

CERAMIC WELDING BACKING KERAMIKSCHWEISSBADSICHERUNG KERAMISK SVEJSEUNDERLAG



DABOTEK

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DABOTEK CERAMIC WELD BACKING

In heavy metal fabrication welding conditions are never ideal. Weld joint fit-ups to provide optimum (root) weld conditions and often impossible for all practical purposes. DABOTEK DTG and DTB Weld Backing are manufactured in many shape and sizes for the conditions of heavy metal fabrication. These non-hygroscopic, neutral non-metallic weld backings, when properly positioned and attached to the back-side of weld joint openings produce a condition which results in root weld free of defects. Since rework associated with poor root weld is eliminated, additional joint prep, weld and cleanup time become superfluous. Unlike metal backing bars, DABOTEK non-metallic weld backing do not become part of finished weld.

One-side one pass, and one-side multipass welds are possible with DABOTEK weld backings. Our backings have been shown to evenly support molten weld metal over a wide range of welding heats resulting in a uniform back bead of finished quality.

For Years DABOTEK has been an innovator in the welding industry attending to the needs of heavy metal fabricators and now services a principal share of Danish and others shipbuilders in Europe. Through commitment to our customers we have developed 98 custom weld backing configurations to meet their demands. As you know, these needs are constantly changing without sacrificing a high standard of quality. Our ceramic backings are manufactured in accordance to DIN 40865. DABOTEK is also changing to meet these needs. This is why DABOTEK is proud to announce our latest 1998 product to date **DWC**.

Our **DABOTEK Weld Ceramic DWC** is a very economical non-metallic weld backing designed for one pass root welds of thinner sections. Like all of DABOTEK's products **DWC** eliminates gouging, grinding, rewelding and rework.

DWC comes with it's own hand held dispenser making for fast applications in all positions. By using different dept of shape, you will always become an optimal welding procedure.

DWC has been designed to work for steel plates up to 60 mm thick.

To get further information please write or give us a call. We are glad to field all questions.

SERVICES

At DABOTEK, 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.

-DABOTEK non-metallic weld backings are available in over 60 different configurations to accommodate almost any joint prep.

- We specialize in providing backings for special weld joints.

- Use GMA;SMA;SUB-ARC OR TIG with any joint prep.

KERAMIK I STÅL SKINNER - 600 mm.
CERAMIC IN STEELRAIL. - 600 mm.
KERAMIK IN STAHLSCHINE- 600 mm.

Keramik fra DABOTEK leveres som løse brikker og løse skinner eller færdig monteret i 0,5mm stålskinne i længde på 600mm. Længder på 1000 mm kan

leveres. (min 4800 stk, eks. DTG100-3514-1R)

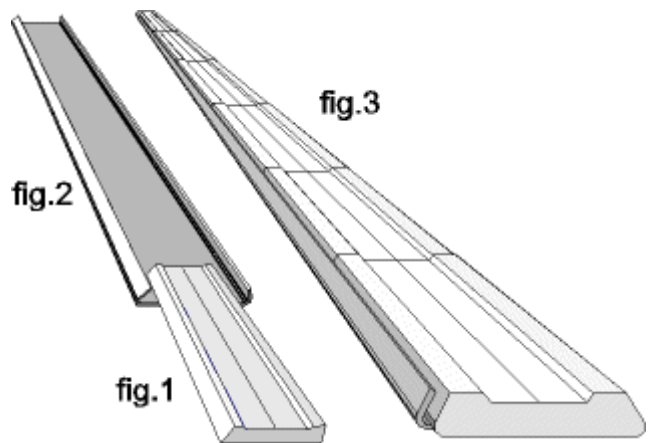
På forespørgsel alle typer leveres på kraftig selvklæbende ALU-tape.

Fig.1 : KERAMIKBRIK, CERAMICBRICK, KERAMIKBRICK

Fig.2 : STÅLSKINNE, STEELRAIL, STAHLSCHINE

Fig.3 : MONTERET, MOUNTED, MONTIERT

Tilbage : [Tilbage](#)



SVEJSE KERAMIK I STÅL SKINNER						
Type	Tekst	Figur	Illustration	Længde i skinne (mm)	Dybde Længde brede (mm)	Form Matr. farve
DTG100-2509 DTG100-2509-6R DTR585-25	Brik Brik i skinne Stålskinne			600	0,9 150 25	flad B511 brun
DTG100-2509U DTG100-2509U-6R DTR585-25	Brik Brik i skinne Stålskinne			600	0,9 100 25	rund C410 grå
DTG100-2514U DTG100-2514U-6R DTR585-25	Brik Brik i skinne Stålskinne			600	1,4 100 25	rund C410 grå
DTG100-2509 DTG100-2509-6R DTR585-25	Brik Brik i skinne Stålskinne			600	0,9 100 25	flad C410 grå
DTG100-2511 DTG100-2511-6R DTR585-25	Brik Brik i skinne Stålskinne			600	1,1 100 25	flad C410 grå
DTG150-2511 DTG150-2511-6R DTR585-25	Brik Brik i skinne Stålskinne			600	1,1 150 25	flad C410 grå
DTG100-2514 DTG100-2514-6R DTR585-25	Brik Brik i skinne Stålskinne			600	1,4 100 25	flad C410 grå
DTG080-3009 DTG080-3009-6R DTR585-30	Brik Brik i skinne Stålskinne			600	0,9 80 30	flad C410 grå
DTG100-3509 DTG100-3509-6R DTR585-35	Brik Brik i skinne Stålskinne			600	0,9 100 35	flad C410 grå
DTG100-3514 DTG100-3514-6R DTR585-35	Brik Brik i skinne Stålskinne			600	1,4 100 35	flad C410 grå
DTG100-4011 DTG100-4011-6R DTR585-40	Brik Brik i skinne Stålskinne			600	1,1 100 40	flad C410 grå

KERAMIK MONTERET PÅ TAPE

KERAMIK AUF ALU FOLIE

CERAMIC ON ALU TAPE

[Forside Erste Seite, Coverpage](#)

KERAMIK MONTERET PÅ TAPE						
typenr.:	Beskrivelse:	Tegning:	Keramik på tape	længde på tape, brede	dybde længde brede	form matr. farve
				(mm)	(mm)	
DTG028-2400-6T	Fleksibel flad			600,75	0,0 28 24	flat C410 grey
DTG026-2408U-6T	Fleksibel rund			600,75	0,8 26 24	round C410 grey
DTG026-2410U-6T	Fleksibel rund			600,75	0,9 26 24	round C410 grey
DTG028-2409U-6T	Fleksibel rund			600,75	0,9 28 24	round C410 grey
DTG028-2414U-6T	Fleksibel rund			600,75	1,4 28 24	round C410 grey
DTG028-2409-6T	Fleksibel flad			600,75	0,9 28 24	flat C410 grey
DTG028-2414-6T	Fleksibel flad			600,75	1,4 28 24	flat C410 grey
DTG026-2409-6T	Fleksibel flad			600,75	0,9 28 24	flat C410 grey
DTG026-2505-6T	Fleksibel flad			600,75	\ 28 24	----- C410 grey
DTB020-3009U-6T	Fleksibel rund			600,100	0,9 20 30	round B511 brown
DTB020-3009-6T	Fleksibel flad			600,100	0,9 20 30	flat B511 brown
DTG020-3009U-6T	Fleksibel rund			600,100	0,9 20 30	round C410 grey
DTG020-3009-6T	Fleksibel flad			600,100	0,9 20 30	flat C410 grey
DTG020-3014-6T	Fleksibel flad			600,100	1,4 20 30	flat C410 grey

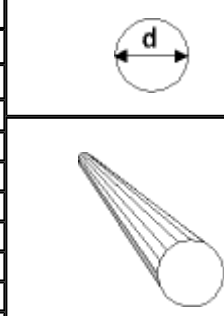
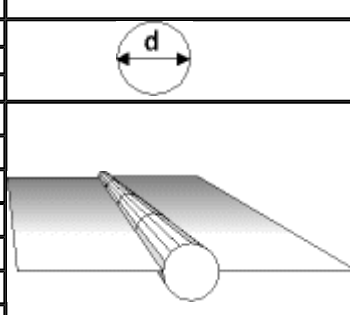
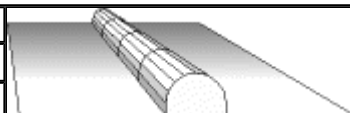
Side, Page, Seite 2

DTG020-30XX can on request be mounted on steelwire.

(Brede på tape, Breite auf Alufolie, Width on Alutape: 75/100 mm)

**KERAMISKE RØR PÅ TAPE -
KERAMISCHE ROHRE AUF ALUFOLIE
CERAMIC PIPES ON ALUTAPE**

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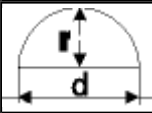
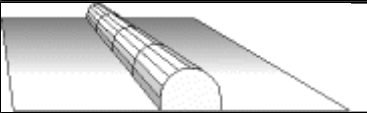
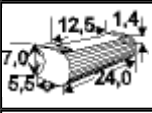
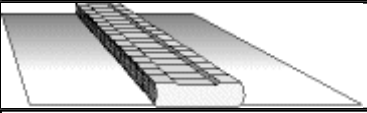
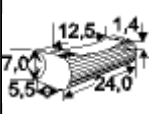
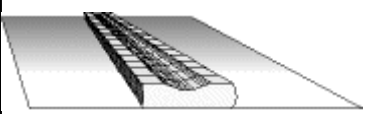
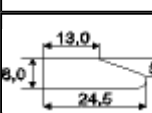
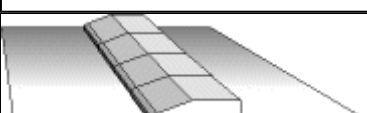
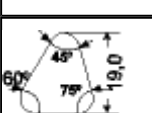
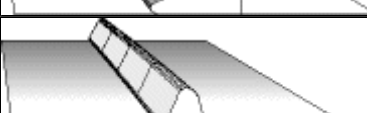
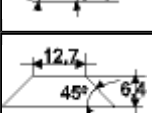

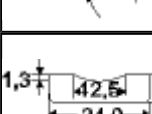

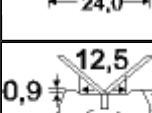
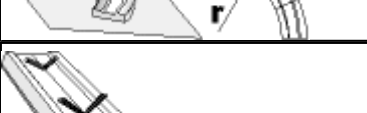
KERAMISKE RØR - KERAMISCHE ROHRE - CERAMIC PIPES					
Typenr.	Beskrivelse:	Fig.	Længde Diameter:	diameter længde /brikker	Form Matr. Farve
			(mm)	(mm)	grå
DTG020-07-P	Rør Ø7		7,0	20	C410
DTG100-07-P	Rør Ø7		7,0	100	C410
DTG025-09-P	Rør Ø9		9,0	25	C410
DTG100-09-P	Rør Ø9		9,0	100	C410
DTG025-12-P	Rør Ø12		12,0	25	C410
DTG100-12-P	Rør Ø12		12,0	100	C410
DTG025-15-P	Rør Ø15		15,0	25	C410
DTG100-15-P	Rør Ø15		15,0	100	C410
DTG025-20-P	Rør Ø20		20,0	25	C410
DTG100-20-P	Rør Ø20		20,0	100	C410
KERAMISKE RØR PÅ TAPE - KERAMISCHE ROHRE AUF ALUFOLIE - CERAMIC PIPES ON ALUTAPE					
Typenr.	Beskrivelse:	Fig.	Længde på tape Tapebrede:	diameter længde /brikker	Form Matr. Farve
Typenr.:	D (mm)		(mm)	(mm)	grå
DTG020-07-6PT	Rør Ø7 på tape		600/75	600	C410
DTG100-07-6PT	Rør Ø7 på tape		600/75	600	C410
DTG025-09-6PT	Rør Ø9 på tape		600/75	600	C410
DTG100-09-6PT	Rør Ø9 på tape		600/75	600	C410
DTG025-12-6PT	Rør Ø12 på tape		600/75	600	C410
DTG100-12-6PT	Rør Ø12 på tape		600/75	600	C410
DTG025-15-6PT	Rør Ø15 på tape		600/75	600	C410
DTG100-15-6PT	Rør Ø15 på tape		600/75	600	C410
DTG025-20-6PT	Rør Ø20 på tape		600/100	600	C410
DTG100-20-6PT	Rør Ø20 på tape		600/100	600	C410
HALVCYLINDER PÅ TAPE - HALBCYLINDER AUF ALUFOLIE - HALFCYLINDER ON ALUTAPE					
DTG025-12-6QT	12x25		600/75	600	C410
DTG025-16-6QT	16x25		600/75	600	C410
DTG025-20-6QT	20x25		600/75	600	C410

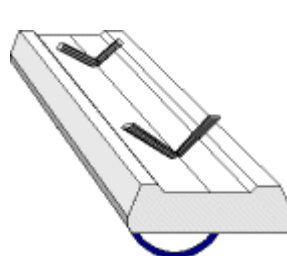
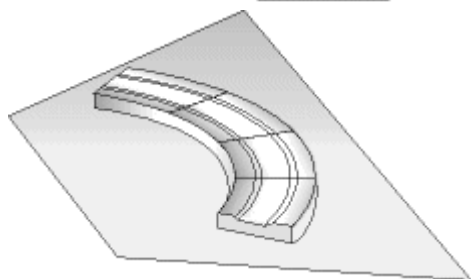
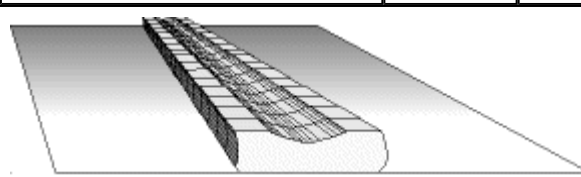
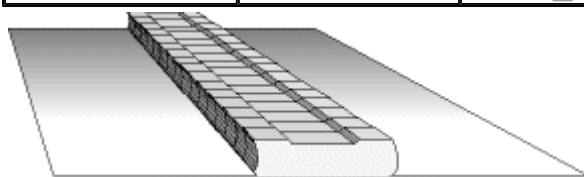
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Side 3

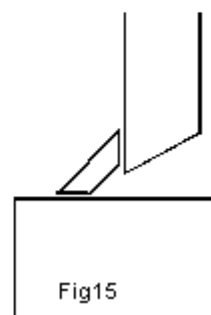
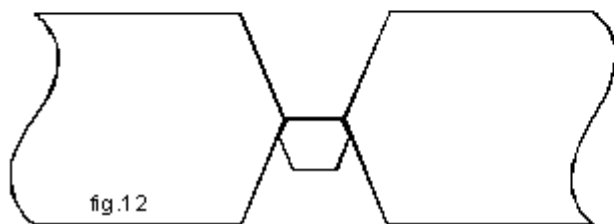
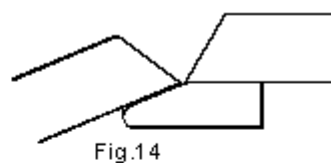
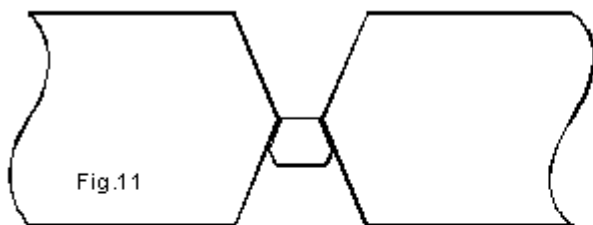
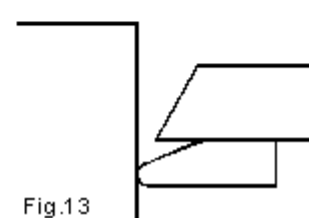
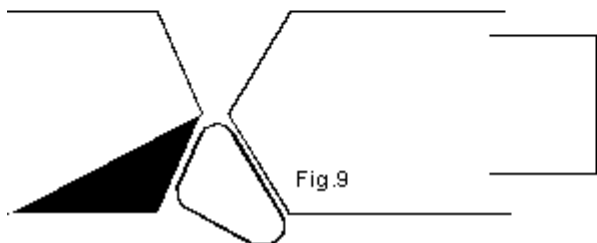
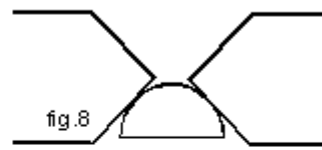
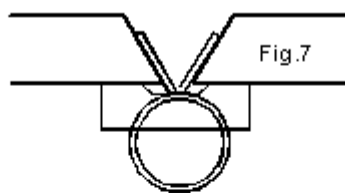
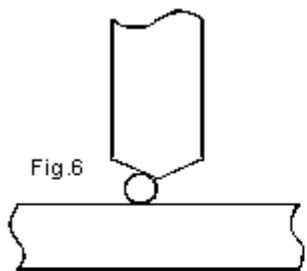
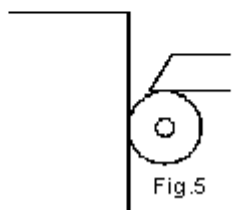
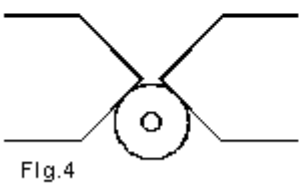
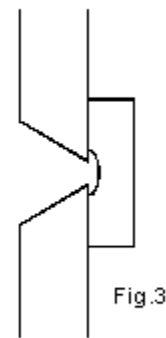
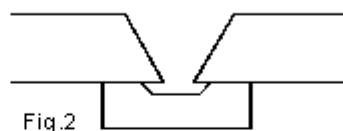
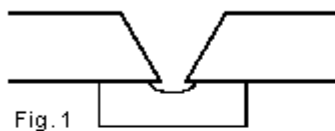
ANDRE TYPER SONDER KERAMIK SPECIAL CERAMIC

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DABOTEK SPECIAL KERAMIK						
Typenr.:	Beskrivelse:	Tegning:		Længde: på tape	dia/dyb længde /brikker	Form Matr. Farve
DTG025-12-6QT DTG025-16-6QT DTG025-20-6QT	halvcylinder på tape d = 12X25 ---" d = 16X25 ---" d = 20X25 ---"			600	12 25 24	rund C410 grå/hvid
DTG007-2514-6T	flex 85 STK på tape flad, dyb 1,4			600	1,4 7 85	flad C410 grå/hvid
DTG007-2514U-6T	rund, dyp 1,4 85 STK x 7 mm			600	1,4 7 85	rund C410 grå/hvid
DTG026-2505-6T	flex STK på tape l=600mm 24 STK x 25 mm			600	1,4 25 24	skrå C410 grå/hvid
DTG025-19-A DTG100-19-A DTG025-19-6AT	Triangle -----" ----- on tape			600	19 25 24	triangle C410 grå/hvid
DTG025-06-B DTG100-06-B DTG025-06-6BT	Trapez -----" ----- on tape			600	12,7 25 25	trapetz C410 grå/hvid
DTG025-2413U-100RT DTG025-2413U-150RT DTG025-2413U-200RT DTG025-2413U-300RT	Raduis 100 på tape ----- 150 ---" ----- 200 on tape ----- 300 ---"			100 150 200 300	1,3 25 25	rund C410 grå/hvid
DTB150-2509-C	Keramik med klips KERAMIK mit Klips Ceramic with clips			150x25	0,9 25 1	flad B511 Brun/gul



APPLICATION OF CERAMIC BACKING



DABOTEK WELD BACKING[info page1](#) ; [info page2](#) ; [info page3](#) ; [back](#)

F/D=Flat down;V/U=Vertical Up;VD=vertical down;H=Horizontal; X=very good; x=good;

DABOTEK WELD BACKING	Fig	mm	nose mm	Thick. steel plates mm	Weldposition				Weld form				Welding Metode					
					F/D	V/U	V/D	H	DV	SV	SB	TJ	JG	GMA	SMA	FC	SAW	TIG
DTB150-2509-C	7	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTG140-2409-C	7	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTB150-2509	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTB150-2509-6R	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTB150-2509-1R	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTB150-2509-1RT	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTG100-2509	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTG100-2509-6R	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTG100-2509-1R	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X	
DTG100-2511	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2511-6R	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2511-1R	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2514	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2514-6R	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2514-1R	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2514U	1	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2514-6R	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG100-2514-1R	2	3-7	0-5	6	x	X	X	X		X	X			X	X	X	X	
DTG080-3009	2	3-8	0-5	8	X	x	x	X		X	X			X	X	X	X	
DTG080-3009-6R	2	3-8	0-5	8	X	x	x	X		X	X			X	X	X	X	
DTG080-3009-1R	2	3-8	0-5	8	X	x	x	X		X	X			X	X	X	X	
DTG100-3509	2	3-8	0-5	10	X	x	x	X		X	X			X	X	X	X	
DTG100-3509-6R	2	3-8	0-5	10	X	x	x	X		X	X			X	X	X	X	
DTG100-3509-1R	2	3-8	0-5	10	X	x	x	X		X	X			X	X	X	X	
DTG100-3514	2	3-8	0-5	10	x	X	X	X		X	X			X	X	X	X	
DTG100-3514-6R	2	3-8	0-5	10	x	X	X	X		X	X			X	X	X	X	
DTG100-3514-1R	2	3-8	0-5	10	x	X	X	X		X	X			X	X	X	X	
DTG100-4011	2	5-15	0-5	12	x	X	X	X		X	X			X	X	X	X	
DTG100-4011-6R	2	5-15	0-5	12	x	X	X	X		X	X			X	X	X	X	
DTG100-4011-1R	2	5-15	0-5	12	x	X	X	X		X	X			X	X	X	X	

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F/D=Flat down;V/U=Vertical Up;VD=vertical down;H=Horizontal; X=very good; x=good;

DABOTEK WELD BACKING	Fig	Gab		Thick. steel plates mm	Weldposition				Weld form				Welding Metode				
		mm	mm		F/D	V/U	V/D	H	DV	SV	SB	TJ	JG	GMA	SMA	FC	SAW
DTG028-2409-6T	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X
DTG028-2414-6T	2	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X
DTG028-2414U-6T	1	3-7	0-5	6	X	x	x	X		X	X			X	X	X	X
DTG020-3009-6T	2	3-8	0-5	8	X	x	x	X		X	X			X	X	X	X
DTG020-3009U-6T	1	3-8	0-5	8	X	x	x	X		X	X			X	X	X	X
DTG020-3014-6T	2	3-8	0-5	10	x	X	X	X		X	X			X	X	X	X
DTG020-3014U-6T	1	3-8	0-5	10	x	X	X	X		X	X			X	X	X	X
DTB020-3009-1W	1/2	3-8	0-5	8	X	x	x	X		X	X			X	X	X	X
DTB020-3014-1W	1/2	3-8	0-5	10	x	X	X	X		X	X			X	X	X	X
DTG020-07-P	4,5,6	1-3	0-5	6	X	X	X	X	X	X	X	X	X	X	X	X	X
DTG100-07-P	4,5,6	1-3	0-5	6	X	X	X	X	X	X	X	X		X	X	X	X
DTG025-09-P	4,5,6	2-5	0-5	6	X	X	X	X	X	X	X	X	X	X	X	X	X
DTG100-09-P	4,5,6	2-5	0-5	6	X	X	X	X	X	X	X	X		X	X	X	X
DTG025-12-P	4,5,6	3-7	0-5	8	X	X	X	X	X	X	X	X	X	X	X	X	X
DTG100-12-P	4,5,6	3-7	0-5	8	X	X	X	X	X	X	X	X		X	X	X	X
DTG100-15-P	4,5,6	4-8	0-5	10	X	X	X	X	X	X	X	X		X	X	X	X
DTG100-20-P	4,5,6	5-10	0-5	12	X	X	X	X	X	X	X	X		X	X	X	X
DTG020-07-6PT	4,5,6	1-3	0-5	6	X	X	X	X	X	X	X	X	X	X	X	X	X
DTG100-07-6PT	4,5,6	1-3	0-5	6	X	X	X	X	X	X	X	X		X	X	X	X
DTG025-09-6PT	4,5,6	2-5	0-5	6	X	X	X	X	X	X	X	X	X	X	X	X	X
DTG100-09-6PT	4,5,6	2-5	0-5	6	X	X	X	X	X	X	X	X		X	X	X	X
DTG025-12-6PT	4,5,6	3-7	0-5	8	X	X	X	X	X	X	X	X	X	X	X	X	X
DTG100-12-6PT	4,5,6	3-7	0-5	8	X	X	X	X	X	X	X	X		X	X	X	X
DTG100-15-6PT	4,5,6	4-8	0-5	10	X	X	X	X	X	X	X	X		X	X	X	X
DTG100-20-6PT	4,5,6	5-10	0-5	12	X	X	X	X	X	X	X	X		X	X	X	X

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F/D=Flat down;V/U=Vertical Up;VD=vertical down;H=Horizontal; X=very good; x=good;

DABOTEK WELD BACKING	nose			Thick. steel plates	Weldposition				Weld form				Welding Metode					
	Fig	Gab mm	mm		mm	F/D	V/U	V/D	H	DV	SV	SB	TJ	JG	GMA	SMA	FC	SAW
DTG100-19-A	9,10	3-7	0-5	10	X	X	X	X	X			X		X	X	X	X	
DTG025-19-A	9,10	3-7	0-5	10	X	X	X	X	X			X		X	X	X	X	
DTG025-19-A-6T	9,10	3-7	0-5	10	X	X	X	X	X			X		X	X	X	X	
DTG100-06-B	15	5-8	0-5	10	X	X	X	X				X		X	X	X	X	
DTG025-06-B	15	5-8	0-5	10	X	X	X	X				X		X	X	X	X	
DTG025-06-B-6T	15	5-8	0-5	10	X	X	X	X				X		X	X	X	X	
DTG025-12-6QT	8	3-7	0-5	8	X	X	X	X	X	X	X	X	X	X	X	X	X	
DTG025-16-6QT	8	4-8	0-5	10	X	X	X	X	X	X	X	X	X	X	X	X	X	
DTG025-20-6QT	8	5-10	0-5	12	X	X	X	X	X	X	X	X	X	X	X	X	X	
DTG100-45X	11	4-7	0-5	12	X	X	X	X	X					X	X	X	X	
DTG100-45X7-6T	11	4-7	0-5	12	X	X	X	X	X					X	X	X	X	
DTG100-45X9-6T	12	6-9	0-5	12	X	X	X	X	X					X	X	X	X	

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Technische eigenschaften unsere Keramik

Eigenschaftstabelle unsere keramischen Werkstoffe VDE 0335 (DIN 40865).		
Bezeichnung d. Werkstoffes	KER 410 (C410)	KER 511 (B 511)
Farbe	weiß	braun
Formgebung	gepreßt	gepreßt
Wasseraufnahmevermögen %	0	5
Rohdichte kg/mm ²	2,1	1,9
Druckfestigkeit N/mm ²	300	200
Biegefestigkeit N/mm ²	50	35
Mohs-Härte	7	6
Wärmefestfähigkeit (kcal/m.h.m.grd)	1,7-2,0	1,1-1,3
Temperaturwechselkeit (grad Celcius)	250	340-380
Feuerfestigkeit nach Segerkegeln	--	18-32
Kegelfallpunkt nach Grad	---	1520-1710

Korrosionsbeständigkeit:

Keramische Isolierstoffe sind gegen korrosive Einwirkungen der Atmosphäre auch in Gegenwart von salz-, säure und alkalihaligen Dämpfen und Niederschlagen - mit ausnahme vo Flußsäure - beständig.

Kennzeichnende Eigenschaften:

Große Temperaturbeständigkeit, den besonderen Betriebsbedingungen der Elektrowärmegeräte angepaßt

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TECHNICAL REFERENCES

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[Eigenschaften unsere keramischen Werkstoffe](#)

NOTE: Number systems for ceramic backing.

Our number systems are build up of the technical data for the ceramic type. Ex.:
DTG100-2514U-1R

DT----- : DABOTEK Trading ApS (maufactor)

----G----- : Gray (Ceramic matr.-typical G=gray or B=Braun)

-----100----- : Length of ceramicblock : 100 = 100 mm

-----2511----- : width, dept : 25=25mm width, 11=1,1mm dep. shape

-----U----- : U = round shape. (nothing=flat)

-----1R : length of mounting. Ex: 1R=1000 in rail

Ceramic blocks are mounted in fol. standards

C : clip

6R : 600 mm in steel rail

1R : 1000 mm in steel rail

6T : 600 mm on ALU-tape

1T : 1000 mm on ALU-tape

1W : 1000 mm on wire

- technical references

- technical specification on ceramic

- description of ceramic type no.:

If you have other technical suggestions please inform by mail : SALES@DABOTEK.COM