The problem:
A common welding difficulty is the penetration of weld metal to the back side of the weld joint, leaving a metal buildup which must be removed by grinding. If the buildup occurs in a restricted area, such as the inside of a small-diameter tube, removal without damage to the joint becomes extremely difficult.

The solution:
Use an easily removable ceramic backup material butted against the back of the weld zone to prevent the buildup of weld metal at that site.

How it’s done:
In a typical, difficult welding configuration (see fig.), a heat-resistant ceramic ring is slip-fitted to the inside diameter of the two pieces to be welded. The ring, machined from a commercial vitreous aluminum silicate, spans the weld junction. After welding is completed, the ring is easily chipped out, leaving a highly smooth inner surface.

This method has been successfully used in the manual tungsten-inert gas (TIG) welding of 316 corrosion resistant steel (CRES) pieces with a 0.76 cm (0.30 in.) throat diameter and a 1.57 cm (0.64 in.) pipe i.d.

Notes:
1. The use of removable backup material to prevent weld metal buildup is not restricted to TIG welding.
2. A variation of this method has previously been employed in ship riveting.
3. Requests for further information may be directed to:
   Technology Utilization Officer
   AEC-NASA Space Nuclear Systems Office
   U.S. Atomic Energy Commission
   Washington, D.C. 20545
   Reference: B71-10117

Patent status:
No patent action is contemplated by AEC or NASA.

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