

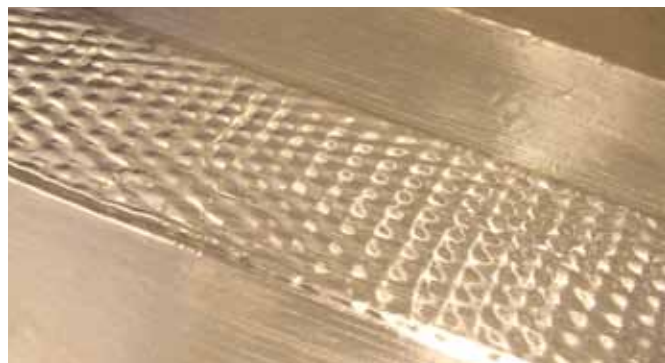
Argweld® Weld Backing Tape™ & Weld Purge Tape™



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To reduce welding costs when joining linear or circumferential seams, a backing tape can be applied to the rear of the weld seam allowing the molten metal to be cast onto the glass fibre matting leaving a smooth, coke free weld root.

Huntingdon Fusion Techniques HFT®, manufactures three grades of backing tape, suitable for different weld current levels.



Picture above: a close up shot of the 25 mm wide glass fibre matting affixed to the 75 mm wide adhesive aluminium tape, applied so that no air pockets are trapped underneath the foil.

A light duty grade for welding up to 80 Amps, a medium current version for welding up to 160 Amps and a heavy duty grade for welding up to 240 Amps.

KEY ADVANTAGES

- Can be used with any arc welding process
- Weld is cast flat onto the tape leaving a smooth, coke free surface
- Welding can be carried out by operatives with lower skill levels
- The amount of weld root grinding and cleaning is minimised, giving a significant financial saving
- Suitable for automatic and manual welding techniques
- Allows faster welding thus saving more time and money. Other advantages will be highlighted later in this leaflet
- Tape rolled up and delivered in a multilingual labelled box complete with user instructions

ABT0004 - LIGHT DUTY TAPE

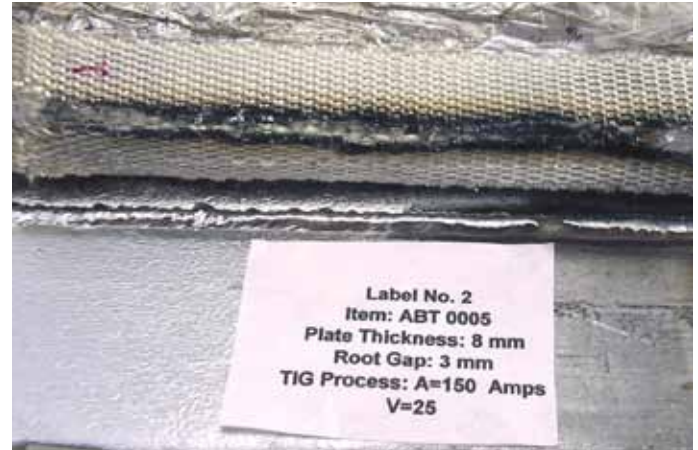
Available in pre-cut 25 meter lengths. The light duty backing tape with its weave thickness of 1mm will aid in the production of a flat weld underbead with minimum oxidation and porosity. The use of Argweld® **Weld Backing Tape™** will also eliminate weld coking, drop through and icicles, sugaring and is allowing for faster welding. Welding can be carried out by lower skilled labour and result in a valuable reduction in post production cleaning and pickling.



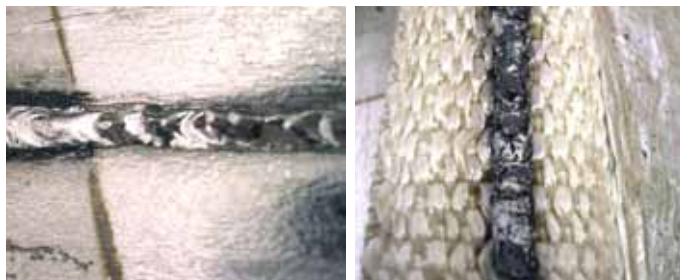
Close-up of the weld bead achieved with Light Duty Weld Backing Tape. 8 mm Plate, 3 mm Root Gap, Manual TIG Process at: 90 Amps, 25 V

ABT0005 - MEDIUM DUTY TAPE

Available in pre-cut 12.5 meter lengths. The medium duty backing tape allows for welding up to 160 amps with any arc process, while obtaining faster welding with lower skilled labour. Producing a flat weld underbead minimises oxidation and porosity and eliminates weld coking drop through and icicles.



Close-up of the weld bead achieved with Medium Duty Weld Backing Tape. 8 mm Plate, 3 mm Root Gap, TIG Process at: 150 Amps, 25 V



Close-up of the Argweld® Light Duty Weld Tape after one weld at: 90 Amps, 25 V



Close-up of the Argweld® Medium Duty Weld Tape

TYPICAL APPLICATIONS:

- Suitable for light duty stainless steel fabrication up to 80 Amps.
- Typical customers are pipework fabricators for the dairy, brewery and pharmaceutical industries.
- Using flat sheet metal, as well as cylindrical structures nominally up to 1.6 mm thick.

TYPICAL APPLICATIONS:

- Suitable for medium duty stainless steel fabrication up to 160 Amps in the dairy industry, using flat sheet metal, as well as cylindrical structures nominally up to 2.4 mm thick, pipework fabricators for the pharmaceutical, petrochemical industry and vessel manufacturers.

ABT0006 - HEAVY DUTY TAPE

Available in pre-cut 12.5 meter lengths. The heavy duty backing tape allows for welding up to 240 amps with any arc process, while obtaining faster welding with lower skilled labour. This produces a flat weld underbead which minimises oxidation and porosity, thus eliminating weld coking and drop through. Additional benefits are the reduction of post production cleaning and pickling costs.



Close-up of the weld bead achieved with Heavy Duty Weld Backing Tape. 8 mm Plate, 3 mm Root Gap, TIG Process at: 250 Amps, 25 V



Close-up of the Argweld® Heavy Duty Weld Tape™

TYPICAL APPLICATIONS:

- Suitable for heavy duty welding applications, such as submerged arc welding of plate in the shipbuilding and ship repair industries.
- Also for use with boilers, heat exchangers and pipelines.
- It helps to produce flat, coke free underbead and reduce weld purge requirements.

ABT0003 - ARGWELD® WELD PURGE ALUMINIUM TAPE™ ONLY WITHOUT GLASS WOVEN SUPPORT

Available roll length is 45 metres (144 ft). Comprising 50 mm (2") wide adhesive heat resistant Argweld® **Weld Purge Aluminium Tape™**.

Ideal for use as weld joint tape to prevent purge gas from escaping through open root weld joint fit-up prior to welding.

Contact HFT® for special procedure to seal weld gap without adhesive touching the adjacent metal.



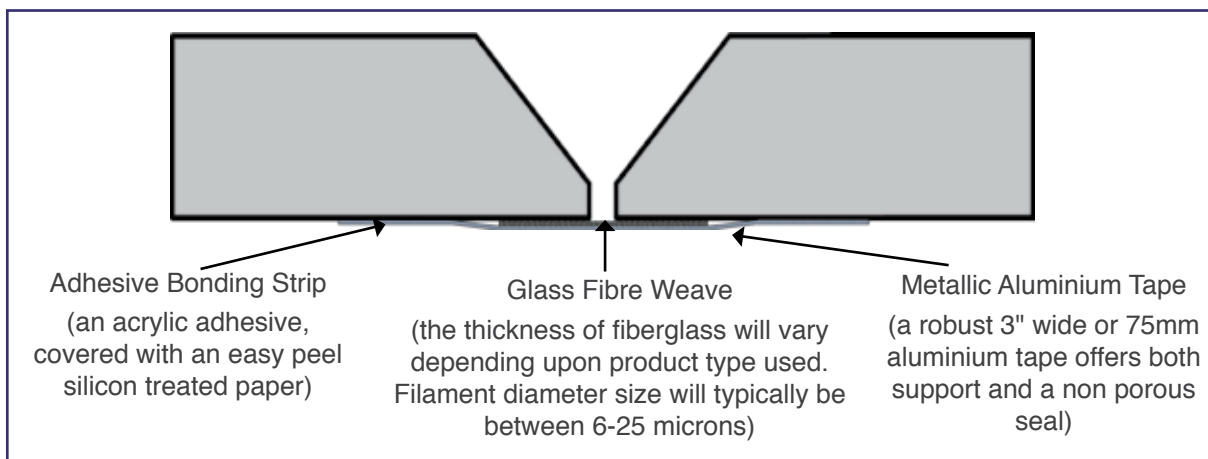
Close-up of Weld Purge Tape™



0.5 mm thickness

APPLYING THE BACKING TAPE:

The following illustration is a typical profile, showing the correct application off the Argweld® **Weld Backing Tape™**.



Step 1: Simply stick the tape onto the pre-cleaned weld joint area.



Step 3: Remove the tape to see a flat, well formed bead



*Step 2: Weld onto the Argweld® **Purge Tape™***

ADDITIONAL / SUPPORTING LITERATURE:

As with all of our other products we also have for the Argweld® **Weld Backing Tape™**:

- A material safety data sheet
- An application guide
- Training poster
- User list
- Technical papers (as published in The Fabricator and Welding & Cutting)

All are available at request. Sample packs are available by contact HFT® with a description of your application, containing a small trial strip of each grade of **Weld Backing Tape™**.

HUNTINGDON FUSION TECHNIQUES ■ HFT

Our Product Range:

Argweld® Inflatable Pipe Weld Purge Systems
Argweld® PurgEye® Weld Purge Monitors® (100 to 1000)
Argweld® Water Soluble Weld Purge Film and Weld Purge Super Adhesive™
Argweld® Weld Trailing Shields®
Argweld® Weld Backing Tape™ & Weld Purge Tape™
Argweld® Flexible Welding Enclosures®
Argweld® Weld Purging Plugs™ & Orbital Welding Plugs
Techweld® MultiStrike® Tungsten Electrodes
HFT Pipestoppers® Pipe Plugs & Stoppers, Nylon, Aluminium & Steel
HFT Pipestoppers® Inflatable Stoppers