

BACKING RINGS

S-40000

CARBON STEEL SPLIT BACKING RINGS WITH PINS FOR WELDING

The APF MODEL S-40000, CARBON STEEL SPLIT BACKING RINGS is designed for quick, easy alignment of pipe piles where butt welding is required. Chamfered pins allow close tolerance fit-ups and clean strike off.

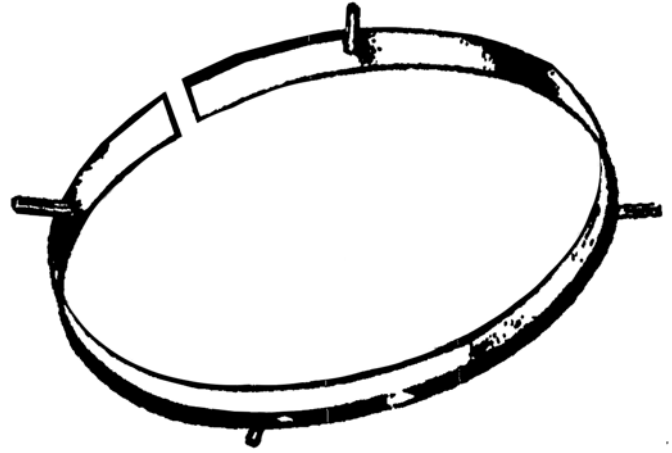
The pin diameter automatically sets the welding gap for root pass as the width of the pin conforms to the diameter of the welding rod.

SIMPLIFIED WELDING PROCEDURE

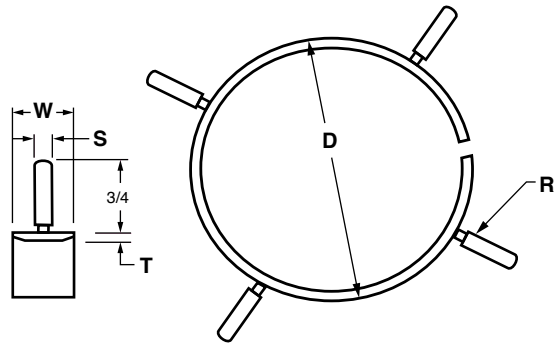
APF S-40000 BACKING RINGS are inserted into the beveled pipe pile end with the spacer pins flush against the land of the pipe. The beveled end of the adjoining pipe is slipped onto the backing ring until the edge of the pipe bevel is firmly abutted against the spacer pin. The welder has the choice of striking off the pins or leaving them intact.

The welder can either weld the split making a solid ring, or weld away from the split allowing the heat of the molten metal to expand the ring tightly against the inner surface of the pipe. This eliminated gaps, openings or crevices between the backing ring and the pipe. The engineered concavity across the surface of the S-40000 BACKING RING permits weld shrinkage and prevents curling-of the ring edges.

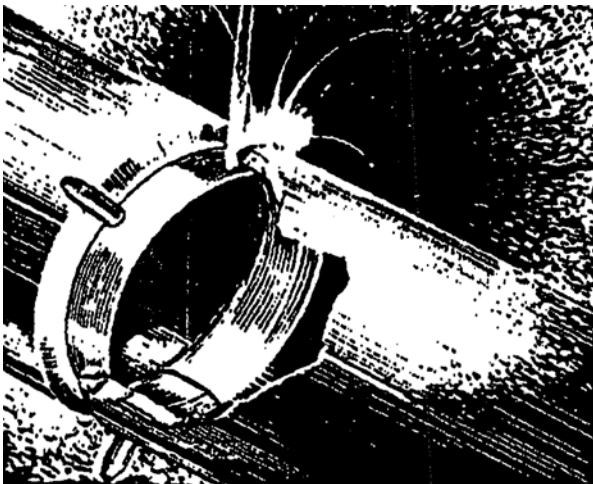
During welding, the arc should be directed to penetrate the inner edge of both ends of the pipe and the backing ring. The molten metal should penetrate into the backing ring approximately 1/16" thereby forming an integral welded joint.



MODEL S-40000



CARBON STEEL ASTM A-109 TEMPER 4



Nom. Pipe Size	ID of Pipe		No. of Root Opening Spcrrs R	Dia of Spcrrs S	Ring Thickness T	Ring Width W
	Std. D	X Hvy D				
8"	7.981"	7.625"	4	3/16"	1/8"	1"
10"	10.020"	9.750"	4	3/16"	1/8"	1"
12"	12.000"	11.750"	4	3/16"	1/8"	1"
14"	13.250"	13.000"	4	3/16"	1/8"	1"
16"	15.250"	15.000"	4	3/16"	1/8"	1"
18"	17.250"	17.000"	4	3/16"	1/8"	1"
20"	19.250"	19.000"	5	3/16"	1/8"	1"
24"	23.250"	23.000"	5	3/16"	1/8"	1"
30"	29.250"	29.000"	5	3/16"	1/8"	1"
36"	35.250"	35.000"	5	3/16"	1/8"	1"



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