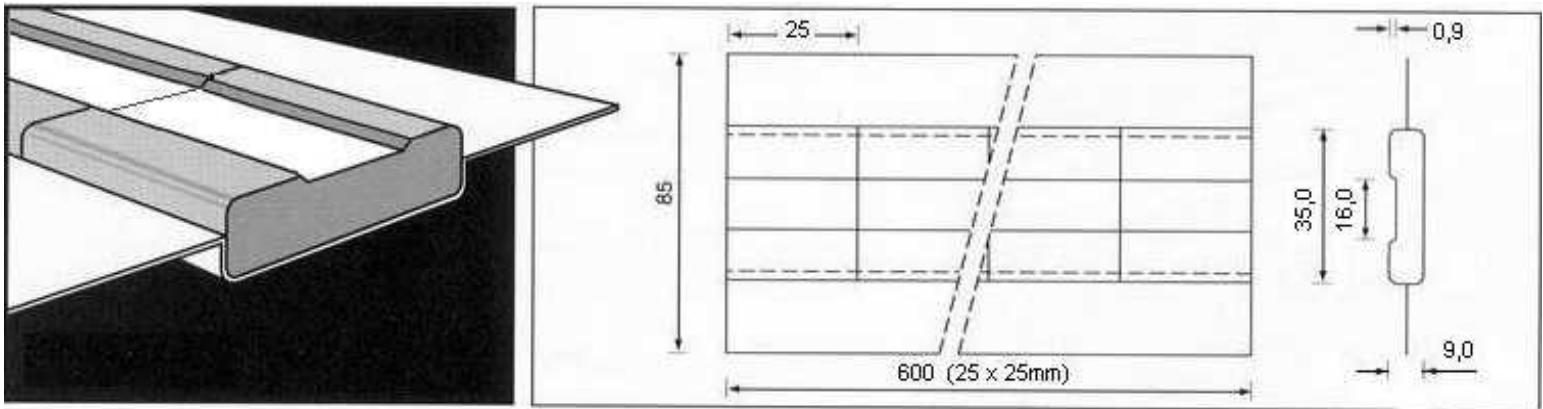
Gin. no.	Colour	Shape	Assembly	Length mm
2150052000	Brown	Round	On adhesive tape	500 (20x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
56	8	42	2 352	336

A P P L I C A T I O N

# Ceramic backing weld metal supports

## PZ1500/54



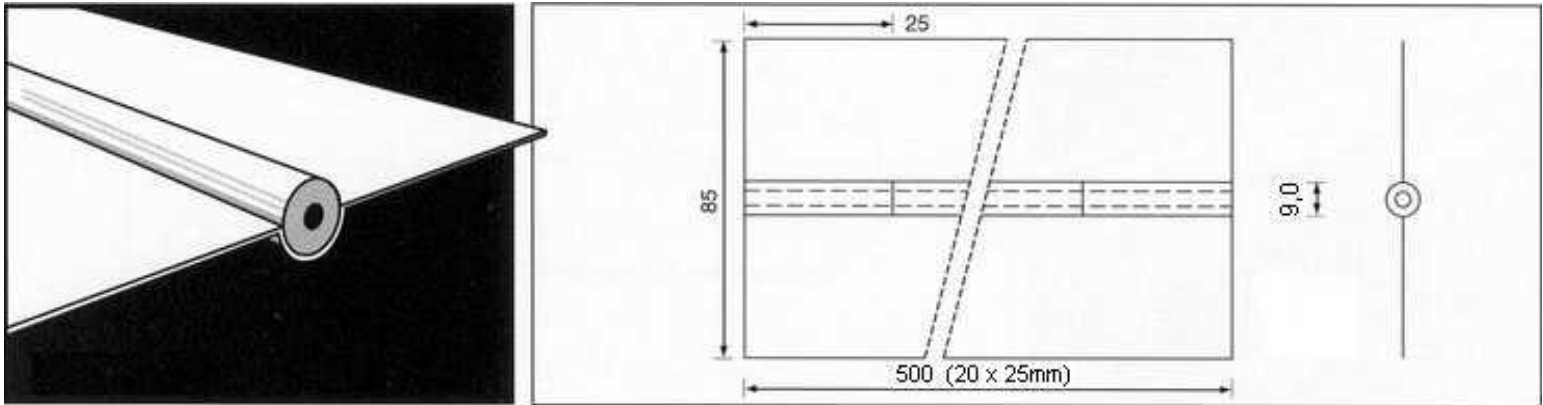
Gin. no.	Colour	Shape	Assembly	Length mm
2150054000	Grey	Rectangular	On adhesive tape	600 (24x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
30	14	35	1 050	473

A P P L I C A T I O N

# Ceramic backing weld metal supports

## PZ1500/56



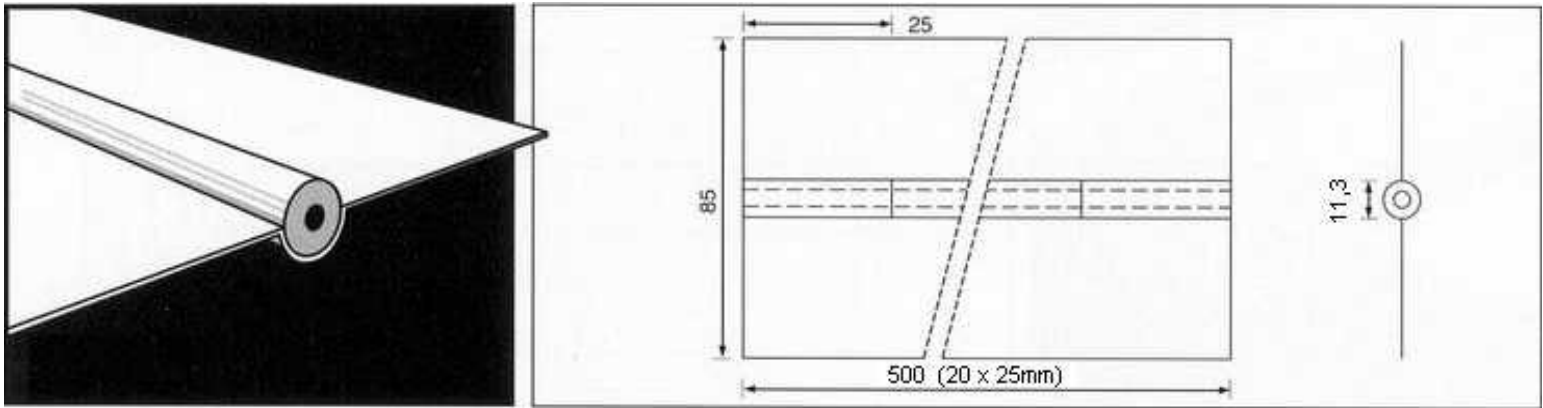
Gin. no.	Colour	Shape	Assembly	Length mm
2150056000	Grey	Round	On adhesive tape	500 (20x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
72	7	42	3 024	294

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/57



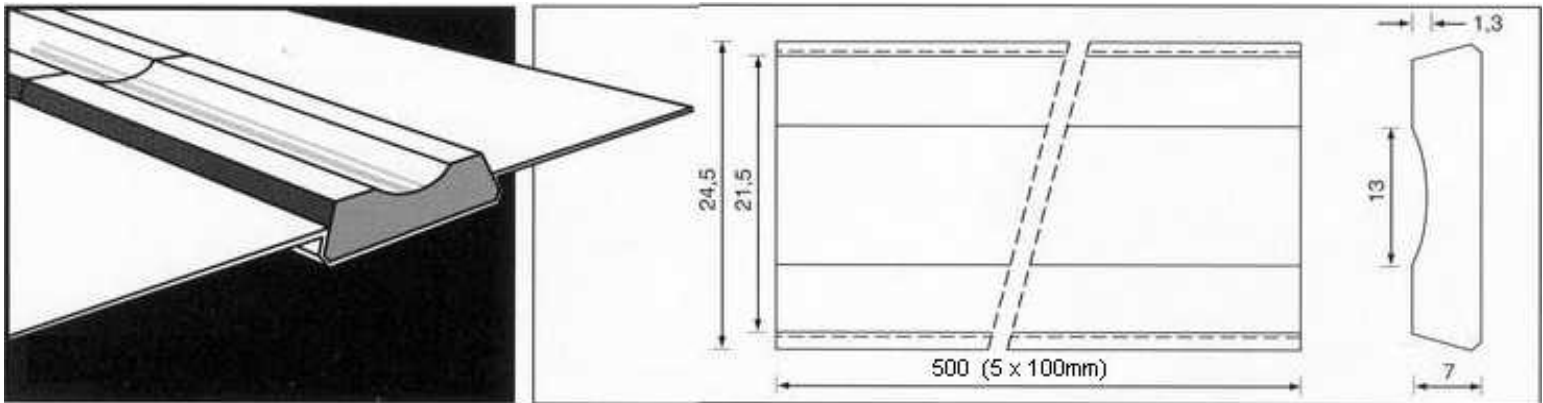
Gin. no.	Colour	Shape	Assembly	Length mm
2150057000	Grey	Round	On adhesive tape	500 (20x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
60	9	42	2 520	378

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# Ceramic backing weld metal supports

## PZ1500/70



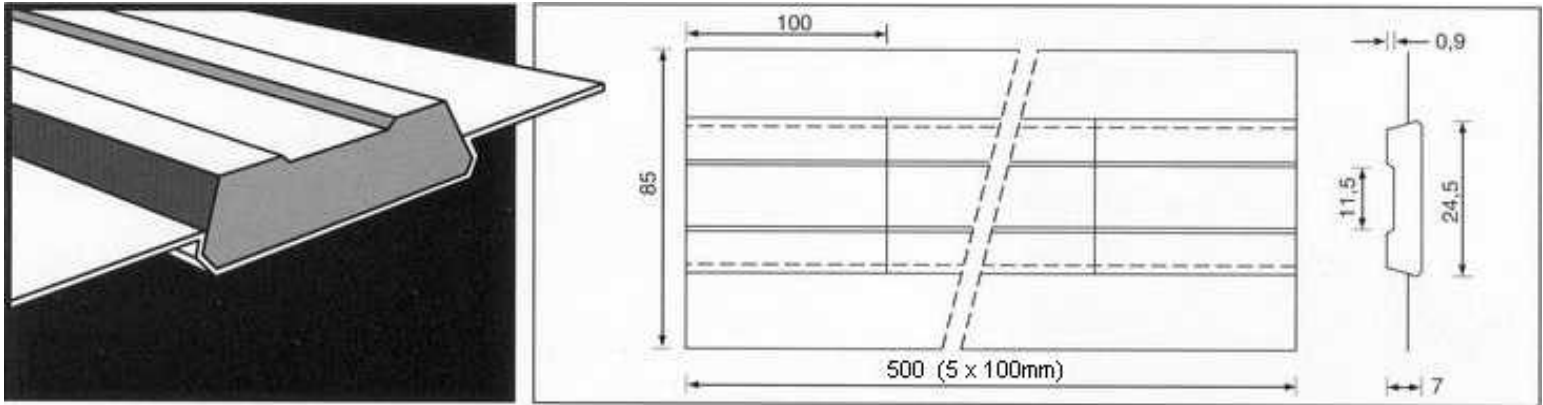
Gin. no.	Colour	Shape	Assembly	Length mm
2150070000	Grey	Concave	On adhesive tape	500 (5x100)

per box		per pallet		
pcs	kg	box's	pcs	kg
56	11	42	2 352	462

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/71



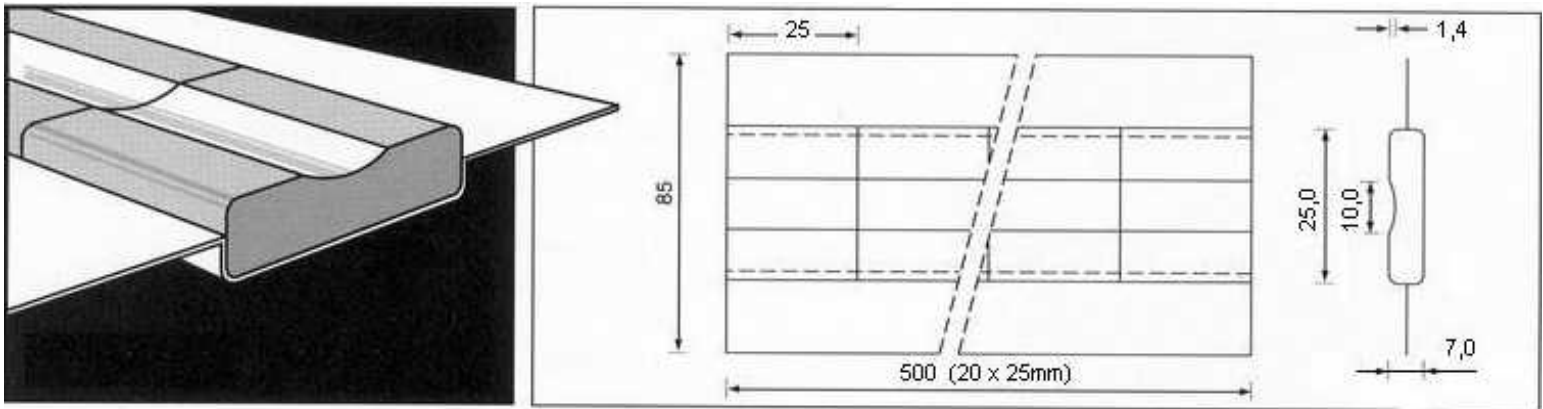
Gin. no.	Colour	Shape	Assembly	Length mm
2150071000	Grey	Rectangular	On adhesive tape	500 (5x100)

per box		per pallet		
pcs	kg	box's	pcs	kg
56	11	42	2 352	462

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/72



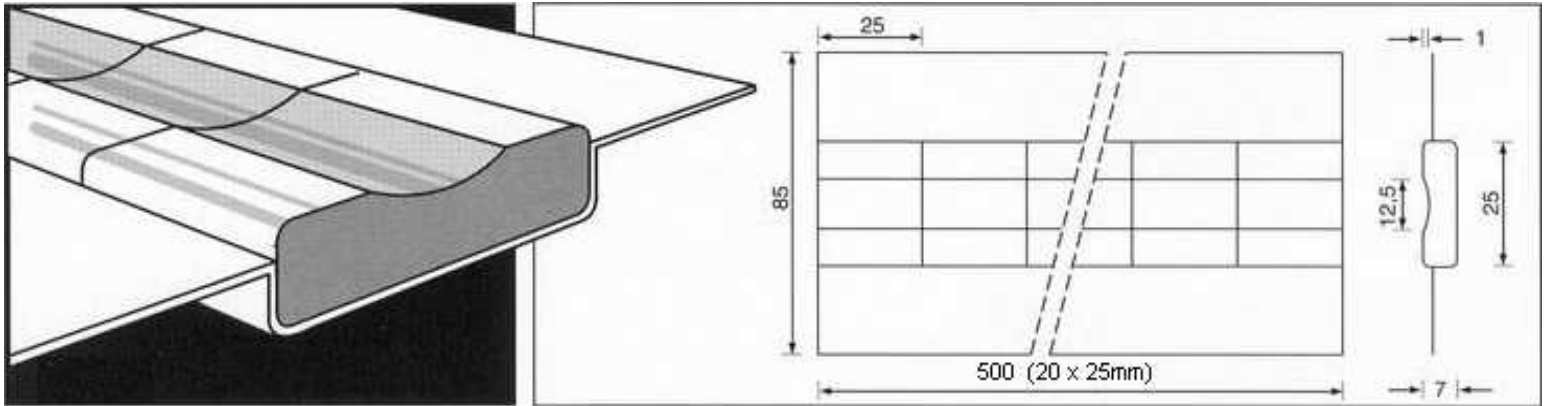
Gin. no.	Colour	Shape	Assembly	Length mm
2150072000	Grey	Concave	On adhesive tape	500 (20x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
56	13	42	2 352	546

APPLICATION

# Ceramic backing weld metal supports

## PZ1500/73



Gin. no.	Colour	Shape	Assembly	Length mm
2150073000	Brown	Concave	On adhesive tape	500 (20x25)

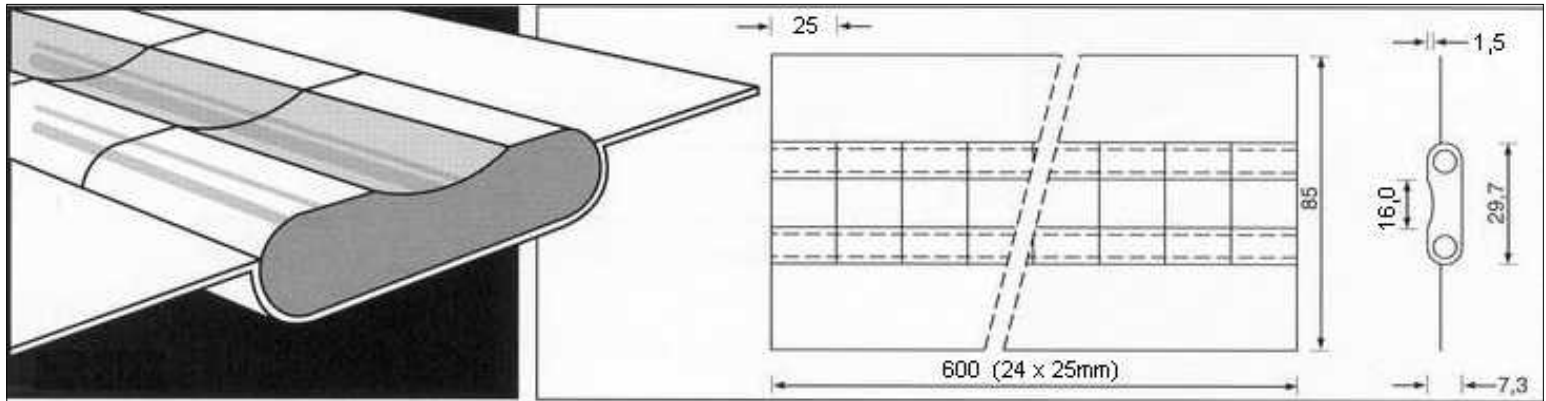
per box		per pallet		
pcs	kg	box's	pcs	kg
56	10	42	2 352	420

APPLICATION



# Ceramic backing weld metal supports

## PZ1500/80



Gin. no.	Colour	Shape	Assembly	Length mm
2150080600	Grey	Concave	On adhesive tape	600 (24x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
48	15	35	1 680	525

A P P L I C A T I O N

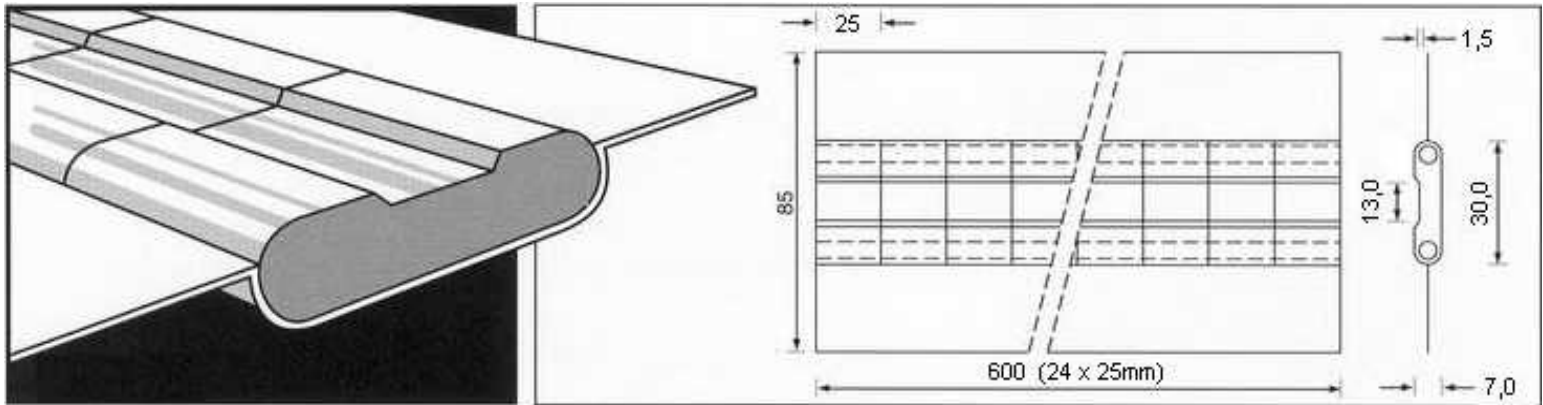


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# Ceramic backing weld metal supports

## PZ1500/81



Gin. no.	Colour	Shape	Assembly	Length mm
2150081600	Grey	Rectangular	On adhesive tape	600 (24x25)

per box		per pallet		
pcs	kg	box's	pcs	kg
48	15	35	1 680	525

APPLICATION

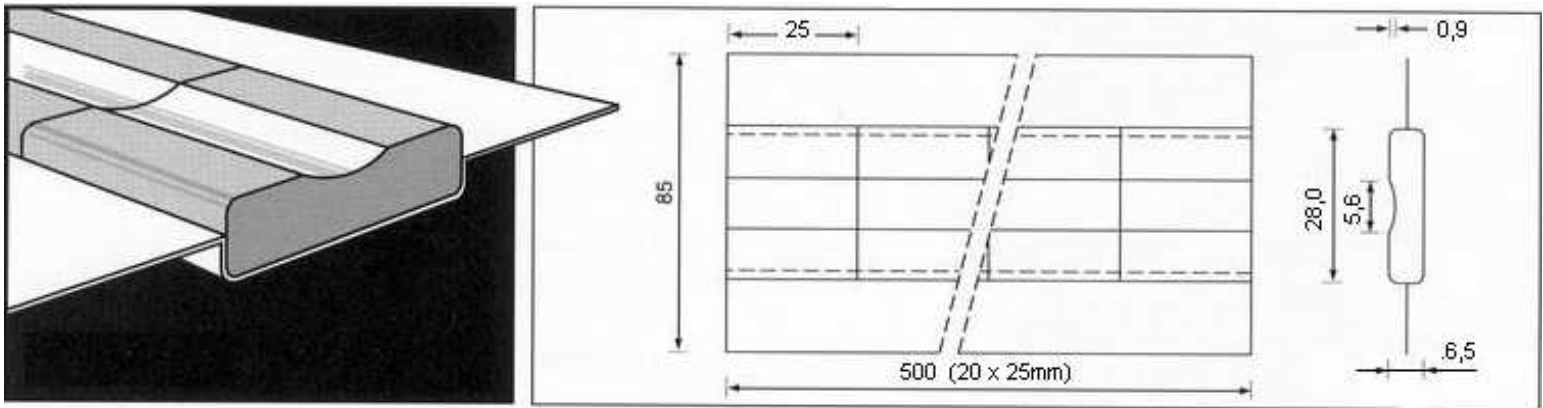


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# Ceramic backing weld metal supports

## PZ1500/87



Gin. no.	Colour	Shape	Assembly	Length mm
2150087000	Grey	Concave	On adhesive tape	500 (20x25)

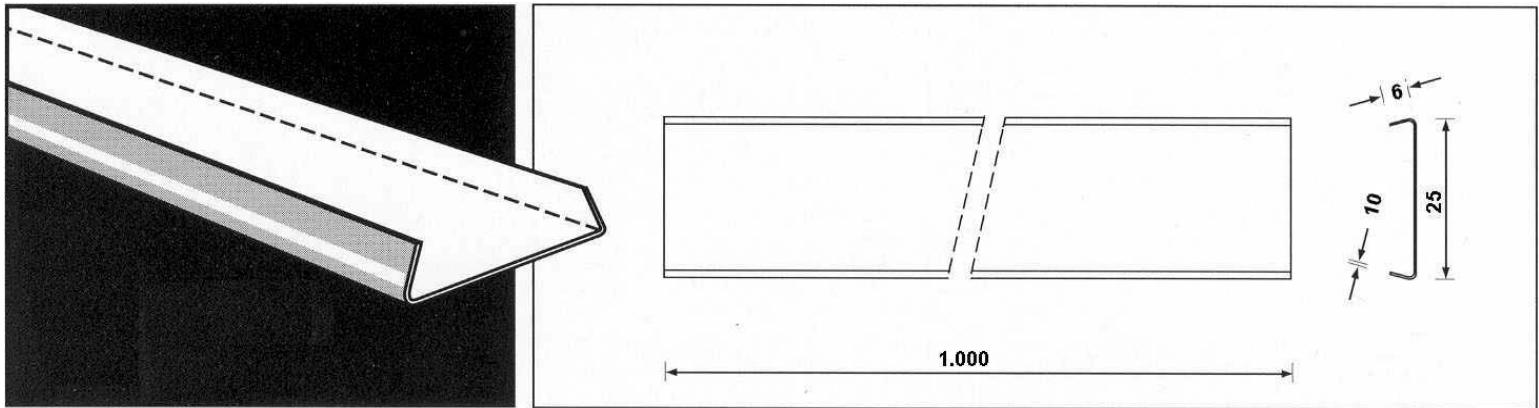
per box		per pallet		
pcs	kg	box's	pcs	kg
54	13	42	2 268	525

APPLICATION



# Ceramic backing weld metal supports

## PZ1501/01



Gin. no.	Colour	Shape	Assembly	Length mm
2150101000	none	0	Metal rails	1000

per box		per pallet		
pcs	kg	box's	pcs	kg
48	15	30	1 440	450

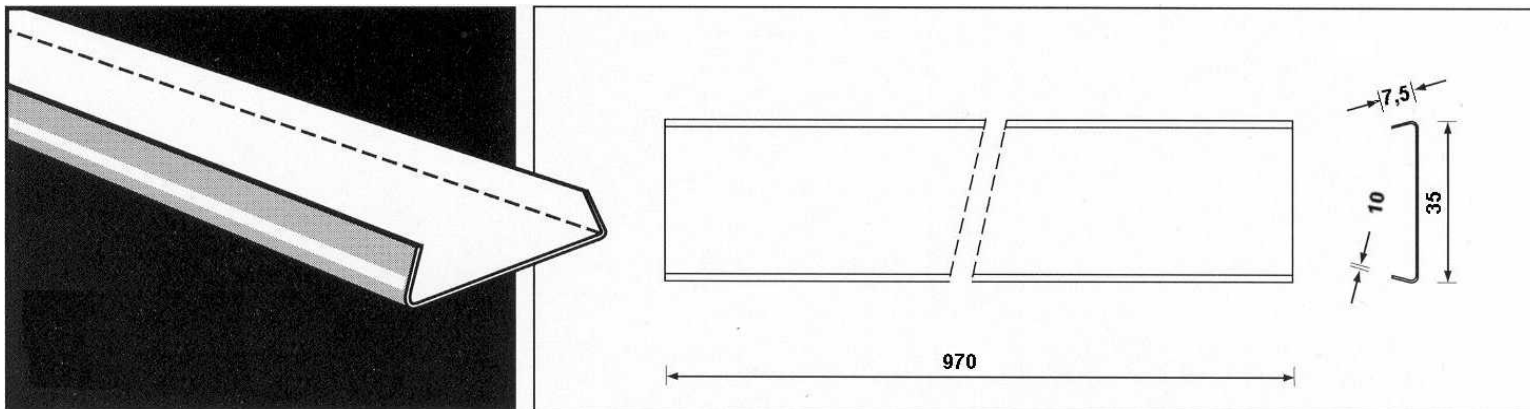
APPLICATION

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# Ceramic backing weld metal supports

## PZ1501/02



Gin. no.	Colour	Shape	Assembly	Length mm
2150102000	none	0	Metal rails	970

per box		box's	per pallet	
pcs	kg		pcs	kg
38	8	30	1 140	225

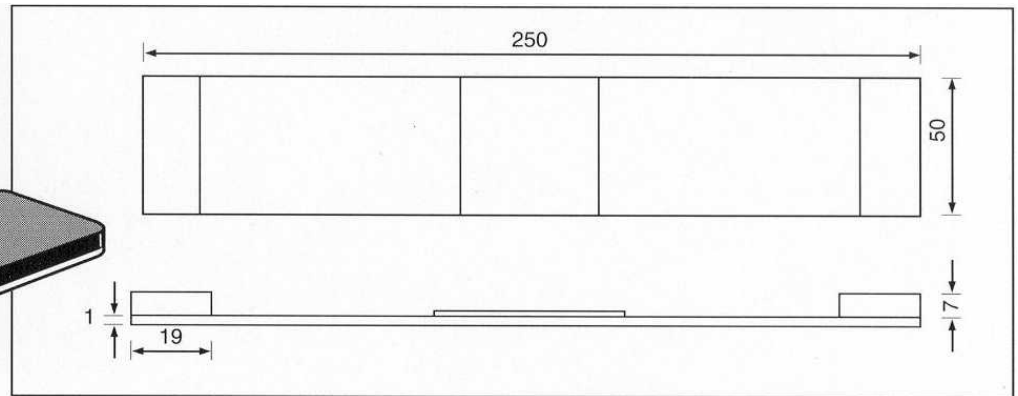
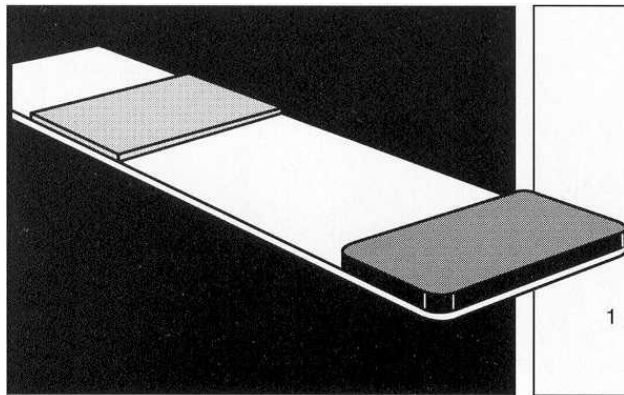
APPLICATION

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# Ceramic backing weld metal supports

## PZ1504/01



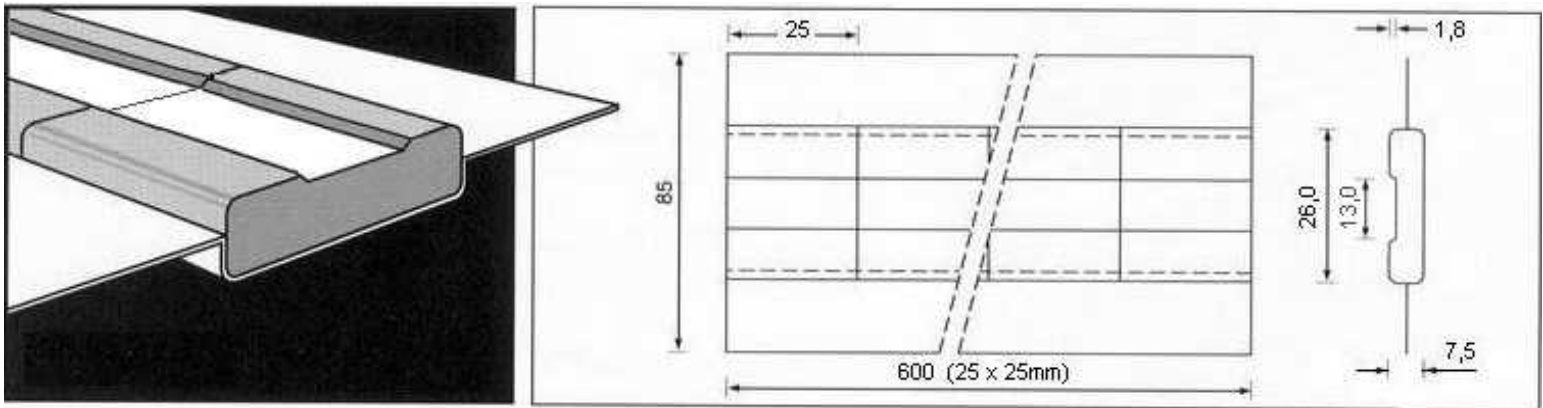
Gin. no.	Colour	Shape	Assembly	Length mm
2150401000	none	0	Magnetic clamp	250

per box		box's	per pallet	
pcs	kg		pcs	kg
66	10	48	3 168	480

APPLICATION

# Ceramic backing weld metal supports

## OK Backing Rectangular 13



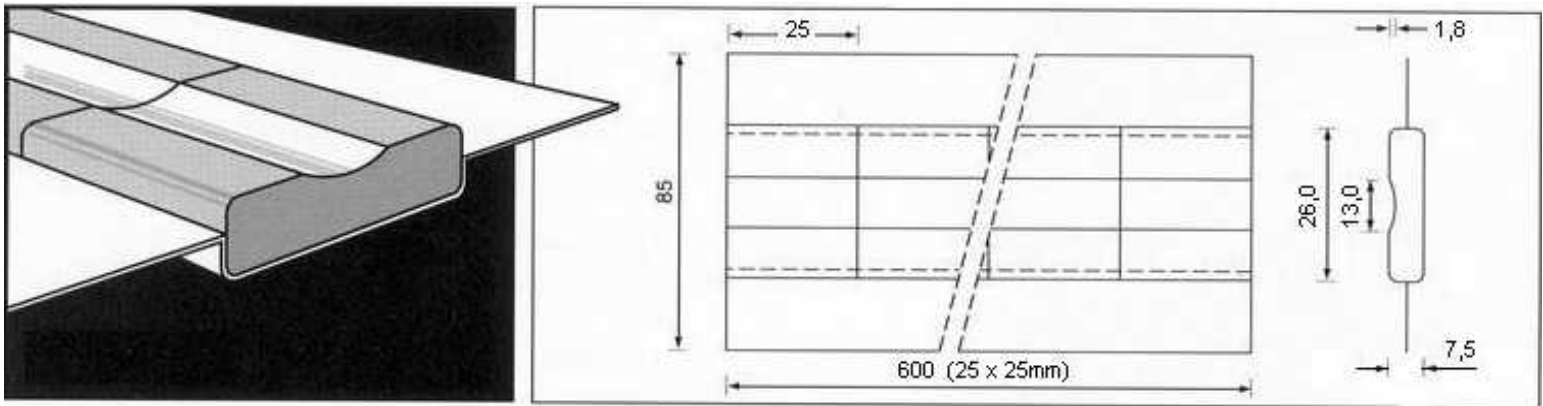
Gin. no.	Colour	Shape	Assembly	Length mm
2124000R13	Brown	Rectangular	On adhesive tape	600

per box		per pallet		
pcs	kg	box's	pcs	kg
56	13	35	1 960	470

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# Ceramic backing weld metal supports

## OK Backing Concave 13



Gin. no.	Colour	Shape	Assembly	Length mm
2124000C13	Brown	Concave	On adhesive tape	600 (24x25)

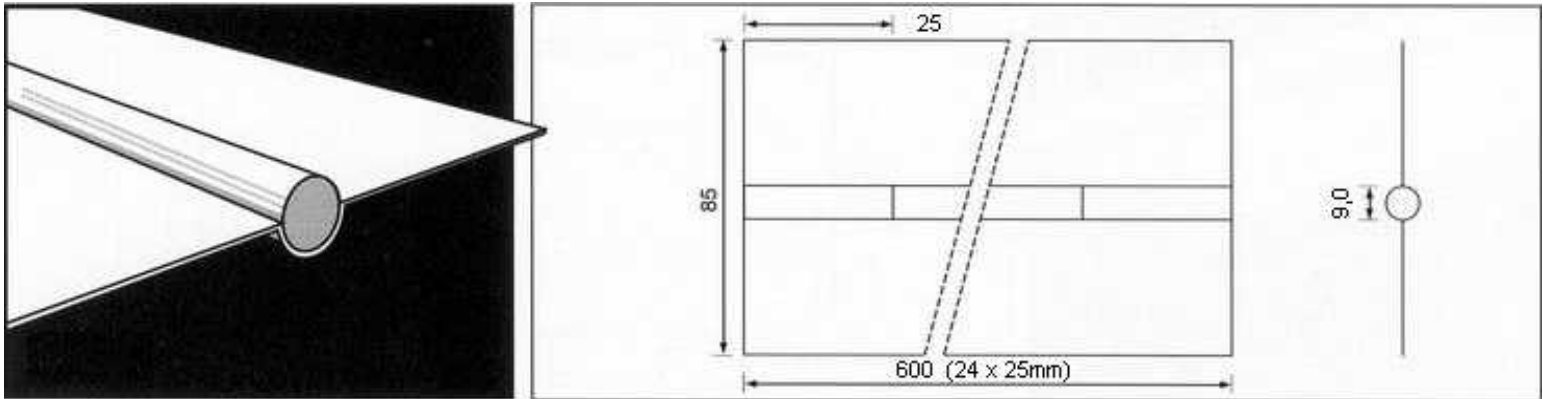
per box		box's	per pallet	
pcs	kg		pcs	kg
56	13	35	1 960	470

APPLICATION



# Ceramic backing weld metal supports

## OK Backing Pipe 9



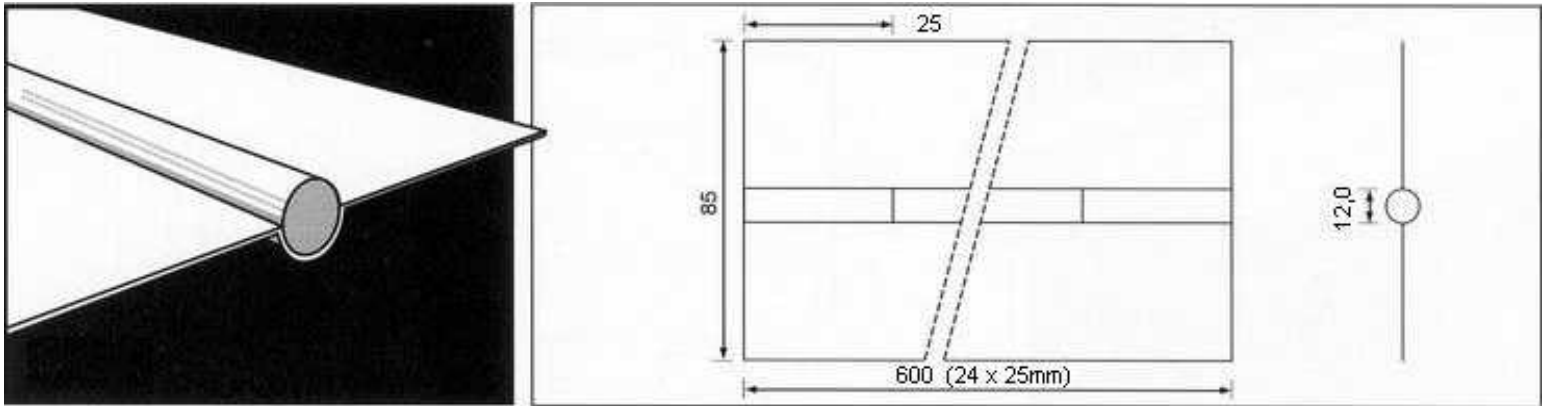
Gin. no.	Colour	Shape	Assembly	Length mm
2124000P09	Brown	Round	On adhesive tape	600

per box		per pallet		
pcs	kg	box's	pcs	kg
72	8	35	2 520	35

A P P L I C A T I O N

# Ceramic backing weld metal supports

## OK Backing Pipe 12



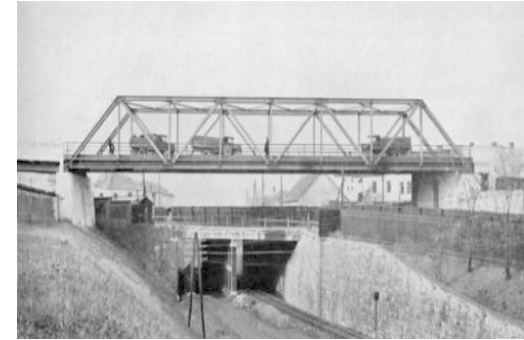
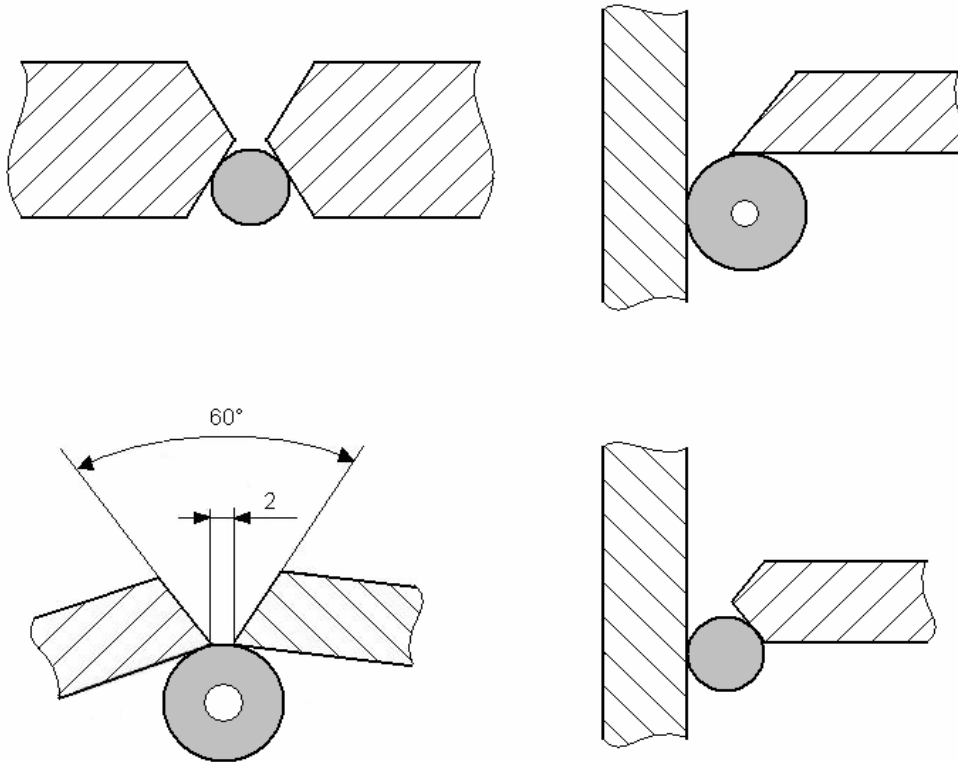
Gin. no.	Colour	Shape	Assembly	Length mm
2124000P12	Brown	Round	On adhesive tape	600

per box		per pallet		
pcs	kg	box's	pcs	kg
56	10	35	1 960	350

APPLICATION

# Ceramic backing weld metal supports

## Application for Round types



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# Ceramic backing weld metal supports

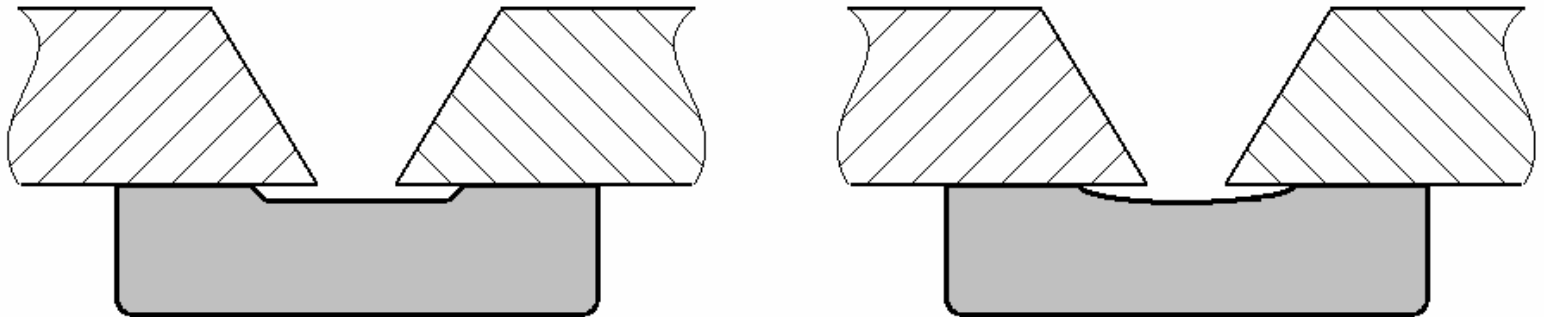


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# *Ceramic backing weld metal supports*

## **Application for Rectangular and Concave types**



# *Ceramic backing weld metal supports*



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# *Ceramic backing weld metal supports*



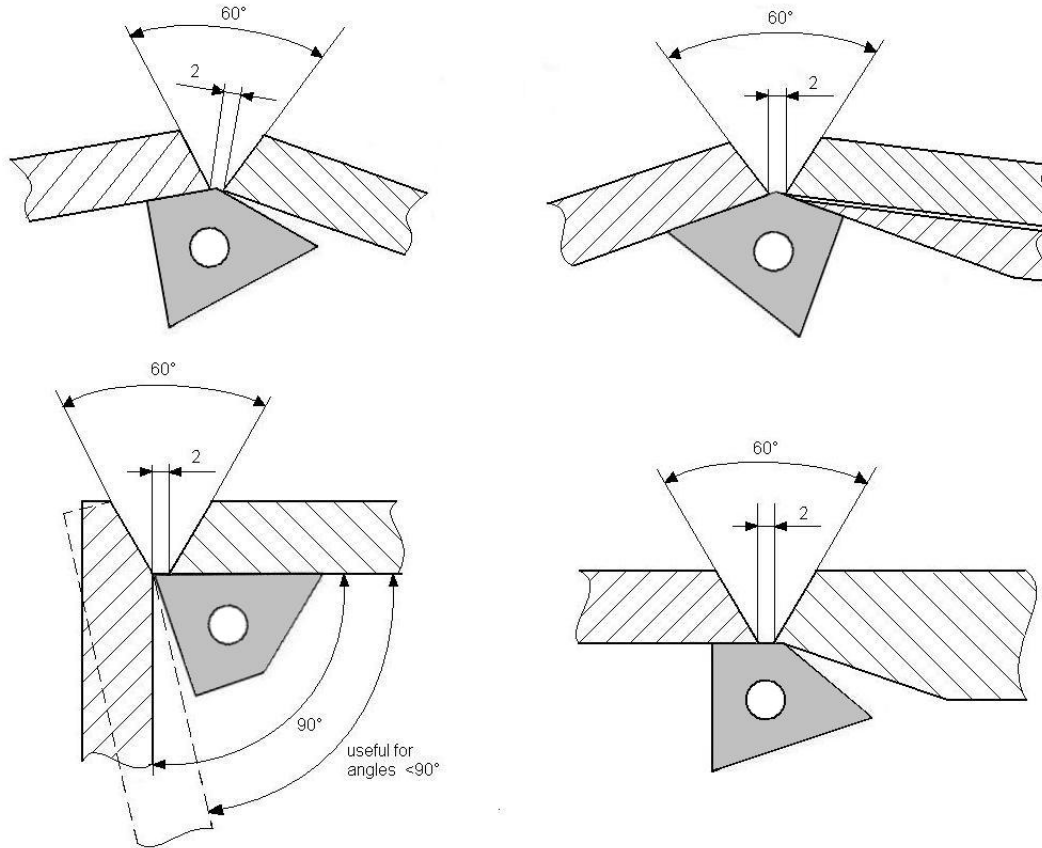
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ESAB 1904-2004  
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# Ceramic backing weld metal supports

## Application for Special type

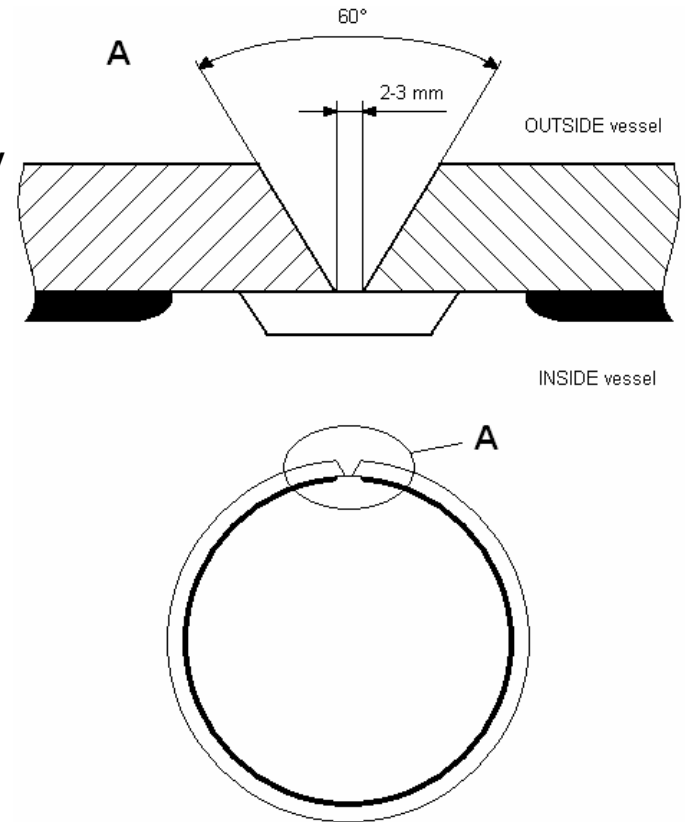




# Ceramic backing weld metal supports

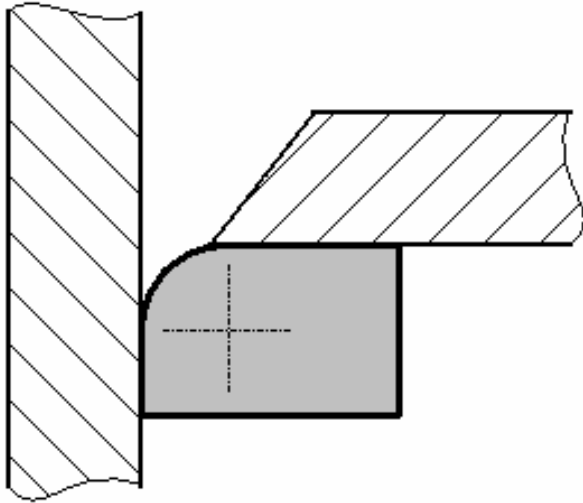
## Application for Special-Flat type

- Plochá podložka je použita pro dosažení co nejnižšího převýšení svaru z druhé strany z důvodu navařování vnitřku nádoby páskou.
- Kořen je vařen z vnějšku nádoby kovovou plněnou elektrodou.
- Svary jsou buď podélné s nádobou nebo ve šroubovici.
- Po svařování je podložka odstraněna a navařování páskou může být dokončeno v poloze PA.



# *Ceramic backing weld metal supports*

## **Application for Special-Flat type**



# Ceramic backing weld metal supports

Typical one-sided welding procedures for hull construction, using FILARC PZ6114(S) and PZ6130HS.

