

Copper Back-Up Clamp

Proven Technology

The CRC-Evans Copper Back-Up Clamp (CBUC) is designed to meet a variety of pipeline welding applications using automated GMAW/PGMAW equipment. In addition to functioning as an internal pipe line-up clamp, a CBUC supports external root bead weld deposition with a copper backing surface. A CBUC makes it possible to deposit more consistent, higher quality external root beads with normal pipe alignment.

Superior Function

CRC-Evans copper back-up clamps are available with segmented and spring-loaded copper backing shoes, or solid copper tile configurations depending upon application.

Segmented copper tiles allow each backing shoe to individually conform to the pipe's internal diameter. This insures consistent root bead support with many variations commonly encountered in production pipe tolerances, such as wall thickness, roundness, diameter, and joint fit up. A single CRC-Evans segmented copper CBUC can be used for a family of

pipe diameters without changes to the copper backing mechanism, reducing cost and changeover time. For projects requiring multiple pipe sizes, heavy wall and thin wall varieties, or extreme tolerance deviations, a segmented copper CBUC will provide the advantage.

Solid copper tiles are machined to fit specific pipe diameters and are less forgiving of dimensional variations than segmented coppers. Solid copper tiles are robust, long lasting, and offer mechanical simplicity. When projects demand a high volume of welds on a single pipe diameter, a solid copper back-up clamp will lower operating costs and provide excellent consistency and reliability.

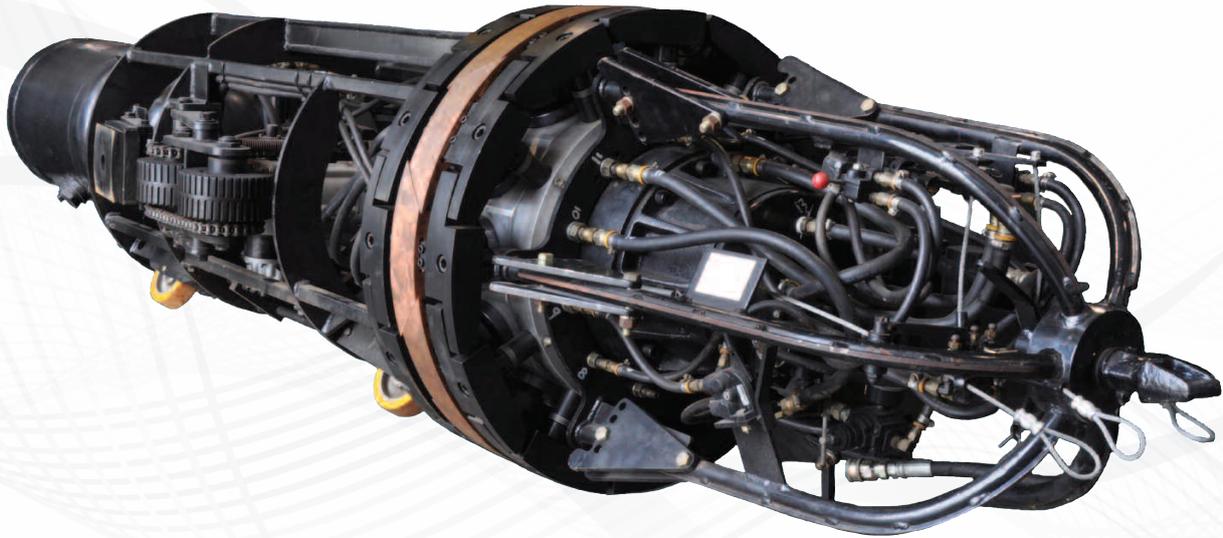
Versatility

CRC-Evans supplies a wide array of copper back-up clamps engineered to meet mainline welding applications for numerous pipeline diameters. Speciality CBUCs are also available for Offshore J-Lay, Tie-In, and Purge applications. Contact CRC-Evans to discuss your custom application.

Copper Back-Up Clamp System

Advantages

- ▶ Consistent External Root Deposition
- ▶ Higher Quality External Root Welds
- ▶ Mainline, Offshore J-Lay, Tie-In, and Purge Configurations
- ▶ Custom Applications Available



Mechanical Specifications

Pipe sizes	Up to 16"	Up to 406 mm	16 to 56"	406 to 1,422 mm
Wall thickness	Not applicable*	Not applicable*	5/16 to 1"	8 to 25.4 mm
Temp rating	To be advised	To be advised	-40 to 158°F	-40 to 70°C
Climb capability	15 degrees**	15 degrees**	15 degrees	15 degrees
Drive capability (flat)	80 feet	+24.4m	80 feet	+24.4m
Operating pressure	200 psig	1.38 MPa	200 psig	1.38 MPa

* Copper back-up clamps under 16" are made for ID measurements

** 14-16" Diameter are the smallest clamps with drive capability.

All dimensions subject to change without notice.

! Disclaimer

Although great care has been taken in compiling the information contained in this catalogue, CRC-Evans does not accept responsibility for the consequences of any errors, nor for the effects of any subsequent changes made by the various sources of data.

Dimensions and weights provided for reference only. Dimensions, specifications and weights can vary depending upon final configuration of the equipment. Please contact CRC-Evans to confirm final weights and dimensions prior to shipment.



Houston: (832) 249-3100 Toll Free: (800) 664-9224 • Tulsa: (918) 438-2100
Netherlands: +31-36-711-7500 • www.crc-evans.com