

APPLICATION SYSTEMS

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SIBACK

FIBERGLASS WELD BACKING TAPES

ALU-FIBER BACKING TAPE - SIBACK tape consists of fiberglass tape laminated with centre of adhesive aluminium foil. Outer adhesive strips are duly laminated with easy release liner. These adhesive edges stick to the area surrounding the root gap with the woven fiberglass tape facing the backside of the root gap.

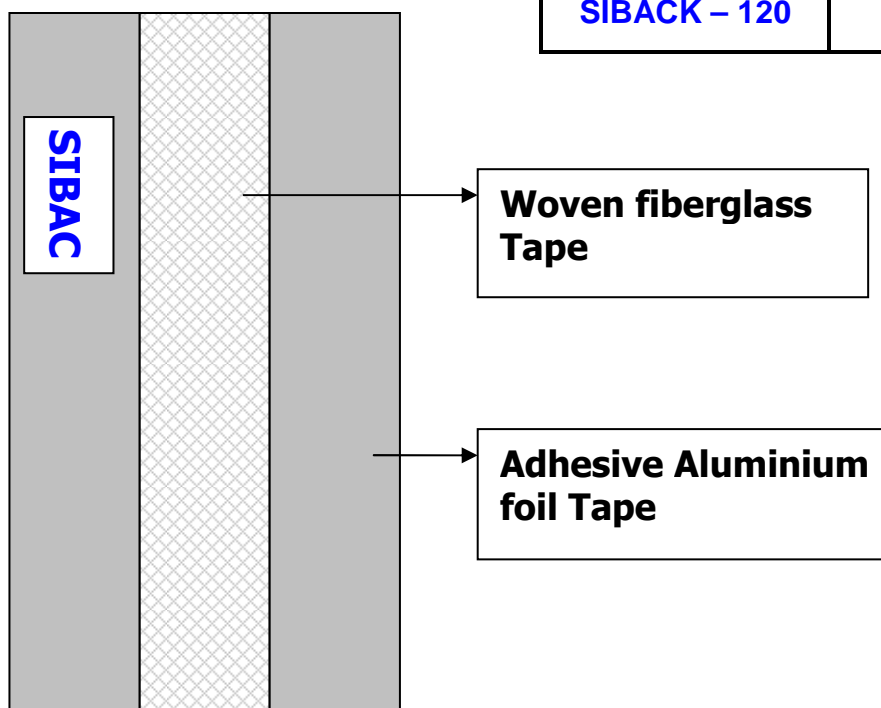
SIBACK is available in convenient size of 75 mm wide with fiberglass tape in 25 mm width. **SIBACK** is available in 3 different varieties, **SIBACK – 40** with 40 mil (1 mm) thick fiberglass tape; **SIBACK – 70** with fiberglass tape of 70 mil (1.75 mm) thickness & **SIBACK – 120** with fiberglass tape of 120 mil thickness (3 mm).

Heat Resistance of SIBACK:

- Adhesive: 400°C
- Aluminium Foil Tape: 600 °C
- Fiberglass Strip: 1000 °C

Suitable for applications upto 400 Amps

Type	Thk of Fiberglass
SIBACK – 40	40 mil/1 mm
SIBACK – 70	70 mil/1.75 mm
SIBACK – 120	120 mil/3 mm



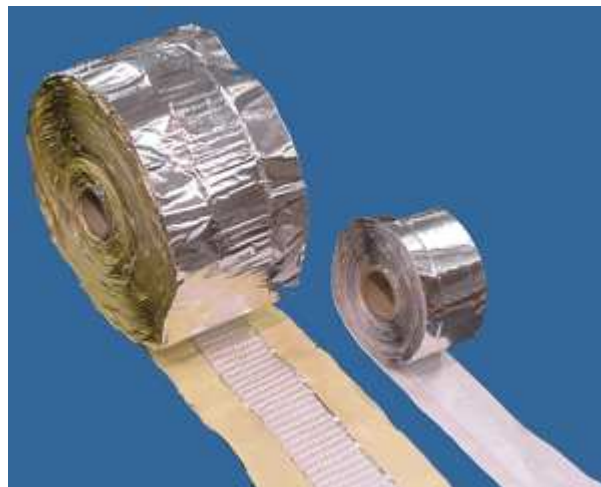
Standard Length: 20 meters/box

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Features

- **Increases productivity, Root weld and fill in one pass**
- **Ideal for stainless steel and alloyed metals, sheet, plate, pipes and vessels.**
- **Imparts X-ray quality back beads on root pass.**
- **Saves argon gas as no purging will be necessary, resulting Massive purge gas savings.**
- **Makes process faster as it saves time in preparation and assemble. Welds one side only.**
- **Provides incombustible, high temperature stability. More flexible, low thermal conductivity, good thermal shock resistance, good mechanical and chemical agents resistance, good electrical properties.**
- **Saves cleaning costs.**
- **Eliminates weld defects, No re-welding & re-work.**
- **For horizontal and vertical welding.**
- **No Gouging or Grinding, Back chipping.**



Composition - Information on Ingredients: Metallic 3 inch wide adhesive Aluminium tape with an acrylic adhesive, covered with siliconized paper, with 1 inch strip of continuous filament glass fiber tape running down the centre. Fibrous glass (E-type, continuous filament); Composition consisting of oxides of silicon, aluminium, calcium, boron and magnesium, fused in an amorphous vitreous state.

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Method of using SIBACK

WRONG



Peel off the backing tapes adhesive strips cover. Repeat this for both sides.



POOR TECHNIQUE would be to just stick tape down - as this allows air to be trapped.



POOR TECHNIQUE - As you can see the spine and tape have air trapped even after hard rubbing.

CORRECT



Peel off the backing tape adhesive strips cover. Repeat this for both sides.



Coil the foil edges back and push the glass fiber spine outwards.



Push the spine down firmly forcing out any trapped air.



Working from the centre out flatten the edges to have a smooth seal.



1. Clean the surface area upto approx 2" on either side of root gap, to make it free from moisture, oil, grease, rust, loose mill scale or dust. Cleaning may be done by wire brushing & Acetone or Metal cleaner.
2. Remove adhesive protecting silicon release paper from "Weld Back-up Tape"
3. Centre the Fiber Glass Tape along the weld-joint and hand press the adhesive side of Aluminium Foil on to the job, till it sticks without air entrapped.
4. Give first pass with TIG and fuse the root using filler wire
5. Weld with subsequent passes using Submerged Arc welding process or any other Welding process.