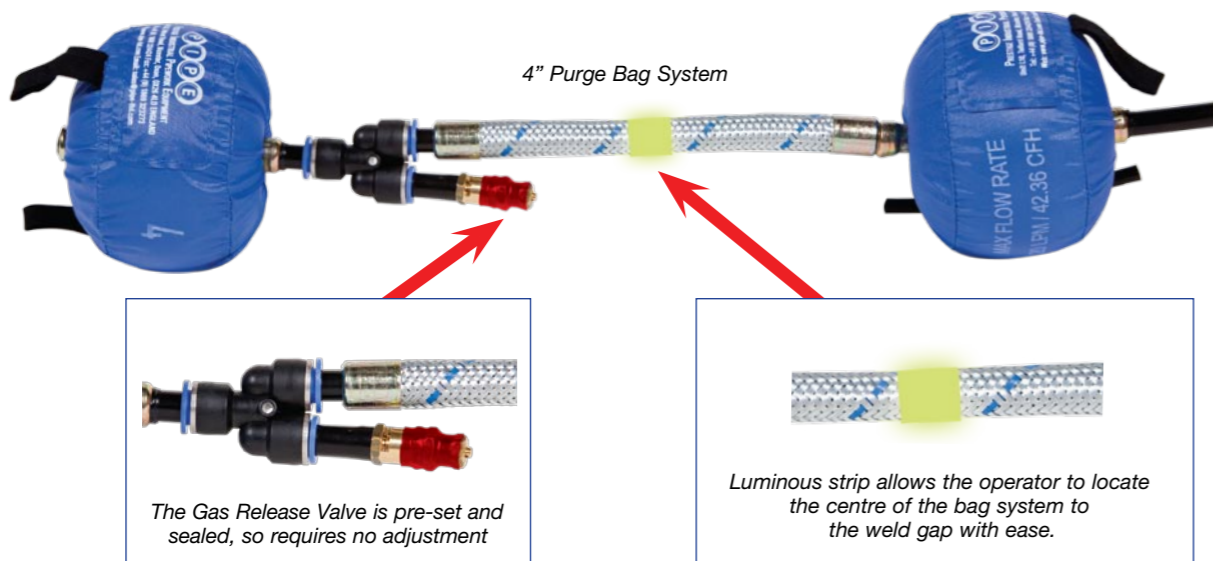


PURGE BAG SYSTEM

Sizes: 2"- 48" (50mm - 1200mm)

Double Inflatable Pipe Weld Purging Systems

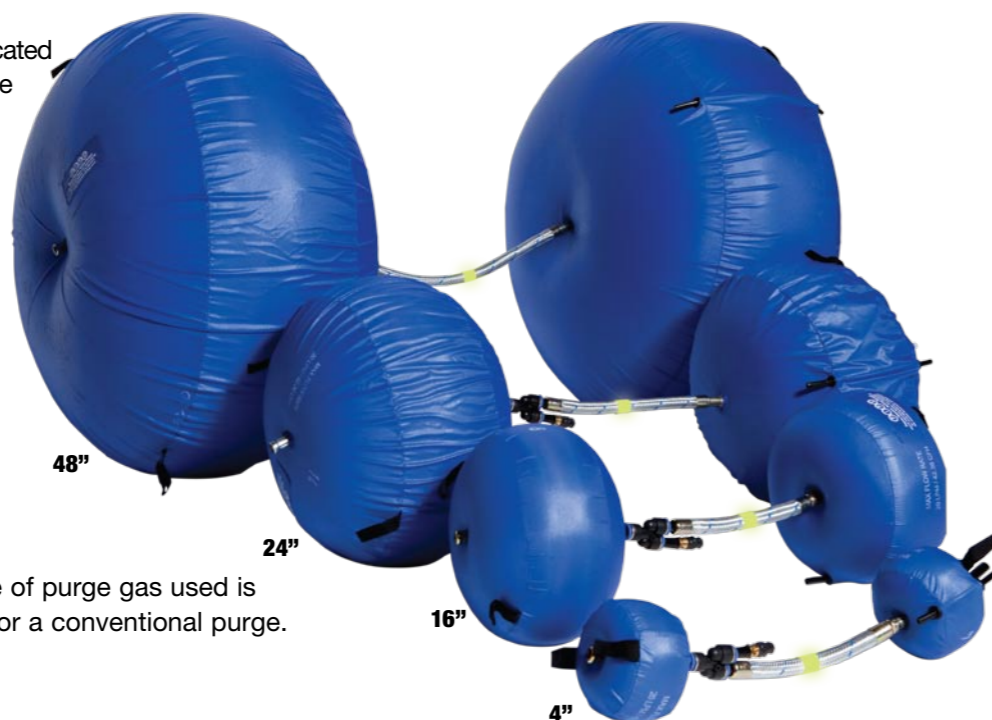
Used for 90% of the traditional pipe weld purging applications to provide bright, shiny, oxide free weld roots. The Pipe Purge Bag Systems are quick and easy to use providing a very rapid weld purge. High quality materials are used in the manufacture of these systems guaranteeing perfect oxide-free weld roots in very little time.



Due to the design of these systems, the volume of gas used to purge is minimised, resulting in significant savings in both time and the quantity of inert gas used. Return on investment can be achieved in as little as just one or two welds. These robust systems can be used over and over again paying for themselves in very little time.

Features and advantages

- PIPE Ltd's Inflatable Pipe Purging Systems dramatically reduce purging times leading to significant savings in labour costs.
Typical purge times for 4" pipe = 1½ mins; 8" pipe = 4 mins; 12" pipe = 8 mins
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 20l a min. Through the preset purge valve.
- Gas pressure control ensures an even positive root bead with no notching.
- Quick and easy to install simplifying the process of inert gas purging.
- Heat resistant up to 70°C continuously.
- Use less inert gas. The volume of purge gas used is less than 2% of that required for a conventional purge.

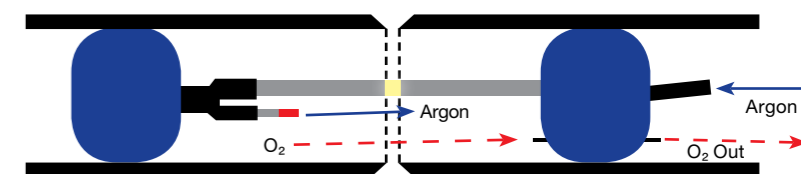


How it works

The Purge Bag Systems in the range manufactured by PIPE Ltd are designed around the principle of using 2 dams to create a seal either side of the weld, just far enough away from the weld not to be effected by heat but close enough to the joint to provide the fastest weld purge time. These dams are connected by an armoured spinal tube.

Once ready to start purging, the system is inserted into the bore of the pipe with one dam either side of the weld joint using the luminous strip to centre the bag system to the weld gap.

When the gas connection is made and the gas flow started, the spinal tube carries the gas to inflate the dams and, upon reaching the pre-set pressure, the valve releases the gas gently into the weld chamber, to purge the interspace without turbulence. The Oxygen is removed from the weld chamber through the integral exhaust tubes in the bags. Used in conjunction with PIPE Ltd's Oxygen Monitors to indicate when the required low level of oxygen has been reached, welding can then commence, with the inert gas enabling the welder to produce an even penetration weld bead. Afterwards, the dams are deflated simply by disconnecting the purge gas feed and the system easily withdrawn. The design of these systems means that only one gas connection is required for both dam inflation and weld purging.



Sizing and specification

PART N°	NOMINAL PIPE SIZE	WEIGHT	INTERNAL DIAMETER RANGE
PB02	50 mm 2"	0.34 kg	44 - 57 mm
PB03	75 mm 3"	0.34 kg	58 - 84 mm
PB04	100 mm 4"	0.34 kg	80 - 110 mm
PB05	125 mm 5"	0.38 kg	103 - 135 mm
PB06	150 mm 6"	0.38 kg	124 - 162 mm
PB08	200 mm 8"	0.90 kg	175 - 213 mm
PB10	250 mm 10"	1.0 kg	230 - 265 mm
PB12	300 mm 12"	1.1 kg	265 - 305 mm
PB14	350 mm 14"	1.3 kg	330 - 355 mm
PB16	400 mm 16"	1.7 kg	380 - 405 mm
PB18	450 mm 18"	1.8 kg	430 - 455 mm
PB20	500 mm 20"	1.9 kg	485 - 510 mm
PB22	550 mm 22"	2.2 kg	535 - 560 mm
PB24	600 mm 24"	2.5 kg	585 - 610 mm
PB26	650 mm 26"	2.8 kg	635 - 660 mm
PB28	700 mm 28"	3.1 kg	685 - 710 mm
PB30	750 mm 30"	3.4 kg	735 - 760 mm
PB32	800 mm 32"	3.8 kg	785 - 810 mm
PB34	850 mm 34"	4.2 kg	835 - 860 mm
PB36	900 mm 36"	4.5 kg	885 - 910 mm
PB40	1000 mm 40"	5.0 kg	990 - 1015 mm
PB42	1050 mm 42"	5.5 kg	1040 - 1065 mm
PB48	1200 mm 48"	6.0 kg	1195 - 1220 mm
PBS401	30 metre argon feed hose assembly for connecting PIPE Purge Bag System to dedicated and regulated gas supply. Fitted at one end with a 3/8" female gas regulator connector and at the other end with a fitting to attach to the inflation hose.		

Standard sizes 2 to 48" are available in large quantities for immediate delivery from stock. Special sizes are available within 7 days.