RANGE & ORDERING GUIDE

GULLCO KATBAK

Ceramic Weld Backing

Support the weld root when access is from one side.



Support the Root from Behind the Joint

Ceramic backing supports the molten weld pool from behind the joint. Where the welding procedure allows, it can help form a consistent root bead from one side and cut down on reverse-side gouging and re-welding.

Choose Your Profile

PROFILE FAMILY	WHEN TO CONSIDER IT	PAGE
Round and Triangular	Round contact or a defined corner arrangement.	2
Grooved Butt-Joint	Recessed face to make room for the formed root bead.	3
Flat, Formed and Corner	Flush contact, stepped fit-up or a shaped joint seat.	4

Before You Order

Check the joint preparation and root opening against the approved WPS. Match the ceramic profile, tape support and individual tile length to the fit-up and any curvature. Short segments can follow tight radii more closely. Confirm the backing is seated and aligned before welding.

Gullco offers special sizes and configurations on request. For an unusual joint, supply a sketch, root opening, radius if applicable and the required run length.

Gullco technical brochure and drawings

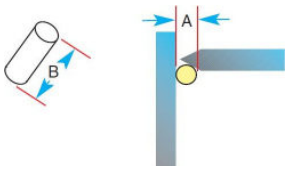
Round and Triangular Profiles

Round backing fits preparations that call for a cylindrical contact face. The triangular family has three arrangements. Check the joint orientation against the drawing.

Order by Gullco code. Dimension letters refer to the drawing beside each code.

1G6-RD

Round | 6.3mm Nominal



Round contact face for the smaller preparation shown.

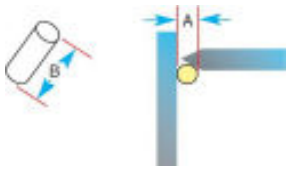
A 6.3mm

Manufacturer drawing

Box | 12m nominal

1G9-RD

Round | 9.5mm Nominal



Round contact face for the larger of the two illustrated corner arrangements.

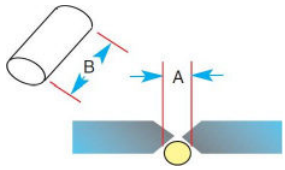
A 9.5mm

Manufacturer drawing

Box | 12m nominal

1G13-RD

Round | 12.7mm Nominal



Round profile illustrated in an open butt preparation.

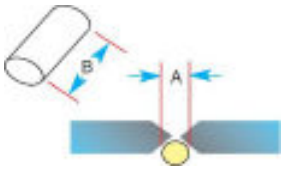
A 12.7mm

Manufacturer drawing

Box | 12m nominal

1G15-RD

Round | 15.9mm Nominal



Larger round profile for the butt arrangement shown.

A 15.9mm

Manufacturer drawing

Box | 12m nominal

1G20-RD

Round | 22.2mm Nominal



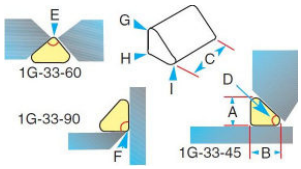
Largest round profile in the published range.

A 22.2mm

Manufacturer drawing

1G33-45

Triangular | 45 Series



Angled placement in the 1G33 family drawing.

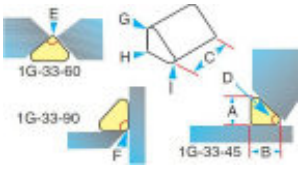
A 14.3mm · B 15.9mm · C 25.4mm · D 40° · E 55° · F 85°

Manufacturer drawing

Box | 12m nominal

1G33-60

Triangular | 60 Series



Butt-joint placement in the 1G33 family drawing.

A 14.3mm · B 15.9mm · C 25.4mm · D 40° · E 55° · F 85°

Manufacturer drawing

Box | 12m nominal

1G33-90

Triangular | 90 Series



Corner placement in the 1G33 family drawing.

A 14.3mm · B 15.9mm · C 25.4mm · D 40° · E 55° · F 85°

Manufacturer drawing

Box | 12m nominal

The 1G33 suffix identifies the profile variant. Use the drawing for the actual angles rather than using the suffix as a measured angle.

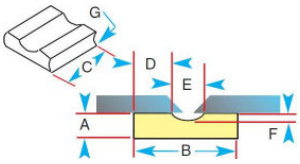
Grooved Butt-Joint Profiles

The groove leaves room behind the root for the weld bead to form. Match the groove geometry, seating width and tile length to the qualified joint preparation.

Order by Gullco code. Dimension letters refer to the drawing beside each code.

1G41-R

Rounded Groove | 9.5mm Wide



Narrower recess than 1G42-R on the same nominal body width.

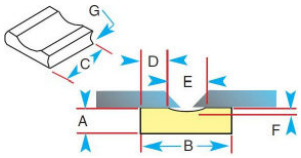
A 6.3mm · B 25.4mm · C 25.4mm · D 7.9mm · E 9.5mm · F 0.79mm

Manufacturer drawing

Box | 12m nominal

1G42-R

Rounded Groove | 11.1mm Wide



A grooved option to consider where the root is welded with cored wire.

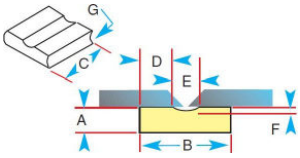
A 6.3mm · B 25.4mm · C 25.4mm · D 7.2mm · E 11.1mm · F 1.6mm

Manufacturer drawing

Box | 12m nominal

1G43-R

Rounded Groove | 6.3mm Wide



Narrower recess when the joint calls for a smaller formed root bead.

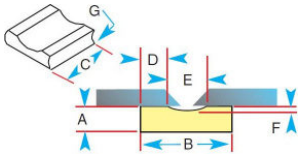
A 6.3mm · B 25.4mm · C 25.4mm · D 9.5mm · E 6.3mm · F 1.6mm

Manufacturer drawing

Box | 12m nominal

1G44-R

Rounded Groove | 17.5mm Wide



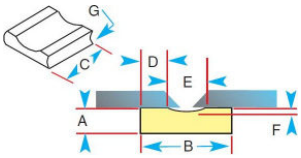
Wide recess on a 31.7mm body.

A 9.5mm · B 31.7mm · C 25.4mm · D 7.2mm · E 17.5mm · F 1.6mm

Manufacturer drawing

1G82-R

Rounded Groove | 11.1mm Wide



Wider body with a deeper groove cut than 1G42-R, as shown by dimension D.

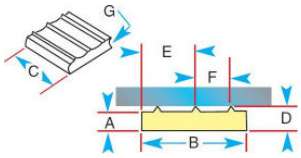
A 7.9mm · B 31.7mm · C 25.4mm · D 10.3mm · E 11.1mm · F 1.6mm

Manufacturer drawing

Box | 12m nominal

1G42-ER

Multi-Groove Profile



Stepped face with two recesses. Check contact on the lands in the actual fit-up.

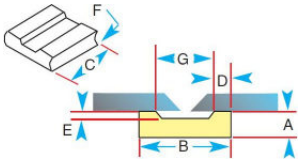
A 4.8mm · B 25.4mm · C 25.4mm · D 6mm · E 12.7mm · F 8.7mm

Manufacturer drawing

Box | 12m nominal

1G93-R

Bevel-Sided Groove



Angled recess with standard 25.4mm tile length in the online drawing.

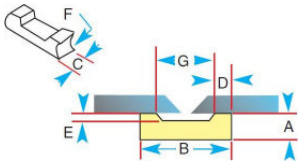
A 6.3mm · B 22.2–25.4mm · C 25.4mm · D 4mm · E 1.6mm · F 4.8mm

Manufacturer drawing

Box | 12m nominal

1G93-R-1/4

Bevel-Sided Groove | Short Tile



Short 6.3mm segments follow curvature in smaller increments.

A 6.3mm · B 22.2–25.4mm · C 6.3mm · D 4mm · E 1.6mm · F 4.8mm

Manufacturer drawing

Box | 12m nominal

For grooved profiles, check the groove width and depth together. Two tiles can have the same quoted groove width with different bodies and root-bead recesses.

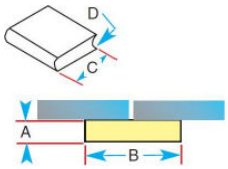
Flat, Formed and Corner Profiles

Pick a flat face where the joint calls for flush support. Use the shaped options where a flange, sloped plate, step or corner changes how the ceramic seats.

Order by Gullco code. Dimension letters refer to the drawing beside each code.

1G42-FR

Flat Face | 25.4mm Wide



Flat face for backing preparations that call for a flush contact surface.

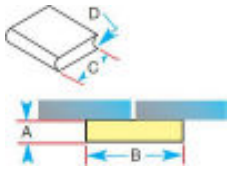
A 6.3mm · B 25.4mm · C 25.4mm

Manufacturer drawing

Box | 12m nominal

1G42-FR-1/4

Flat Face | Short Tile



Short 6.3mm segments for closer fit around curves.

A 6.3mm · B 25.4mm · C 6.3mm

Manufacturer drawing

Box | 12m nominal

1G83-FR

Flat Face | 31.7mm Wide



Wider flat contact face where more seating width is needed.

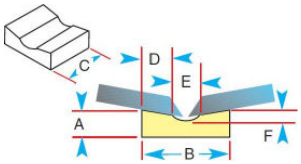
A 7.9mm · B 31.7mm · C 25.4mm

Manufacturer drawing

Box | 12m nominal

1G60

Grooved | Sloped Plate



Formed body illustrated under a joint with one sloped plate.

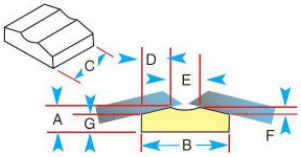
A 9.5mm · B 30.2mm · C 25.4mm · D 9.5mm · E 11.1mm · F 3.6mm

Manufacturer drawing

Box | 12m nominal

1G61

Formed | Two Sloped Plates



Formed shoulders follow the two-sided slope shown in the drawing.

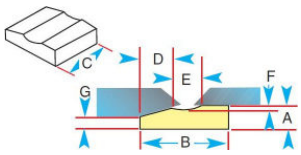
A 9.5mm · B 31mm · C 25.4mm · D 10mm · E 11.1mm · F 0.79mm

Manufacturer drawing

Box | 12m nominal

1G62

Grooved | Uneven Plate Levels



Asymmetric seating geometry for the stepped arrangement shown.

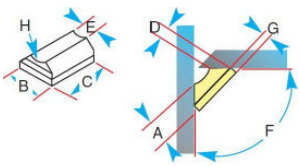
A 8.3mm · B 31mm · C 25.4mm · D 11.1mm · E 11.1mm · F 1.2mm

Manufacturer drawing

Box | 12m nominal

1G65-B

Corner | Stepped Support



Shaped backing illustrated at a right-angle corner.

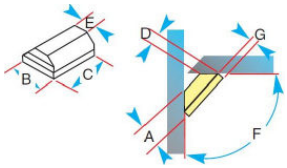
A 7.9mm · B 22.2mm · C 25.4mm · D 5.6mm · E 11.1mm · F 90°

Manufacturer drawing

Box | 12m nominal

1G66-B

Corner | Narrower Body



Alternative right-angle corner tile with a 19mm B dimension.

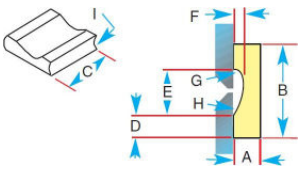
A 8.7mm · B 19mm · C 25.4mm · D 5.6mm · E 7.9mm · F 90°

Manufacturer drawing

Box | 12m nominal

1G80-R

Grooved | Flange Arrangement



Grooved tile shown mounted behind the root on the flange-style preparation.

A 6.3mm · B 25.4mm · C 25.4mm · D 6.3mm · E 12.7mm · F 2.4mm

Manufacturer drawing

Box | 12m nominal