

Robvon Backing Rings

Robvon Commercial Backing Rings are designed for quick, easy alignment of pipe, tube, fittings and valves and assure precise, close tolerance fit-up. They allow complete penetration and fusion of the weld and radiograph perfect certified welds.

The patented nubs automatically set the weld gap for the root-pass. The internal bevels and flat inner lands assure non-restricted fluid flow. The Robvon backing ring eliminates the necessity of tack welding and it also eliminates slag, icicles or metal inside the bore which create obstructions, which can cause damage to valve seats and strainers when broken loose.

Backing Ring Styles



Robvon "CCC" Backing Ring

Designed for quick easy joint alignment where the variation in inside diameters is relatively great.



Robvon "CC" Backing Ring

Designed primarily for automatic welding and to allow quick and easy joint alignment where the inside diameters are slightly out-of-round. Nubs can be chipped off or left intact to be melted into first root pass.



Robvon "Plain" Backing Ring

Designed for quick and easy joint alignment, and for manually setting the root gap.

Backing Ring Welding Procedure

To see the [Backing Ring Welding Procedure](#)

Material's Available:

Carbon Steel	ASTM A-109	ASTM A414/ASME SA-414
Chrome Moly	ASTM A-182/ASME SA-182	F-11, F-22
Stainless Steel	ASTM A-240/ASME SA-240	304, 304L, 316, 316L, 321, 347 & Others
Aluminum	ASTM B-221/ASME SB-221	3003, 5086 & 6061
Copper Nickel	MIL-C-15726(F)	CDA-706, CDA-715

**Other weldable materials available upon inquiry; e.g., special grades of Chrome Moly, Stainless Steel, Nickel, and Cupro Nickel and Other's.

Backing Ring Ordering Information, Specify:

Quantity

NPS & Schedule or Tubing O.D. & Wall

Backing Ring type - "CCC", "CC" or Plain

Material & Grade

Example: (50 pcs - 6" std Robvon "CCC" Carbon Steel A-109)

Nominal Pipe Size or Tube OD range from 1" to 36 " 38" and larger are available upon request.

Note: All rings are marked on inside diameter with:
Size, Sch, Heat No., Material Grade & Robvon Company Identifier

General Backing Ring Information

Backing Rings are manufactured with the following ring gaps included, but are not limited to, 3/32" or .030" on sizes 4" and smaller; 5" and larger exhibit a 1/8" or .040" gap.

To view a table showing Robvon's Standard Backing Ring;
[Dimensions, Ring Weights & Spacer Pins](#)

"CCC" Spacer Nub lengths include, but are not limited to, 3/4" long on "CCC" ring types with 1/8" and 3/16" diameters; 1/8" and 3/16" diameter ball-type nubs on "CC" ring types.