



Key features:

Consistent external root deposition

High quality external root welds

Mainline, offshore
J-lay, tie-in, and purge configurations

Custom applications available

Application

Internal pipe line up

Copper Back Up Clamp B

Engineered to meet various pipeline welding applications and diameters

CRC Evans' (CRCE) copper back up clamp (CBUC) is designed to meet a variety of welding applications using GMAW/PGMAW automatic welding equipment. The system functions as an internal pipe line-up clamp to support external root bead weld deposition with a copper backing surface. The system can deposit more consistent, higher quality external root beads with normal pipe alignment.

Available with segmented and spring-loaded copper backing shoes, or solid copper tile configurations depending upon application. Segmented copper tiles allow backing shoes to individually conform to the internal pipe diameters .

Segmented systems are suitable for projects with multiple pipe sizes, heavy wall and thin wall variations, or extreme tolerance deviations. The system ensures consistent root bead support across common variations in production pipe tolerances including wall thickness, roundness, diameter, and joint fit up.

Solid copper tiles are machined to fit specific pipe diameters and are less forgiving of dimensional variations. They are robust, long lasting, and offer mechanical simplicity. For projects demanding a high volume of welds on a single pipe diameter a solid copper CBUC provides consistency and reliability and can help to reduce operating costs.

Specialist CBUCs are available for J-lay, tie-in, and purge applications.

Copper Back Up Clamp B

Pipe sizes	Up to 16"	Up to 406mm	16 to 56"	4406 to 1422mm
Wall thickness	NA*	NA*	5/16 to 1"	8 to 25.4mm
Temp rating	To be advised		-40 to 158°F	-40 to 70°C
Climb capability	15° **	15° **	15°	15°
Drive capability (flat)	80ft	+24.4m	80ft	+24.4m
Operating pressure	200psig	1.38MPa	200psig	1.38MPa

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

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