

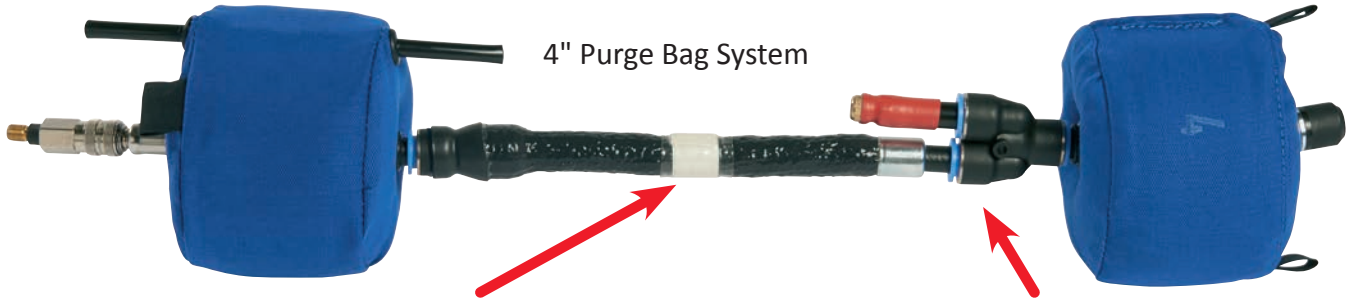


# PURGE BAG SYSTEM

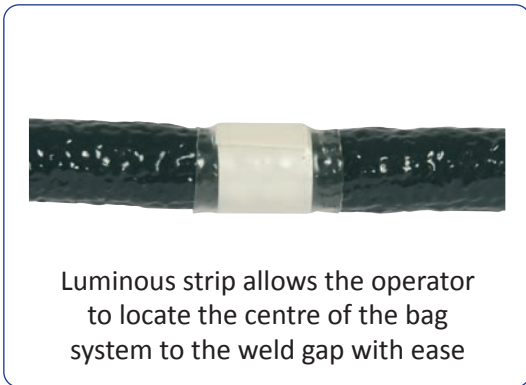
Sizes: 2 - 24" (50 - 610 mm)

## 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 PPM Pipe Purge System is 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.



4" Purge Bag System



Luminous strip allows the operator to locate the centre of the bag system to the weld gap with ease



The Gas Release Valve is pre-set and sealed, so requires no adjustment

Due to the design of these systems, the volume of gas used to purge is minimized, 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

- PPM's Inflatable Pipe Purging Systems dramatically reduce 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 20l a min. 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 70°C continuously
- Use less inert gas. The volume of purge gas used is less than 2% of that required for a conventional purge

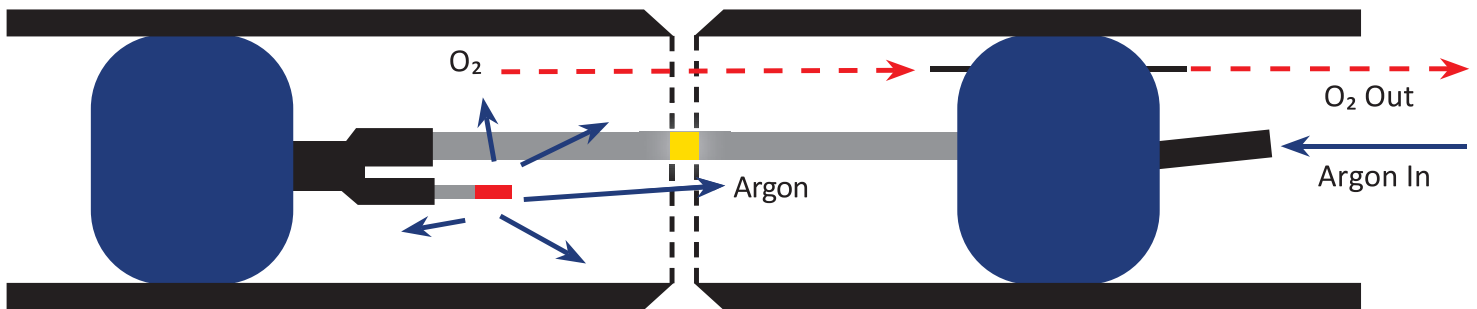


## How it works

The Purge Bag Systems in the range manufactured by PPM 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 using the luminous strip to centre the system to the weld gap.

When the gas flow is started, the dams inflate 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 PPM'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 oxidation free 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 NO.	NOMINAL PIPE SIZE		WEIGHT	INTERNAL DIAMETER RANGE
PB02	50 mm	2"	1 lbs. / 0.34 kg	1.73 - 2.24 / 44 - 57 mm
PB03	75 mm	3"	1 lbs. / 0.34 kg	2.28 - 3.30 / 58 - 84 mm
PB04	100 mm	4"	1 lbs. / 0.34 kg	3.14 - 4.33 / 80 - 110 mm
PB05	125 mm	5"	1 lbs. / 0.38 kg	4.05 - 5.31 / 103 - 135 mm
PB06	150 mm	6"	1 lbs. / 0.38 kg	4.88 - 6.37 / 124 - 162 mm
PB08	200 mm	8"	2 lbs. / 0.90 kg	6.88 - 8.38 / 175 - 213 mm
PB10	250 mm	10"	2 lbs. / 1 kg	9.05 - 10.43 / 230 - 265 mm
PB12	300 mm	12"	2 lbs. / 1.1 kg	10.43 - 12.00 / 265 - 305 mm
PB14	350 mm	14"	2 lbs. / 1.3 kg	12.99 - 13.97 / 330 - 355 mm
PB16	400 mm	16"	3 lbs. / 1.7 kg	14.96 - 15.94 / 380 - 405 mm
PB18	450 mm	18"	3 lbs. / 1.8 kg	16.92 - 17.91 / 430 - 455 mm
PB20	500 mm	20"	4 lbs. / 1.9 kg	19.09 - 20.07 / 485 - 510 mm
PB22	550 mm	22"	4 lbs. / 2.2 kg	21.06 - 22.04 / 535 - 560 mm
PB24	600 mm	24"	5 lbs. / 2.5 kg	23.03 - 24.01 / 585 - 610 mm

**Larger sizes and specials available on request, however Rapid Purge strongly recommended over 12"**

**Rapid Purge  
recommended  
above 12"**