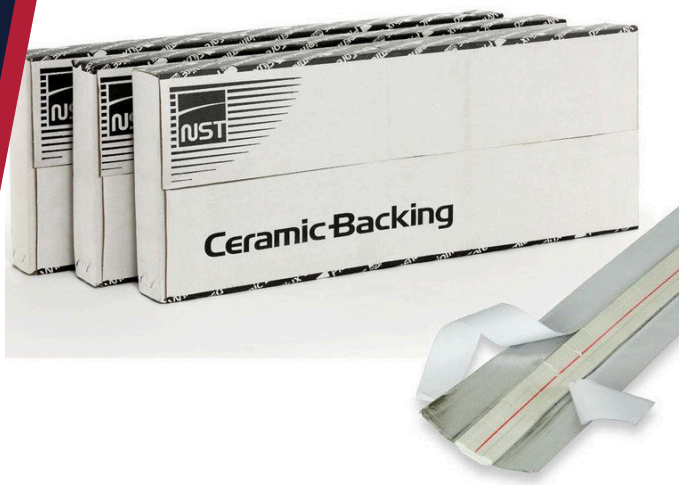
ORDERING GUIDE

NST KERBACK
CERAMIC WELD BACKING

Support the weld root from one side. Choose the profile to suit the joint preparation.



Choose By Joint

Joint or job	Kerback family	Page
Straight butt joint	FS square groove or FR round groove	02
Bevelled or corner preparation	RD round backing	03
Circular openings and curved seams	RAD radius backing	04
Horizontal butt, T-butt and buttering	FAR, TJ, F50 and TR 1302T	05
Bulb profiles and trapezoid backing	FR Bulb, TR and Magnback clamp	06

What To Quote

Give the NST article number, number of boxes and the profile if it is already on your procedure. For help selecting a tile, send the joint drawing, root opening, welding position and any required radius.

NST safety data sheet

Explore the Kerback range

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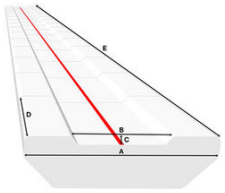
NST KERBACK · ORDERING GUIDE

Flat Backing For Butt Joints

Choose the groove shape and size specified for the root bead. Both families have a flat seating face and use 100mm aluminium adhesive tape.

FS · Square Groove

Use for straight butt joints that call for a square recess. Wider bodies give more seating area where the fit-up allows it.

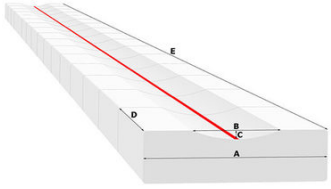


Kerback profile	NST code	Body	Groove W × D	Strips / length per box	Box weight
FS 271412T	20217	27mm	14mm × 1.2mm	30 / 18m	7.6kg
FS 271815T	20224	27mm	18mm × 1.5mm	30 / 18m	7.7kg
FS 401805T	20220	40mm	18mm × 0.5mm	20 / 12m	7.9kg
FS 502510T	20230	50mm	25mm × 1.0mm	20 / 12m	9.5kg

Each strip is 600mm long with 25mm tiles.

FR · Round Groove

Use for a rounded root recess. Choose groove width and depth together to match the qualified root geometry.



Kerback profile	NST code	Body	Groove W × D	Strips / length per box	Box weight
FR 221215T	20223	22mm	12mm × 1.5mm	40 / 24m	7.4kg
FR 270613T	20228	27mm	6.0mm × 1.3mm	30 / 18m	8.2kg
FR 271009T	20213	27mm	10mm × 0.9mm	30 / 18m	7.7kg
FR 271313T	20215	27mm	13mm × 1.3mm	30 / 18m	7.8kg
FR 301615T	20222	30mm	16mm × 1.5mm	30 / 18m	7.8kg
FR 361805T	20219	36mm	18mm × 0.5mm	30 / 18m	11.1kg

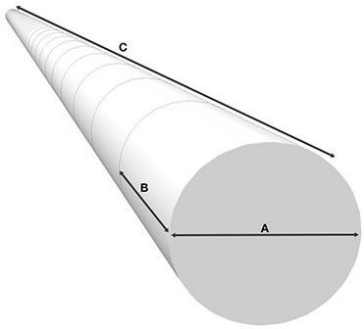
Each strip is 600mm long with 25mm tiles.

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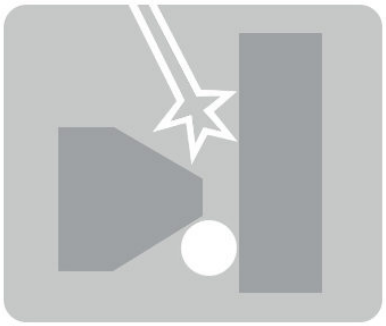
NST KERBACK · ORDERING GUIDE

RD Round Backing

Use cylindrical backing where the joint preparation calls for round contact, including T-butt, K, single-bevel and double-V joints. Match the diameter to the fit-up.



Cylindrical profile



Round backing in a prepared root

Kerback profile	NST code	Diameter	Tile length	Strip length	Strips / length per box	Box weight
RD 0602T	20225	6.0mm	25mm	600mm	75 / 45m	5.0kg
RD 0802T	20209	8.0mm	25mm	600mm	80 / 48m	6.5kg
RD 0902T	20232	9mm	25mm	600mm	60 / 36m	5.2kg
RD 1002T	20210	10mm	25mm	600mm	60 / 36m	7.2kg
RD 1202T	20211	12mm	25mm	600mm	60 / 36m	9.9kg
RD 1501T	20226	15mm	25mm	600mm	30 / 18m	7.7kg
RD 2002T	20227	20mm	25mm	600mm	20 / 12m	8.2kg

Fit The Profile Before Welding

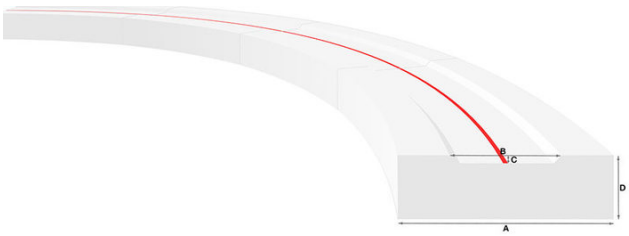
Check the round tile seats evenly against the preparation. Keep adjoining strips close at the root and apply the 100mm foil tape to clean, dry plate.

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RAD Radius Backing

Use pre-curved strips to follow circular openings such as manholes. Select by radius and arc per piece so the backing follows the joint without forcing it.



Curved strip follows the opening



Groove centred under the weld root

Kerback profile	NST code	Radius / circle Ø	Arc	Pieces / circle	Pieces / box	Box weight
RAD 075T	30075	75mm / Ø150mm	90°	4	80	4.9kg
RAD 100T	30100	100mm / Ø200mm	90°	4	44	3.4kg
RAD 150T	30150	150mm / Ø300mm	90°	4	36	3.8kg
RAD 200T	30200	200mm / Ø400mm	72°	5	40	4.7kg
RAD 300T	30300	300mm / Ø600mm	45°	8	56	5.0kg

Across the RAD range, the body is 27mm wide with a 13 × 1.0mm groove, 8.0mm tiles and 100mm aluminium tape.

Order By Radius And Arc

For a complete 400mm-diameter circle, use five RAD 200T sections at 72° each. Allow for the actual joint run and the way the adjoining strips meet.

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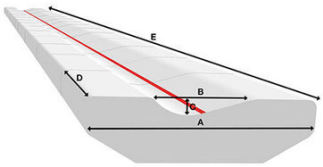
Special Backing Profiles

Match the backing face to the joint preparation and welding position.

FAR 271220T

20229

Horizontal Butt Welds



Asymmetric groove for PC-position butt welds. Check the orientation against NST's drawing.
Body 27mm · groove 12mm × 2.0mm
Tile 25mm · strip 600mm

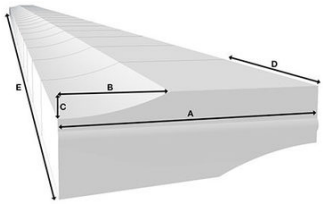
30 strips / 18m per box · 7.1kg · 100mm tape

NST datasheet

TJ 2701T

20216

T-Butt Single-Bevel Joints



Shaped backing for T-butt preparations with one bevel.

Body 27mm · groove 10mm × 2.0mm
Tile 30mm · strip 600mm

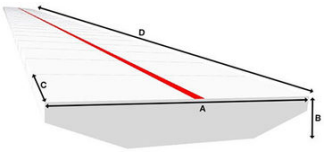
30 strips / 18m per box · 7.6kg

NST datasheet

F 50T

20221

Large Openings & Buttering



Flat, ungrooved face for wide preparations and specified buttering work.

Body 50mm · ungrooved
Tile 23mm · strip 600mm

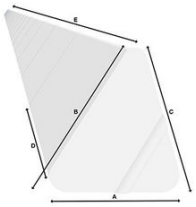
20 strips / 12m per box · 9.0kg · 115mm tape

NST datasheet

TR 1302T

20083

K & Double-V Joints



Triangular 45° profile for the K- and X-joint arrangements shown.

Body 13mm · 45° profile
Tile 25mm · strip 600mm

40 strips / 24m per box · 7.3kg · 100mm tape

NST datasheet

For Horizontal Butt Welds

The FAR recess is shaped for PC welding. Align the asymmetric face as shown in the manufacturer drawing and use the specified root opening and procedure.

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NST KERBACK · ORDERING GUIDE

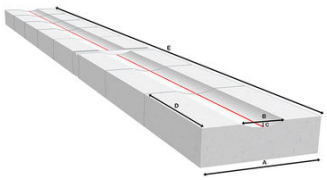
Bulb & Trapezoid Backing

Use the profile drawings to match shaped structural sections and check how each tile will seat at the root.

FR 271009T Bulb

20313

Bulb-Section Splices



Jointed backing for bulb splices, with a 10mm rounded groove.

Body 27mm · groove 10mm × 0.9mm
Tile 30mm · strip 240mm

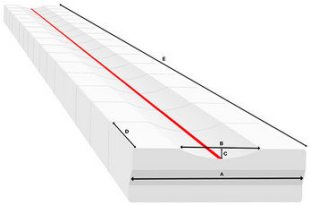
50 strips / 12m per box · 5.0kg · 90mm tape

NST product drawing

FR 271313T Bulb

20315

Bulb Backing · 13mm Groove



Short tiles and a rounded 13mm recess for the specified butt preparation.

Body 27mm · groove 13mm × 1.3mm
Tile 10mm · strip 600mm

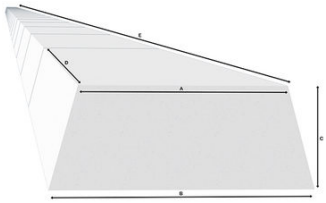
30 strips / 18m per box · 7.8kg · 100mm tape

NST datasheet

TR 101406T

20081

Trapezoid Backing · 10/14mm



Tapered profile for butt welds. Match both bearing faces to the preparation.

Faces 10mm / 14mm · height 6mm
Tile 24mm · strip 600mm

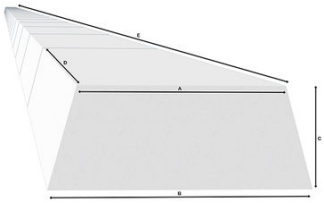
60 strips / 36m per box · 7.2kg · 80mm tape

NST product drawing

TR 121606T

20082

Trapezoid Backing · 12/16mm



Wider trapezoid option for butt welds. Specify the full NST code.

Faces 12mm / 16mm · height 6mm
Tile 22mm · strip 600mm

60 strips / 36m per box · 7.7kg · 80mm tape

NST datasheet

Magnback 2501 · Magnetic Backing Clamp



Holds foil-backed ceramic strips or metal trays against a magnetic workpiece.

NST 29003 · 250 × 50mm · 1.0mm body · 6.0mm magnet height
50 clamps per box · 7.8kg

NST datasheet

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