The B&B P.B.S. Purge Bag Systems is the most common inflatable purge bag method in use. This simple and proven design requires little training and immediate results are achieved. For smaller pipe diameters, purge times are usually within 2-10 minutes all while achieving shiny oxide free welds. It is not uncommon to pay for the purge bag in as little as 3 or 4 uses in time savings alone. Sizes range from 2-24 inches.

Features & Advantages

- B&B’s Inflatable Pipe Purging Systems dramatically reduces purging times leading to significant savings in labor 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 20 LPM through the pre-set 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 70ºc/158ºf continuously.

- Use less inert gas. The volume of purge gas used is less than 2% of that required for a conventional purge.
# P.B.S. Purge Bag Systems

<table>
<thead>
<tr>
<th>Description</th>
<th>Part Number</th>
<th>Umbilical Length (A)</th>
<th>Sphere Size (B)</th>
<th>Inflated Thickness (C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Purge Bag System - 2”</td>
<td>1002</td>
<td>11”</td>
<td>2 ¾”</td>
<td>2 ¼”</td>
</tr>
<tr>
<td>Purge Bag System - 3”</td>
<td>1003</td>
<td>11 ½”</td>
<td>3 ¼”</td>
<td>2 ¼”</td>
</tr>
<tr>
<td>Purge Bag System - 4”</td>
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<td>11 ½”</td>
<td>4 ¼”</td>
<td>2 ¾”</td>
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<tr>
<td>Purge Bag System - 5”</td>
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<td>11 ½”</td>
<td>6 ¾”</td>
<td>4 ¼”</td>
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<tr>
<td>Purge Bag System - 6”</td>
<td>1006</td>
<td>11 ½”</td>
<td>6 ¾”</td>
<td>3 ½”</td>
</tr>
<tr>
<td>Purge Bag System - 8”</td>
<td>1007</td>
<td>11 ¼”</td>
<td>8 ½”</td>
<td>5 ¼”</td>
</tr>
<tr>
<td>Purge Bag System - 10”</td>
<td>1008</td>
<td>11 ¼”</td>
<td>10 ½”</td>
<td>7 ½”</td>
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<tr>
<td>Purge Bag System - 12”</td>
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<td>11 ¼”</td>
<td>12 ¼”</td>
<td>10 ¾”</td>
</tr>
<tr>
<td>Purge Bag System - 14”</td>
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<td>13 ¼”</td>
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<tr>
<td>Purge Bag System - 16”</td>
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<td>13 ¼”</td>
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<td>11”</td>
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<tr>
<td>Purge Bag System - 18”</td>
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<td>14 ¾”</td>
<td>18 ¼”</td>
<td>11”</td>
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<tr>
<td>Purge Bag System - 20”</td>
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<td>15 ¼”</td>
<td>19 ¼”</td>
<td>17 ¼”</td>
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<td>17”</td>
<td>22”</td>
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<td>Purge Bag System - 24”</td>
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<td>17”</td>
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<td>17”</td>
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<td>21”</td>
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<tr>
<td>Purge Bag System - 36”</td>
<td>1021</td>
<td>19 ½”</td>
<td>37 ½”</td>
<td>25 ½”</td>
</tr>
</tbody>
</table>
Operator Instructions for P.B.S. Purge Bag System

Read and understand the instructions for safe performance. If uncertain about working with B&B P.B.S. Purge Bag Systems, always contact B&B prior to using the product. Understand the correct operations, applications and limitations. Store this safety manual in a clear area and always at a readily accessible site. Be especially aware of specific hazard signs. Extra copies are obtainable at B&B Pipe and Industrial Tools.

1. Make sure P.B.S. bag is deflated before use and insertion into pipe.

2. Attach shielded gas line to the bag with a female 1/4 inch NPT fitting. Attach black hose on PBS system. Make sure you have enough feed hose to fully insert bag all the way to the weld point.

3. Insert bag into end of Pipe or Fitting and push into the weld point. If bag placement is at a distance from opening use a “fishing” wire or equivalent to push the bag into the pipe. Use pull tabs sewn into bag to fasten a fish line to the bag.

4. Use glow in the dark middle tape tab to align purging bags. Meaning, if the inside of the pipe is to dark to see the bag, look for glow in the dark tape sewn on the center of the bag to line up the bag with the root pass/weld point.

5. Once the bag is in place, turn on shielded gas.

   **DO NOT OVER INFLATE OR INFLATE TOO QUICKLY OR SYSTEMS WILL NOT FUNCTION AND YOU WILL DESTROY THE SYSTEM.**

6. Inflate at max rate of 20 LPM or .71 CFM (42.36 CFH). If instructions are not followed, warranty is voided.

7. Root gap must be blocked with tape or equivalent to insure shielded gas does not escape before weld process.

8. Bags will inflate with gas then auto releases valve to purge chamber near weld point.

9. Monitor oxygen content with oxygen monitor and when adequate welding climate is achieved, begin weld process.

10. Do not turn off shielding gas. Pressure must remain throughout root pass welding process to ensure oxygen purge.

11. When removing bags, make sure weld area is cool. Do not use feed lines to pull bags! Use sewn in pull tabs to remove bags!