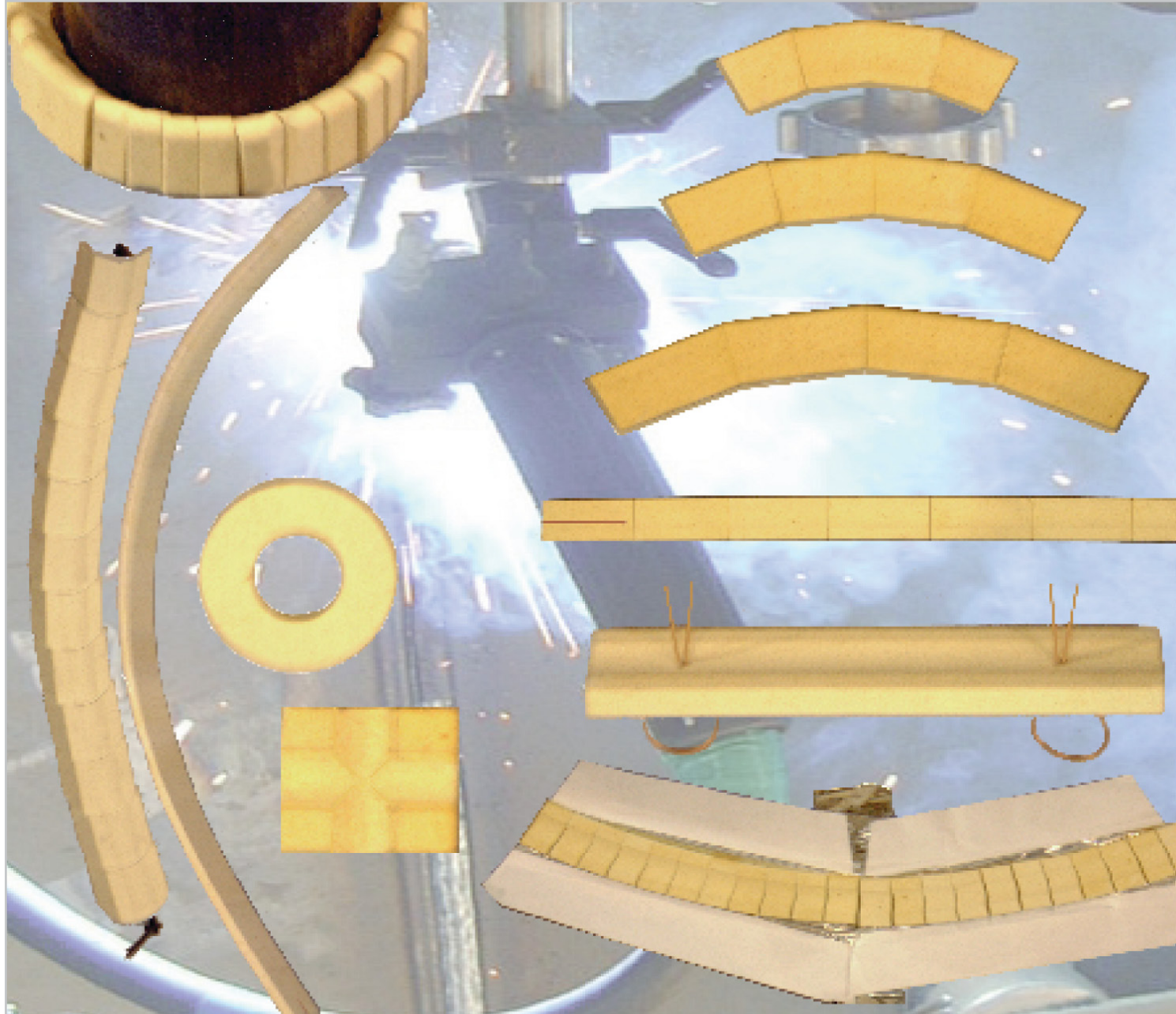


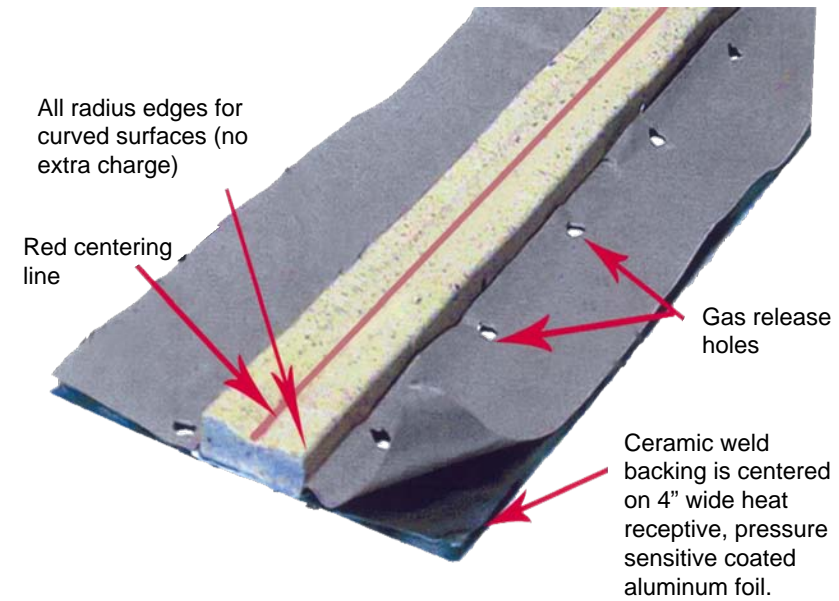
As a manufacturer and distributor of ceramics, Gullco can provide you with a KATBAK® ceramic weld backing to meet your needs. If you do not see the ceramic you need in this brochure contact Gullco or your Gullco distributor to discuss your specific requirement.



WELDING AND CUTTING AUTOMATION



CERAMIC WELD BACKING TAPE - KATBAK®



- Impart x-ray quality back beads on the root pass.
- Weld one side only
- Deposit more weld metal
- Eliminate defects and rework
- Eliminate costly unnecessary gouging and grinding
- Size 1/4" (6.3 mm) to 2" (51 mm) special sizes and configurations available
- Conveniently packaged and sealed in plastic for moisture proof protection
- Wider heat receptive pressure sensitive foil for improved adhesion to work piece



TANK BUILDING



PIPE WELDING



SHIP BUILDING



BRIDGE BUILDING

Quality Certification To: ISO 9000

IMPROVE WELD QUALITY AND REDUCE COST WITH KATBAK® CERAMIC WELD BACKING

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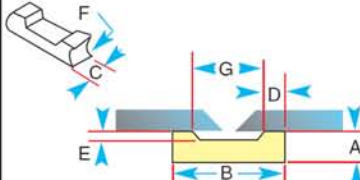
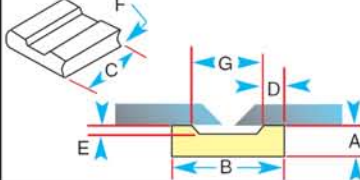
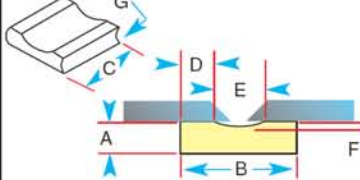
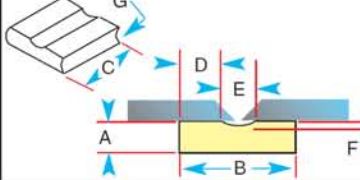
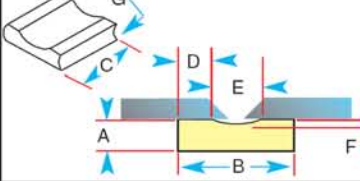
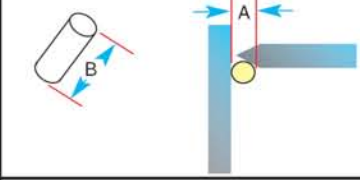
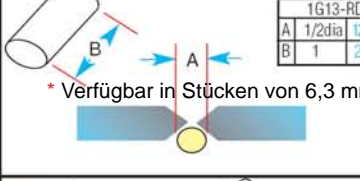
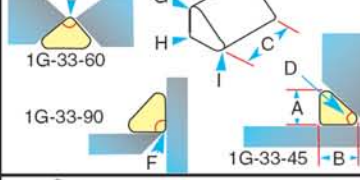
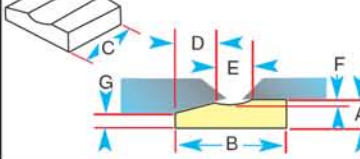
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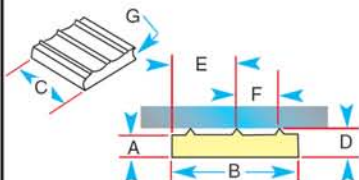
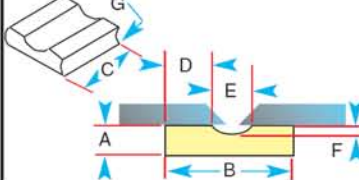
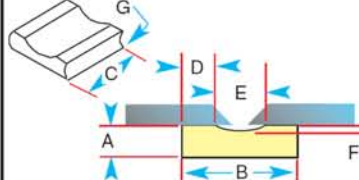
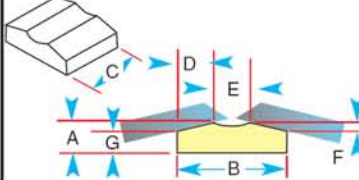
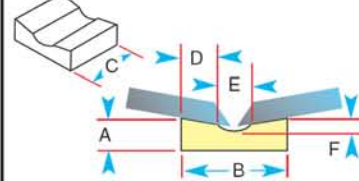
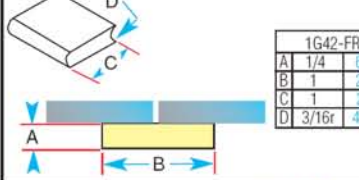
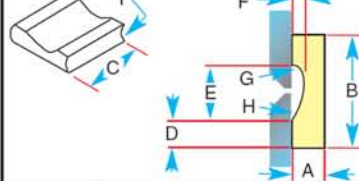
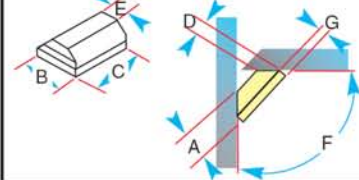
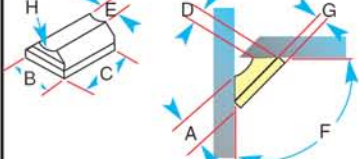
KB-11-01

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Phone: (02 03) 72 94 95	Fax: (02 03) 72 94 96	e-mail: info@stuch-schweisstechnik.de



MODEL	SPECIFICATION/TYPICAL APPLICATION	SPECS. inches / (mm)																														
1G93-R-1/4 (12m - 40ft/ box)	Similar to the 1G93-R tile but in 1/4" lengths making it much more flexible to wrap around smaller diameters of pipe and vessel. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>7/8 to 1</td><td>22.2-25.4</td></tr> <tr><td>C</td><td>1/4</td><td>6.3</td></tr> <tr><td>D</td><td>5/32</td><td>4</td></tr> <tr><td>E</td><td>1/16</td><td>1.6</td></tr> <tr><td>F</td><td>3/16 r</td><td>4.8r</td></tr> <tr><td>G</td><td>7/16</td><td>11.1</td></tr> </table>	A	1/4	6.3	B	7/8 to 1	22.2-25.4	C	1/4	6.3	D	5/32	4	E	1/16	1.6	F	3/16 r	4.8r	G	7/16	11.1									
A	1/4	6.3																														
B	7/8 to 1	22.2-25.4																														
C	1/4	6.3																														
D	5/32	4																														
E	1/16	1.6																														
F	3/16 r	4.8r																														
G	7/16	11.1																														
1G93-R (12m - 40ft/ box)	This tile is most suitable for those applications where slag is involved, mainly M.A.G. welding with cored wire. It gives space for the slag to go while leaving a good root bead. Each tile is radiused to form a strip around the cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>7/8 to 1</td><td>22.2-25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>5/32</td><td>4</td></tr> <tr><td>E</td><td>1/16</td><td>1.6</td></tr> <tr><td>F</td><td>3/16 r</td><td>4.8r</td></tr> <tr><td>G</td><td>7/16</td><td>11.1</td></tr> </table>	A	1/4	6.3	B	7/8 to 1	22.2-25.4	C	1	25.4	D	5/32	4	E	1/16	1.6	F	3/16 r	4.8r	G	7/16	11.1									
A	1/4	6.3																														
B	7/8 to 1	22.2-25.4																														
C	1	25.4																														
D	5/32	4																														
E	1/16	1.6																														
F	3/16 r	4.8r																														
G	7/16	11.1																														
1G42-R (12m - 40ft/ box)	This tile is useful for M.I.G. welding with solid wires and metal cored wires. It is also useful for T.I.G. welding. Cored wires can also be used with this tile but smaller root reinforcement will be produced. Each tile is radiused to form the strip around a cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>9/32</td><td>7.2</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>3/16r</td><td>4.8r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	9/32	7.2	E	7/16	11.1	F	1/16	1.6	G	3/16r	4.8r									
A	1/4	6.3																														
B	1	25.4																														
C	1	25.4																														
D	9/32	7.2																														
E	7/16	11.1																														
F	1/16	1.6																														
G	3/16r	4.8r																														
1G43-R (12m - 40ft/ box)	This tile is for similar applications as the 1G42-R but where a narrower root bead is required. Each tile is radiused to form a strip around a cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/8</td><td>9.5</td></tr> <tr><td>E</td><td>1/4</td><td>6.3</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>3/16r</td><td>4.8r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	3/8	9.5	E	1/4	6.3	F	1/16	1.6	G	3/16r	4.8r									
A	1/4	6.3																														
B	1	25.4																														
C	1	25.4																														
D	3/8	9.5																														
E	1/4	6.3																														
F	1/16	1.6																														
G	3/16r	4.8r																														
1G82-R (9m - 30ft/ box)	This tile is similar to the 1G42-R but it is thicker and more robust for heavier weld deposits and higher amperages. Each tile is radiused to form the strip around the cylinder. ✓	 <table border="1"> <tr><td>A</td><td>5/16</td><td>7.9</td></tr> <tr><td>B</td><td>1 1/4</td><td>31.7</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>13/32</td><td>10.3</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>3/16r</td><td>4.8r</td></tr> </table>	A	5/16	7.9	B	1 1/4	31.7	C	1	25.4	D	13/32	10.3	E	7/16	11.1	F	1/16	1.6	G	3/16r	4.8r									
A	5/16	7.9																														
B	1 1/4	31.7																														
C	1	25.4																														
D	13/32	10.3																														
E	7/16	11.1																														
F	1/16	1.6																														
G	3/16r	4.8r																														
1G6-RD (12m - 40ft/ box) 1G9-RD (12m - 40ft/ box)	This is a 6mm round tile suitable for X preps, K preps and single bevel, single v butt joints (similar to fillet welds) on thin plates up to 10mm thick. Suitable for welding with M.I.G./M.A.G. solid, flux cored or metal cored wires. 1G9-RD is for use on thicker plates.	 <table border="1"> <tr><td colspan="3">1G6-RD</td></tr> <tr><td>A</td><td>1/4dia</td><td>6.3dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td colspan="3">1G9-RD</td></tr> <tr><td>A</td><td>3/8dia</td><td>9.5dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> </table>	1G6-RD			A	1/4dia	6.3dia	B	1	25.4	1G9-RD			A	3/8dia	9.5dia	B	1	25.4												
1G6-RD																																
A	1/4dia	6.3dia																														
B	1	25.4																														
1G9-RD																																
A	3/8dia	9.5dia																														
B	1	25.4																														
1G13-RD (12m - 40ft/ box) 1G15-RD (12m - 40ft/ box) 1G20-RD (12m - 40ft/ box)	These tiles are for similar uses as the 1G6-RD but for thicker plates up to 15mm thick. Suitable for welding with M.I.G./M.A.G. solid, flux cored or metal cored wires. can be used as shown	 <table border="1"> <tr><td colspan="3">1G13-RD</td></tr> <tr><td>A</td><td>1/2dia</td><td>12.7dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td colspan="3">1G15-RD</td></tr> <tr><td>A</td><td>5/8dia</td><td>15.9dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td colspan="3">1G20-RD</td></tr> <tr><td>A</td><td>7/8dia</td><td>22.2dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> </table> <p>* Verfügbar in Stücken von 6,3 mm bis 50,8 mm</p>	1G13-RD			A	1/2dia	12.7dia	B	1	25.4	1G15-RD			A	5/8dia	15.9dia	B	1	25.4	1G20-RD			A	7/8dia	22.2dia	B	1	25.4			
1G13-RD																																
A	1/2dia	12.7dia																														
B	1	25.4																														
1G15-RD																																
A	5/8dia	15.9dia																														
B	1	25.4																														
1G20-RD																																
A	7/8dia	22.2dia																														
B	1	25.4																														
1G33-45 (12m - 40ft/ box) 1G33-60 (12m - 40ft/ box) 1G33-90	All 1G33 tiles are suitable for K or X preps where the bevel angles are 45, 60 or 90 degrees. Also suitable for welding with M.I.G./M.A.G. solid wire, metal cored or flux cored wires. They are a substitute for round tiles where the benefit of the 1G33 range of tiles is a "full-face" contact with the joint preparation... reducing the risk of burn-through as may occur with the round tiles where you have a single point contact of the tile with the work piece. 1G33-90 also used when reverse side of a single bevel, single V butt joint where the reverse angle will always be 90°.	 <table border="1"> <tr><td colspan="3">1G33-45</td></tr> <tr><td>A</td><td>9/16</td><td>14.3</td></tr> <tr><td>B</td><td>5/8</td><td>15.9</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>40°</td><td>40°</td></tr> <tr><td>E</td><td>55°</td><td>55°</td></tr> <tr><td>F</td><td>85°</td><td>85°</td></tr> <tr><td>G</td><td>1/8 r</td><td>3.2 r</td></tr> <tr><td>H</td><td>7/64 r</td><td>2.8 r</td></tr> <tr><td>I</td><td>3/32 r</td><td>2.4 r</td></tr> </table>	1G33-45			A	9/16	14.3	B	5/8	15.9	C	1	25.4	D	40°	40°	E	55°	55°	F	85°	85°	G	1/8 r	3.2 r	H	7/64 r	2.8 r	I	3/32 r	2.4 r
1G33-45																																
A	9/16	14.3																														
B	5/8	15.9																														
C	1	25.4																														
D	40°	40°																														
E	55°	55°																														
F	85°	85°																														
G	1/8 r	3.2 r																														
H	7/64 r	2.8 r																														
I	3/32 r	2.4 r																														
1G62 (9m - 30ft/ box)	This tile is used when two plates to be welded are of a different thickness and is suitable for MIG welding with solid wire, metal core wire and can also be used with flux core wire.	 <table border="1"> <tr><td>A</td><td>21/64</td><td>8.3</td></tr> <tr><td>B</td><td>1 7/32</td><td>31</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>7/16</td><td>11.1</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>3/64</td><td>1.2</td></tr> <tr><td>G</td><td>11/64</td><td>4.4</td></tr> </table>	A	21/64	8.3	B	1 7/32	31	C	1	25.4	D	7/16	11.1	E	7/16	11.1	F	3/64	1.2	G	11/64	4.4									
A	21/64	8.3																														
B	1 7/32	31																														
C	1	25.4																														
D	7/16	11.1																														
E	7/16	11.1																														
F	3/64	1.2																														
G	11/64	4.4																														

* Available in 1/4" to 2" (6.3 mm to 50.8 mm) tiles

MODEL	SPECIFICATION/TYPICAL APPLICATION	SPECS. inches / (mm)																																													
1G42-ER (12m - 40ft/ box)	This tile is suitable for use with M.I.G./M.A.G. applications with solid, flux or metal cored wires where minimal penetration is required but higher amperage is necessary because the small up-stands that are present in this tile will not burn away with amperages less than about 120 amps. Each tile is radiused to form the strip around a cylinder.	 <table border="1"> <tr><td>A</td><td>3/16</td><td>4.8</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>15/64</td><td>6</td></tr> <tr><td>E</td><td>1/2</td><td>12.7</td></tr> <tr><td>F</td><td>11/32</td><td>8.7</td></tr> <tr><td>G</td><td>3/16 r</td><td>4.8r</td></tr> </table>	A	3/16	4.8	B	1	25.4	C	1	25.4	D	15/64	6	E	1/2	12.7	F	11/32	8.7	G	3/16 r	4.8r																								
A	3/16	4.8																																													
B	1	25.4																																													
C	1	25.4																																													
D	15/64	6																																													
E	1/2	12.7																																													
F	11/32	8.7																																													
G	3/16 r	4.8r																																													
1G41-R (12m - 40ft/ box)	This is similar to the 1G42-R but has a slightly smaller groove where more penetration is required than with the 1G42-R. Each tile is radiused to form a strip around a cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>5/16</td><td>7.9</td></tr> <tr><td>E</td><td>3/8</td><td>9.5</td></tr> <tr><td>F</td><td>1/32</td><td>1</td></tr> <tr><td>G</td><td>3/16 r</td><td>4.8 r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	5/16	7.9	E	3/8	9.5	F	1/32	1	G	3/16 r	4.8 r																								
A	1/4	6.3																																													
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F	1/32	1																																													
G	3/16 r	4.8 r																																													
1G44-R (9m - 30ft/ box)	This tile is a larger tile and has a larger groove than the 1G42 tile or the 1G41-R tile where the user needs more penetration and more substance in the tile. Possibly for submerged arc welding applications and thicker plates. Each tile is radiused to form a strip around the cylinder. ✓	 <table border="1"> <tr><td>A</td><td>3/8</td><td>9.5</td></tr> <tr><td>B</td><td>1 1/4</td><td>31.7</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>9/32</td><td>7.2</td></tr> <tr><td>E</td><td>11/16</td><td>17.5</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>1/4 r</td><td>6.3 r</td></tr> </table>	A	3/8	9.5	B	1 1/4	31.7	C	1	25.4	D	9/32	7.2	E	11/16	17.5	F	1/16	1.6	G	1/4 r	6.3 r																								
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F	1/16	1.6																																													
G	1/4 r	6.3 r																																													
1G61 (12.2m - 40ft/box)	This is for inserting behind plates where there is a taper on the backside of the plate. This tile allows the groove portion to fit snugly against the root. Note that these tiles are square edged and so, will not go round a radius. They are meant for flat plates. Again, these tiles are used for M.I.G./M.A.G. welding with all the wires. ✓	 <table border="1"> <tr><td>A</td><td>3/8</td><td>9.5</td></tr> <tr><td>B</td><td>1 7/32</td><td>31</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>25/64</td><td>10</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>1/32</td><td>.79</td></tr> <tr><td>G</td><td>1/4</td><td>6.3</td></tr> </table>	A	3/8	9.5	B	1 7/32	31	C	1	25.4	D	25/64	10	E	7/16	11.1	F	1/32	.79	G	1/4	6.3																								
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F	1/32	.79																																													
G	1/4	6.3																																													
1G60 (9m - 30 ft/ box)	This tile has upturned sides for use when the plates are introduced at an angle or with differing thicknesses to allow the root of the weldment to sit snugly against the tile and present next to the radiused portion where the root will form. ✓	 <table border="1"> <tr><td>A</td><td>3/8</td><td>9.5</td></tr> <tr><td>B</td><td>1 3/16</td><td>30.2</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/8</td><td>9.5</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>9/64</td><td>3.6</td></tr> </table>	A	3/8	9.5	B	1 3/16	30.2	C	1	25.4	D	3/8	9.5	E	7/16	11.1	F	9/64	3.6																											
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1G42-FR (12m - 40ft/ box) 1G83-FR (9m - 30 ft/ box) 1G42-FR-1/4 (12m - 40ft/ box)	This tile is similar to the standard flat tile but it is more flexible to go round a tighter radius. Please note that all other tile shapes can be made 1/4" long to aid flexibility of the tile. Each tile is radiused to form a strip around a cylinder. 1G83-FR This is similar to the 1G42-FR but it is a thicker, larger tile to withstand higher currents where minimal penetration is required. ✓	 <table border="1"> <tr><td colspan="3">1G42-FR</td></tr> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/16r</td><td>4.8r</td></tr> <tr><td colspan="3">1G83-FR</td></tr> <tr><td>A</td><td>5/16</td><td>7.9</td></tr> <tr><td>B</td><td>1 1/4</td><td>31.7</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/16r</td><td>4.8r</td></tr> <tr><td colspan="3">1G42-FR-1/4</td></tr> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1/4</td><td>6.3</td></tr> <tr><td>D</td><td>3/16r</td><td>4.8r</td></tr> </table>	1G42-FR			A	1/4	6.3	B	1	25.4	C	1	25.4	D	3/16r	4.8r	1G83-FR			A	5/16	7.9	B	1 1/4	31.7	C	1	25.4	D	3/16r	4.8r	1G42-FR-1/4			A	1/4	6.3	B	1	25.4	C	1/4	6.3	D	3/16r	4.8r
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1G80-R (12m - 40 ft/ box)	This tile is specially designed to prevent back bead droop in horizontal welding and can be used with MIG welding with solid wire, metal core wire and can also be used with flux core wire. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>1/4</td><td>6.3</td></tr> <tr><td>E</td><td>1/2</td><td>12.7</td></tr> <tr><td>F</td><td>3/32</td><td>2.4</td></tr> <tr><td>G</td><td>3/32 r</td><td>2.4 r</td></tr> <tr><td>H</td><td>3/4 r</td><td>19. r</td></tr> <tr><td>I</td><td>3/16 r</td><td>4.8 r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	1/4	6.3	E	1/2	12.7	F	3/32	2.4	G	3/32 r	2.4 r	H	3/4 r	19. r	I	3/16 r	4.8 r																		
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1G66-B (12m - 40ft/ box)	This is for fitting behind a single bevel, single v butt where a fillet weld must be produced on the backside of the joint during welding on the front side of the joint... possibly where access for welding or repairs is not possible. This tile will produce a mitered fillet. ✓	 <table border="1"> <tr><td>A</td><td>11/32</td><td>8.7</td></tr> <tr><td>B</td><td>3/4</td><td>19.</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>7/32</td><td>5.6</td></tr> <tr><td>E</td><td>5/16</td><td>7.9</td></tr> <tr><td>F</td><td>90°</td><td>90°</td></tr> <tr><td>G</td><td>1/8</td><td>3.2</td></tr> </table>	A	11/32	8.7	B	3/4	19.	C	1	25.4	D	7/32	5.6	E	5/16	7.9	F	90°	90°	G	1/8	3.2																								
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1G65-B (12m - 40ft/ box)	Similar applications to the 1G66-B but the fillet weld produced will be a convex radiused fillet instead of a mitered fillet. ✓	 <table border="1"> <tr><td>A</td><td>5/16</td><td>7.9</td></tr> <tr><td>B</td><td>7/8</td><td>22.2</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>7/32</td><td>5.6</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>90°</td><td>90°</td></tr> <tr><td>G</td><td>3/32</td><td>2.4</td></tr> <tr><td>H</td><td>9/16 r</td><td>14.3 r</td></tr> </table>	A	5/16	7.9	B	7/8	22.2	C	1	25.4	D	7/32	5.6	E	7/16	11.1	F	90°	90°	G	3/32	2.4	H	9/16 r	14.3 r																					
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* Available in 1/4" to 2" (6.3 mm to 50.8 mm) tiles